

Catalogue 2019

Welding machines and accessories



EN 1090 WPQR package
now free of charge!

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

EWM AG – Simply more!

EWM has a system whose components are completely matched to one another, in which all the components are oriented towards constantly producing the highest welding quality, while using resources sparingly and saving effort. The advantages for our customers are obvious: the complete product portfolio means that they only just one point of contact: EWM provides you with advice and service. We also guarantee the quickest availability and delivery times for all of our products. In this manner, we accept technological responsibility for your entire welding process.

This price list contains the complete product range of EWM welding machines.



■ Consultancy + service

Do you have any questions not answered in this price list? Our global EWM branches and sales partners are happy to help and advise you at any time.

You can find a list of sales partners in your area on the internet at www.ewm-group.com. Furthermore, the EWM factory team is on hand to assist you at all times on +49 2680 181-0 or at info@ewm-group.com.



■ Prices

See title page for validity. All price sheets with earlier dates are hereby void. The prices quoted are in euros before VAT.



■ Financing

Do you only require a machine temporarily, or you would like financing for it? We will be happy to provide you with an attractive leasing or rental quote. Get in touch with us or the dealer responsible for your area.



■ Warranty of up to 5 years

Our welding machines combine future-oriented, state-of-the-art technology of the highest quality in all their high-tech components. We take responsibility for it. Each of our products is carefully checked.

We have every faith in our products and therefore provide you with a 5 or 3-year warranty on our welding machines, even 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.



■ General terms and conditions of business + 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.

Contacting EWM

■ Internet www.ewm-group.com ■ Email info@ewm-group.com

You can reach us by telephone from Monday to Friday between 7.00am and 5.00pm: +49 (0)2680-181-0

■ Sales	sales@ewm-group.com	■ Marketing	marketing@ewm-group.com
■ Service	service@ewm-group.com	■ Technical documentation	documentation@ewm-group.com
■ Training	training@ewm-group.com	■ Quality management	qm@ewm-group.com
■ Products and process technology	welding@ewm-group.com	■ Automation	automatisierung@ewm-group.com

EN 1090 WPQR Package

Now a free download in PDF format!!

Save time and money on qualifying 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 machines¹ 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 Titan XQ puls, Phoenix puls, Taurus Synergic S, Taurus Steel or Picomig machine series.



This is how it works:

1. You acquire a new EWM welding machine from the Titan XQ puls, Phoenix puls, Taurus Synergic S, Taurus Steel or Picomig machine series
2. Register it with the machine serial number at <https://www.ewm-group.com/registrierung>

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.

In addition, the package can also be downloaded in PDF format.





















Type	Name	Item no.	PG
EN 1090 WPQR Package folder	EN 1090 WPQR Package in a folder	090-008803-00000	D1
EN 1090 WPQR Package download	EN 1090 WPQR Package in German as download	KOS-V00055-00000	N1
EN 1090 WPQR Package download	EN 1090 WPQR Package in English as a download	KOS-V00067-00000	N1

Would you like to know what the package contains?
Simply ask for a free demo version at
www.ewm-en1090.com

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

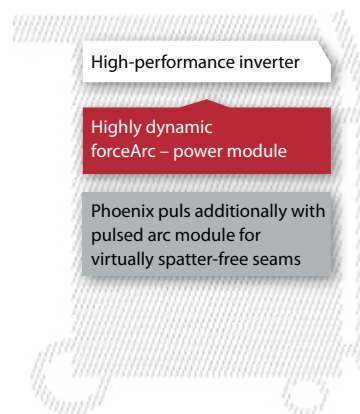
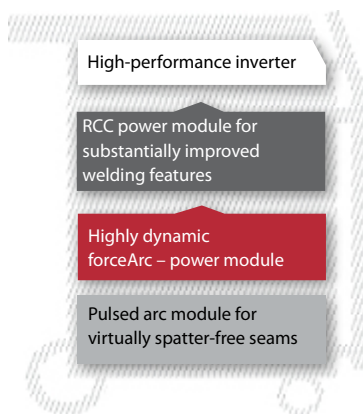
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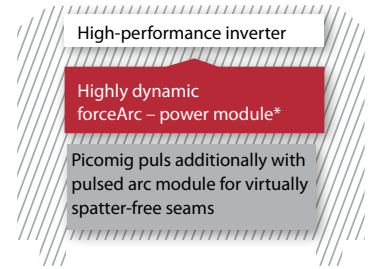
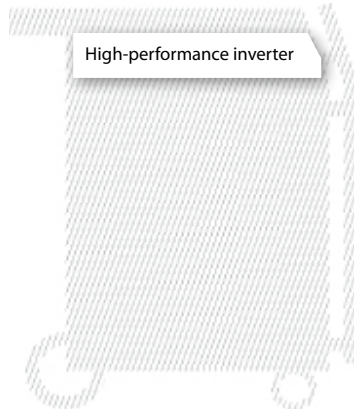
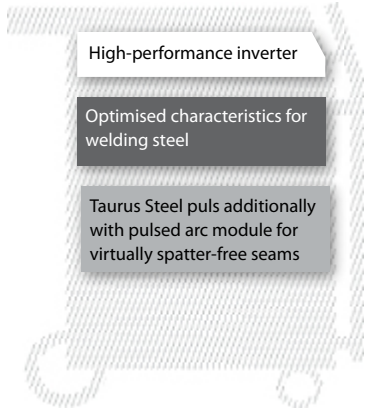
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Inverter welding machines and welding processes

From the portable inverter welding machines of the Picomig series, welding machines optimised for steel construction of the Taurus Steel series, the Multimatrix machines Phoenix puls and Taurus Synergic up to our flagship Titan XQ puls – we can provide you the suitable MIG/MAG welding machine!



		Titan XQ puls	Phoenix puls	Taurus Synergic S
Special	Open circuit voltage	82 V	79 V	79 V
	Xnet-compatible	✓	✓	✓
	Patented RCC module	✓	✗	✗
	forceArc power module	✓	✓	✓
MIG/MAG	acArc puls XQ	✓ XQ ⁴⁾	✗	✗
	rootArc/rootArc puls	✓ XQ / ✓ XQ	✓ / ✓	✓ / ✗
	coldArc/coldArc puls	✓ XQ / ✓ XQ	✗ / ✗	✗ / ✗
	forceArc/forceArc puls	✓ XQ / ✓ XQ	✓ / ✓	✓ / ✗
	wiredArc/wiredArc puls	✓ XQ / ✓ XQ	✗ / ✗	✗ / ✗
	Positionweld	✓	✗	✗
	superPuls	✓	✓	✓
	Pulsed arc	✓ XQ	✓	✗
	Standard	✓ XQ	✓	✓
	Unalloyed/ low-alloy steel	✓ XQ	✓	✓
	High-alloy/ stainless steel	✓ XQ	✓	✓ **
	Aluminium	✓ XQ	✓	✓ **
	Brazing	✓ XQ	✓	✓ **
	Surfacing	✓ XQ	✓	✓
	MMA	✓	✓	✓
TIG (lift arc)	✓	✓	✓	
Gouging	✓	✓	✓	
Number of Synergic characteristics	429	335	184	



	Taurus Steel Puls S	Taurus Steel Synergic S	Taurus Basic S	Taurus Basic	Picomig Puls	Picomig Synergic
	79 V	79 V	79 V	79 V	80 V	80 V
	x	x	x	x	x	x
	x	x	x	x	x	x
	x	x	x	x	✓ ¹⁾ /✓ ¹⁾	✓ ¹⁾
	x	x	x	x	x	x
	x/x	x/x	x/x	x/x	✓ ¹⁾ /✓ ¹⁾	✓ ¹⁾ /x
	x/x	x/x	x/x	x/x	x/x	x/x
	x/x	x/x	x/x	x/x	✓ ¹⁾ /✓ ¹⁾	✓ ¹⁾ /x
	x/x	x/x	x/x	x/x	x/x	x/x
	x	x	x	x	x	x
	x	x	x	x	x	x
	✓	x	x	x	✓	x
	✓	✓	✓	✓	✓	✓
	✓	✓**	✓**	✓**	✓	✓
	x	x	✓**	✓**	✓	x
	x	x	✓**	✓**	✓	✓**
	x	x	x	x	✓	✓**
	x	x	x	x	x	x
	✓	✓	✓	✓	✓	✓
	✓	✓	x	x	✓	✓
	✓	✓	✓	✓	x	x
	32	24	x	x	122/50 ²⁾	73/35 ³⁾

¹⁾ Only Picomig 355 puls/Picomig 355 Synergic

²⁾ Number of JOBs in Picomig 355 puls: 122

Number of JOBs in Picomig 180/185 puls: 50

³⁾ Number of JOBs in Picomig 355 Synergic: 73

Number of JOBs in Picomig 180/185 Synergic: 35

⁴⁾ Only Titan XQ AC puls

**Only standard, no pulse

MIG/MAG inverter pulse welding machines

Titan XQ puls C

Titan XQ 350 puls C

Titan XQ 400 puls C

XQ - Process

all in

- / rootArc®/rootArc® puls
- / coldArc®/coldArc® puls
- / forceArc®/forceArc® puls
- / wiredArc®/wiredArc® puls
- / Standard
- / Pulse welding
- / Positionweld
- / surPuls
- / TIG
- / MMA
- / Gouging

Xnet 2.0 ready



DC (40°)	350 A / 80 %	400 A / 60 %
	320 A / 60 %	350 A / 80 %
	-	320 A / 100 %
Welding machine control	Exrt-XQ 2.0	Exrt-XQ 2.0
	HP-XQ	HP-XQ
	LP-XQ	LP-XQ
Machine cooling	Gas/water	Gas/water
Product configurator	57	57

Titan XQ puls D

Titan XQ 350 puls D

Titan XQ 400 puls D

XQ - Process

all in

- / rootArc®/rootArc® puls
- / coldArc®/coldArc® puls
- / forceArc®/forceArc® puls
- / wiredArc®/wiredArc® puls
- / Standard
- / Pulse welding
- / Positionweld
- / surPuls
- / TIG
- / MMA
- / Gouging

Xnet 2.0 ready



DC (40°)	350 A / 100 %	400 A / 80 %
	-	-
	-	370 A / 100 %
Wire feeder control	EX-XQ 2.0	EX-XQ 2.0
	HP-XQ	HP-XQ
	LP-XQ	LP-XQ
Welding machine control	Optionally Exrt-XQ 2.0 or no control	Optionally Exrt-XQ 2.0 or no control
Machine cooling	Gas/water	Gas/water
Product configurator	64	64
Product configurator double wire feeder	66	66



3 in 1 MIG/MAG, TIG, MMA welding

Titan XQ AC puls

XQ - Process

all in

- / acArc puls
- / rootArc®/rootArc® puls
- / coldArc®/coldArc® puls
- / forceArc®/forceArc® puls
- / wiredArc/wiredArc puls
- / Standard
- / Pulse welding
- / Positionweld
- / surPuls
- / TIG
- / MMA
- / Gouging

Xnet 2.0 ready

Titan XQ 400 AC puls D



DC (40°)	400 A / 80 % 370 A / 100 %
Wire feeder control	EX-XQ 2.0
Welding machine control	Optionally Exrt-XQ 2.0 or no control
Machine cooling	Water
Product configurator	70


Titan XQ 500 puls D


Titan XQ 600 puls D



500 A / 80 % -	600 A / 40 % 550 A / 60 %
470 A / 100 %	470 A / 100 %
EX-XQ 2.0	EX-XQ 2.0
HP-XQ	HP-XQ
LP-XQ	LP-XQ
Optionally Exrt-XQ 2.0 or no control	Optionally Exrt-XQ 2.0 or no control
Gas/water	Gas/water
64	64
66	66

MIG/MAG inverter pulse welding machines

Phoenix puls	Phoenix 355 puls TKM
<p>MULTIMATRIX®</p> <ul style="list-style-type: none"> / MIG/MAG standard / forceArc®/forceArc® puls / rootArc®/rootArc® puls / Pulse welding / surPuls / TIG / MMA / Gouging <p>Xnet 2.0 ready</p>	
	<p>DC (40°)</p> <p>350 A / 40 %</p> <p>300 A / 60 %</p> <p>270 A / 100 %</p>
<p>Welding machine control</p>	<p>Exrt 2.0</p> <p>HP</p> <p>LP</p>
<p>Machine cooling</p>	<p>Gas/water</p>
<p>Details of version with HP/LP control in the welding machine from page</p>	<p>93</p>
<p>Details of version with Exrt 2.0 control in the welding machine from page</p>	<p>95</p>

Phoenix puls	Phoenix 355 puls TDM	Phoenix 405 puls TDM	Phoenix 505 puls TDM
<p>MULTIMATRIX®</p> <ul style="list-style-type: none"> / MIG/MAG standard / forceArc®/forceArc® puls / rootArc®/rootArc® puls / Pulse welding / surPuls / TIG / MMA / Gouging <p>Xnet 2.0 ready</p>			
	<p>DC (40°)</p> <p>350 A / 60 %</p> <p>300 A / 100 %</p>	<p>-</p> <p>400 A / 100 %</p>	<p>500 A / 60 %</p> <p>430 A / 100 %</p>
<p>Wire feeder control</p>	<p>EX 2.0</p> <p>HP</p> <p>LP</p>	<p>EX 2.0</p> <p>HP</p> <p>LP</p>	<p>EX 2.0</p> <p>HP</p> <p>LP</p>
<p>Welding machine control</p>	<p>Optionally Exrt 2.0 or no control</p>	<p>Optionally Exrt 2.0 or no control</p>	<p>Optionally Exrt 2.0 or no control</p>
<p>Machine cooling</p>	<p>Gas/water</p>	<p>Gas/water</p>	<p>Gas/water</p>
<p>Details of version without control in the welding machine</p>	<p>97</p>	<p>97</p>	<p>97</p>
<p>Details of version with Exrt 2.0 control in the welding machine from page</p>	<p>101</p>	<p>101</p>	<p>101</p>



3 in 1 MIG/MAG, TIG, MMA welding



MIG/MAG inverter pulse welding machines

Phoenix puls

Phoenix 401 puls FKW

Phoenix 501 puls FKW

MULTIMATRIX®

- / MIG/MAG standard
- / forceArc®/forceArc® puls
- / rootArc®/rootArc® puls
- / Pulse welding
- / surPuls
- / TIG
- / MMA
- / Gouging

Xnet 2.0 ready



DC (40°)

-
400 A / 100 %

500 A / 60 %
430 A / 100 %

Welding machine control

Exrt 2.0

-

HP

HP

LP

LP

Machine cooling

Water

Water

Details of version with HP/LP control in the welding machine page

105

105

Details of version with Exrt 2.0 control in the welding machine

107

Phoenix puls

Phoenix 351 puls FDW

Phoenix 401 puls FDW

Phoenix 451 puls FDW

Phoenix 551 puls FDW

MULTIMATRIX®

- / MIG/MAG standard
- / forceArc®/forceArc® puls
- / rootArc®/rootArc® puls
- / Pulse welding
- / surPuls
- / TIG
- / MMA
- / Gouging

Xnet 2.0 ready



DC (40°)

-
350 A/100%

-
400A / 100 %

450 A / 80 %
420 A / 100 %

550 A / 60 %
420 A / 100 %

Wire feeder control

EX 2.0

EX 2.0

EX 2.0

EX 2.0

HP

HP

HP

HP

LP

LP

LP

LP

Welding machine control

Optionally Exrt 2.0 or no control

Optionally Exrt 2.0 or no control

Optionally Exrt 2.0 or no control

Optionally Exrt 2.0 or no control

Machine cooling

Water

Water

Water

Water

Details of version without control in the welding machine

109

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109

Details of version with Exrt 2.0 control in the welding machine

112


112


112

112





3 in 1 MIG/MAG, TIG, MMA welding

Phoenix puls	Phoenix 351 puls 2DVX DW	Phoenix 401 puls 2DVX DW	Phoenix 451 puls 2DVX DW	Phoenix 551 puls 2DVX FDW
MULTIMATRIX® / MIG/MAG standard / forceArc®/forceArc® puls / rootArc®/rootArc® puls / Pulse welding / surPuls / TIG / MMA / Gouging Xnet 2.0 ready				
DC (40°)	-	-	450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	420 A / 100 %
Wire feeder control	EX 2.0	EX 2.0	EX 2.0	EX 2.0
	HP	HP	HP	HP
	LP	LP	LP	LP
Welding machine control	Optionally Exrt 2.0 or no control	Optionally Exrt 2.0 or no control	Optionally Exrt 2.0 or no control	Optionally Exrt 2.0 or no control
Machine cooling	Water	Water	Water	Water
Details of version without control in the welding machine	115	115	115	115
Details of version with Exrt 2.0 control in the welding machine	121	121	121	121

Phoenix puls	Phoenix 351 puls D FDW	Phoenix 401 puls D FDW	Phoenix 451 puls D FDW	Phoenix 551 puls D FDW
MULTIMATRIX® / MIG/MAG standard / forceArc®/forceArc® puls / rootArc®/rootArc® puls / Pulse welding/surPuls / TIG / MMA / Gouging Xnet 2.0 ready				
DC (40°)	-	-	450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	420 A / 100 %
Wire feeder control	EX 2.0	EX 2.0	EX 2.0	EX 2.0
	HP	HP	HP	HP
Welding machine control	None	None	None	None
Machine cooling	Water	Water	Water	Water
Details of version without control in the welding machine	118	118	118	118

MIG/MAG inverter welding machines


Taurus Synergic S		Taurus 355 TKM
MULTIMATRIX® / MIG/MAG standard / rootArc® / forceArc® / surPuls / TIG / MMA / Gouging Xnet 2.0 ready		
	DC (40°)	350 A / 40 % 300 A / 60 % 270 A/100%
Welding machine control	HP LP	
Machine cooling	Gas/water	
Details from page	127	

Taurus Synergic S		Taurus 355 TDM	Taurus 405 TDM	Taurus 505 TDM
MULTIMATRIX® / MIG/MAG standard / rootArc® / forceArc® / surPuls / TIG / MMA / Gouging Xnet 2.0 ready				
	DC (40°)	350 A / 60 % 300 A/100%	- 400 A / 100 %	500 A / 60 % 430 A / 100 %
Wire feeder control	EX 2.0 HP LP	EX 2.0 HP LP	EX 2.0 HP LP	
Welding machine control	None	None	None	
Machine cooling	Gas/water	Gas/water	Gas/water	
Details from page	129	129	129	




3 in 1 MIG/MAG, TIG, MMA welding

Taurus Synergic S	Taurus 351 FKG Taurus 351 FKW	Taurus 401 FKG Taurus 401 FKW	Taurus 501 FKW
MULTIMATRIX® / MIG/MAG standard / rootArc® / forceArc® / surPuls / TIG / MMA / Gouging Xnet 2.0 ready			
DC (40°)	350 A / 100 %-	400 A / 100 %	500 A / 60 % 430 A / 100 %
Welding machine control	HP LP	HP LP	HP LP
Machine cooling	Gas/water	Gas/water	Water
Details of gas cooled machines from page	133	133	-
Details of water-cooled machines from page	135	135	135

Taurus Synergic S	Taurus 351 FDG Taurus 351 FDW	Taurus 401 FDG Taurus 401 FDW	Taurus 451 FDG Taurus 451 FDW	Taurus 551 FDG Taurus 551 FDW
MULTIMATRIX® / MIG/MAG standard / rootArc® / forceArc® / surPuls / TIG / MMA / Gouging Xnet 2.0 ready				
DC (40°)	- 350 A / 100 %	- 400 A / 100 %	450 A / 80 % 420 A / 100 %	550 A / 60 % 420 A / 100 %
Wire feeder control	EX 2.0 HP LP	EX 2.0 HP LP	EX 2.0 HP LP	EX 2.0 HP LP
Welding machine control	None	None	None	None
Machine cooling	Gas/water	Gas/water	Gas/water	Gas/water
Details of gas cooled machines from page	137	137	137	137
Details of water-cooled machines from page	140	140	140	140

MIG/MAG inverter welding machines

Taurus Steel puls S	Taurus 405 Steel Puls S	Taurus 505 Steel Puls S
<ul style="list-style-type: none"> / MIG/MAG standard / Pulse welding / MMA / Gouging 		
DC (40°)	-	500 A / 60 %
	400 A / 100 %	430 A / 100 %
Wire feeder control	Taurus Steel Puls	Taurus Steel Puls
Welding machine control	None	None
Machine cooling	Gas/water	Gas/water
Details from page	160	160

Taurus Steel Synergic S	Taurus 405 Steel Synergic S	Taurus 505 Steel Synergic S
<ul style="list-style-type: none"> / MIG/MAG standard / MMA / Gouging 		
DC (40°)	-	500 A / 60 %
	400 A / 100 %	430 A / 100 %
Wire feeder control	Taurus Steel Synergic S	Taurus Steel Synergic S
Welding machine control	None	None
Machine cooling	Gas/water	Gas/water
Details from page	163	163



2 in 1 MIG/MAG, MMA welding

Taurus Basic S

Taurus 405 Basic S

Taurus 505 Basic S

- / MIG/MAG standard
- / MMA
- / Gouging



DC (40°)	-	500 A / 60 %
	400 A / 100 %	430 A / 100 %
Wire feeder control	Basic S	Basic S
Welding machine control	None	None
Machine cooling	Gas/water	Gas/water
Details from page	179	179

MIG/MAG inverter welding machines

Taurus Basic

Taurus 355 TKM

- / MIG/MAG standard
- / MMA
- / Gouging



DC (40°)	350 A / 40 %
	300 A / 60 %
	270 A/100%
Wire feeder control	-
Welding machine control	Basic
Machine cooling	Gas/water
Details from page	195

Taurus Basic

Taurus 355 TDM

Taurus 405 TDM

Taurus 505 TDM

Taurus 400 TDG


- / MIG/MAG standard
- / MMA
- / Gouging




DC (40°)	-	-	-	400 A / 30 %
	350 A / 60 %	-	500 A / 60 %	280 A / 60 %
	300 A/100%	400 A / 100 %	430 A / 100 %	230 A / 100 %
Wire feeder control	Basic	Basic	Basic	Basic
Welding machine control	Basic	Basic	Basic	Basic
Machine cooling	Gas/water	Gas/water	Gas/water	Gas
Details from page	197	197	197	193





2 in 1 MIG/MAG, MMA welding

Taurus Basic	Taurus 351 FKG Taurus 351 FKW	Taurus 401 FKG Taurus 401 FKW
<ul style="list-style-type: none"> / MIG/MAG standard / MMA / Gouging 		
DC (40°)	-	-
	350 A / 100 %	400 A / 100 %
Welding machine control	Basic	Basic
Machine cooling	Gas/water	Gas/water
Details of gas cooled machines from page	203	203
Details of water-cooled machines from page	205	205

Taurus Basic	Taurus 351 FDG Taurus 351 FDW	Taurus 401 FDG Taurus 401 FDW	Taurus 451 FDG Taurus 451 FDW	Taurus 551 FDG Taurus 551 FDW
<ul style="list-style-type: none"> / MIG/MAG standard / MMA / Gouging 				
DC (40°)	-	-	450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	420 A / 100 %
Wire feeder control	Basic	Basic	Basic	Basic
Welding machine control	Basic	Basic	Basic	Basic
Machine cooling	Gas/water	Gas/water	Gas/water	Gas/water
Details of gas cooled machines from page	207	207	207	207
Details of water-cooled machines from page	210	210	210	210

MIG/MAG inverter welding machines

Picomig puls	Picomig 180	Picomig 185	Picomig 355
<ul style="list-style-type: none"> / MIG/MAG standard / Pulse welding / rootArc®/rootArc® puls¹⁾ / forceArc®/forceArc® puls¹⁾ / TIG / MMA 			
DC (40°)	180 A / 25 % 120 A / 60 % 100 A / 100 %	180 A / 25 % 120 A / 60 % 100 A / 100 %	350 A / 40 % 300 A / 60 % 270 A / 100 %
Welding machine control	Picomig puls	Picomig puls	Picomig puls
Machine cooling	Gas	Gas	Gas/water
Details from page	204	208	210

Picomig Synergic	Picomig 180	Picomig 185	Picomig 355
<ul style="list-style-type: none"> / MIG/MAG standard / rootArc®¹⁾ / forceArc®¹⁾ / TIG / MMA 			
DC (40°)	180 A / 25 % 120 A / 60 % 100 A / 100 %	180 A / 25 % 120 A / 60 % 100 A / 100 %	350 A / 40 % 300 A / 60 % 270 A / 100 %
Welding machine control	Picomig Synergic	Picomig Synergic	Picomig Synergic
Machine cooling	Gas	Gas	Gas/water
Details from page	206	209	212



3 in 1 MIG/MAG, TIG, MMA welding*

Pico 350 cel puls

Pico 350 cel puls
+ Pico drive 4 L/Pico drive 200C

- / MMA
- / TIG
- / MIG/MAG CC/CV
- / MMA pulse
- / TIG pulse



DC (40°)

350 A / 35 %

280 A / 60 %

230 A / 100 %

Machine cooling

Gas

Details from page

426

Gouging

Set Taurus 505 Basic Duo Gouging

- / Gouging
- / MIG/MAG
- / MMA



DC (40°)

1000 A / 60 %

860 A / 100 %


Machine cooling



Gas

Details from page

201

MIG/MAG welding machines, step switch controlled

Mira	Mira 151 FKG	Mira 221 MV FKG	Mira 251 FKG	Mira 301 FKG
/ MIG/MAG standard				
DC (40°)	150 A / 15 % 55 A / 100 %	220 A / 15 % 85 A / 100 %	250 A / 20 % 125 A / 100 %	300 A / 20 % 150 A / 100 %
Welding machine control	M1.02 -	M1.02 -	M1.02 -	M1.02 M2.40
Machine cooling	- Gas	- Gas	- Gas	M2.20 Gas
Details from page	240	240	240	240

Saturn	Saturn 301 FKG	Saturn 351 FDG
/ MIG/MAG standard	 	
DC (40°)	300 A / 40 % 190 A / 60 % 190 A / 60 %	350 A / 40 % 250 A / 60 % 220 A / 100 %
Wire feeder control	- -	M1.02 M2.20 M2.40
Welding machine control	M1.02 M2.20 M2.40	- - -
Machine cooling	Gas	Gas
Details from page	243	246



Wega	Wega 401 FKW Wega 401 FKG	Wega 401 FDW Wega 401 FDG
/ MIG/MAG standard		
DC (40°)	-	-
	400 A / 60 %	400 A / 60 %
	300 A / 100 %	300 A / 100 %
Wire feeder control	-	M1.02
	-	M2.20
	-	M2.40
Welding machine control	M1.02	-
	M2.20	-
	M2.40	-
Machine cooling	Gas/water	Gas/water
Details from page	248	252

Wega	Wega 501 FDW	Wega 601 FDW
/ MIG/MAG standard		
DC (40°)		-
	500 A / 60 %	-
	400 A / 100 %	450 A / 100 %
Wire feeder control	M1.02	M1.02
	M2.20	M2.20
	M2.40	M2.40
Welding machine control	None	None
Machine cooling	Water	Water
Details from page	254	254

MIG/MAG accessories

Wire feeders and options

Drive XQ

drive 4X



Details from page

72

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Drive 4 Basic S

Drive 4 Basic S D200

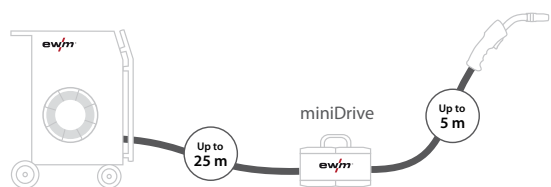


Details from page

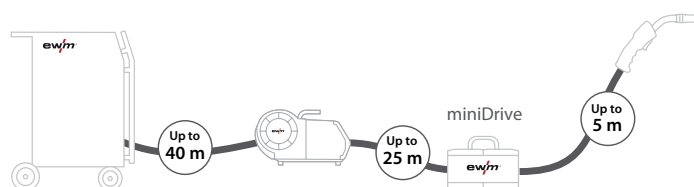
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Intermediate drive – miniDrive*



System example: Compact welding machine + miniDrive



System example: Decompact welding machine with reinforced pump + wire feeder + miniDrive

* Compatibility machine-dependent

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



drive 4X IC

drive 4X IC D

Drive 4X Steel

Drive 4X Steel D200



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166



168

drive 4 Basic

drive 4 IC

drive 41L

drive 41



213



216



258



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miniDrive WS

miniDrive WS V+A



Welding current maximum

400 A

400 A

Volt/amre display

-





Details on the pages

81 / 151 / 172 / 186

81 / 151 / 172 / 186

MIG/MAG accessories

Welding torches	PM MIG/MAG welding torches	MT MIG/MAG welding torches
		
Details from page	279	298

Accessories/options	Intermediate hose packages	Remote controls
		
Suitable for Titan XQ	82	84
Suitable for Phoenix puls/Taurus Synergic	149	155
Suitable for Taurus Steel	167	175
Suitable for Taurus Basic S	179	189
Suitable for Taurus Basic	211	219
Suitable for Picomig	-	-
Suitable for Mira/Saturn/Wega	260	-



UM MIG/MAG welding torches



314

TIG welding torches for MIG/MAG multiprocess machines



318

Machine options



76

322

322

322

322

-

322

Cooling units



320

320

320

320

320

-

Drive rolls



264

264

264



264

264




267

267

TIG DC inverter welding machines


Picotig DC	Picotig 200 puls	Picotig MV 200 puls
<ul style="list-style-type: none"> / TIG DC / TIG pulse / MMA / MMA pulse 		
DC (40°)	200 A / 25 % 150 A / 60 % 140 A / 100 %	200 A / 25 % ¹⁾ 150 A / 60 % ¹⁾ 140 A / 100 % ¹⁾
Welding machine control	Picotig Puls	Picotig Puls
Machine cooling	Gas	Gas
Details from page	345	345


¹⁾ Input voltage 230 V

Tetrix DC	Tetrix 200 Comfort 2.0/Smart 2.0	Tetrix 200 MV Comfort 2.0/Smart 2.0	Tetrix 230 Comfort 2.0/Smart 2.0	Tetrix 300 Comfort 2.0/Smart 2.0
<ul style="list-style-type: none"> / TIG DC / TIG pulse / activArc® / spotArc® / MMA / MMA pulse 				
DC (40°)	200 A / 25 % 150 A / 60 % 140 A / 100 %	200 A / 25 % ¹⁾ 150 A / 60 % ¹⁾ 140 A / 100 % ¹⁾	230 A / 40 % 200 A / 60 % 170 A / 100 %	300 A / 35 % 260 A / 60 % 210 A / 100 %
Welding machine control	Smart 2.0 Comfort 2.0	Smart 2.0 Comfort 2.0	Smart 2.0 Comfort 2.0	Smart 2.0 Comfort 2.0
Machine cooling	Gas	Gas	Gas/water	Gas/water
Xnet 2.0 ready	-	-	-	✓
Details from page	352	352	354	356





2 in 1 TIG and MMA welding

Tetrix DC	Tetrix 300
<ul style="list-style-type: none"> / TIG DC / activArc® / spotArc® / MMA 	
DC (40°)	300 A / 60 % 250 A / 100 %
Welding machine control	Smart Comfort
Machine cooling	Gas/water
Details from page	361

Tetrix DC	Tetrix 351 Comfort 2.0 / Smart 2.0	Tetrix 401 Comfort 2.0 / Smart 2.0	Tetrix 451 Comfort 2.0 / Smart 2.0	Tetrix 551 Comfort 2.0 / Smart 2.0
<ul style="list-style-type: none"> / TIG DC / TIG pulse / activArc® / spotArc® / MMA / MMA pulse Xnet 2.0 ready 				
DC (40°)	-	-	-	-
	-	-	450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	420 A / 100 %
Welding machine control	Smart 2.0	Smart 2.0	Smart 2.0	Smart 2.0
	Comfort 2.0	Comfort 2.0	Comfort 2.0	Comfort 2.0
	Synergic	Synergic	Synergic	Synergic
Machine cooling	Water	Water	Water	Water
Details from page	358	358	358	358

* Xnet only optionally with ON 7pol (092-001826-00000) "7-pole connection socket for accessory components and/or as a digital interface"

TIG AC/DC inverter welding machines

Picotig AC/DC	Picotig 200 AC/DC puls	
<ul style="list-style-type: none"> / TIG DC/TIG AC / TIG pulse / MMA / MMA pulse 		
DC (40°)	200 A / 35 %	
	150 A / 60 %	
	140 A / 100 %	
Welding machine control	Picotig Puls AC/DC	
Machine cooling	Gas/water	
Details from page	348	
Tetrix AC/DC	Tetrix 230 AC/DC Comfort 2.0 / Smart 2.0	Tetrix 300 AC/DC Comfort 2.0 / Smart 2.0
<ul style="list-style-type: none"> / TIG DC/TIG AC / TIG pulse / activArc® / spotArc® / MMA / MMA pulse 		
DC (40°)	230 A / 40 %	300 A / 35 %
	200 A / 60 %	260 A / 60 %
	170 A / 100 %	210 A / 100 %
Welding machine control	Smart 2.0 AC/DC	Smart 2.0 AC/DC
	Comfort 2.0 AC/DC	Comfort 2.0 AC/DC
Machine cooling	Gas/water	Gas/water
Xnet 2.0 ready	-	☑
Details from page	366	368




2 in 1 TIG and MMA welding

Tetrix AC/DC	Tetrix 351 AC/DC Comfort 2.0 / Smart 2.0	Tetrix 451 AC/DC Comfort 2.0 / Smart 2.0	Tetrix 551 AC/DC Comfort 2.0 / Smart 2.0
<ul style="list-style-type: none"> / TIG DC/TIG AC / TIG pulse / activArc® / spotArc® / MMA / MMA pulse <p>Xnet 2.0 ready</p>			
DC (40°)	-	450 A / 80 %	550 A / 60 %
	350 A / 100 %	420 A / 100 %	420 A / 100 %
Welding machine control	Smart 2.0 AC/DC Comfort 2.0 AC/DC Synergic AC/DC	Smart 2.0 AC/DC Comfort 2.0 AC/DC Synergic AC/DC	Smart 2.0 AC/DC Comfort 2.0 AC/DC Synergic AC/DC
Machine cooling	Water	Water	Water
Details from page	370	370	370

* Xnet only optionally with ON 7pol (092-001826-00000) "7-pole connection socket for accessory components and/or as a digital interface"

Plasma welding machines

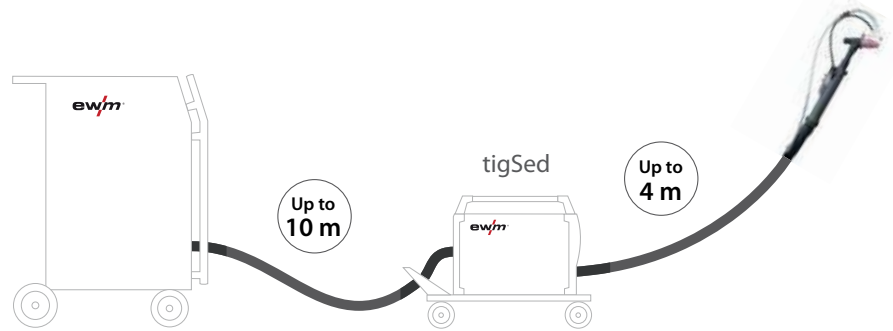
2 in 1 Plasma and TIG welding

Microplasma	Microplasma 25	Microplasma 55	Microplasma 105
<ul style="list-style-type: none"> / Plasma / Plasma-Puls / TIG DC / TIG pulse <p>Xnet 2.0 ready</p>			
DC (40°)	-	-	100 A / 60 %
	20 A / 100 %	50 A / 100 %	70 A / 100 %
Welding machine control	Comfort 2.0 P Water	Comfort 2.0 P Water	Comfort 2.0 P Water
Details from page	389	389	389

Accessories TIG/plasma welding machines

tigSed* hot/cold wire system

- / Wire feeders for hot and cold wire
- / With surimposed forward/backward wire motion
- / Can be used with any water-cooled TIG welding machine



System example: TIG welding machine + tigSed + welding torch

Accessories/options

TIG welding torches

TIGCold/hot wire welding torches




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Details from page





	tigSed continuous drive 45 coldwire	tigSed oscillation drive 45 coldwire	tigSed continuous drive 45 hotwire	tigSed oscillation drive 45 hotwire
				
Cold wire	✓	✓	✓	✓
Hot wire	-	-	✓	✓
Constant wire feeding	✓	✓	✓	✓
Surpuls	✓	✓	✓	✓
Oscillating wire feeding	-	✓	-	✓
Details from page	372	372	373	373

Plasma welding torches	Remote controls	Cooling units	Options
			
391	394	401	404




MMA inverter welding machines

Pico	Pico 160 cel puls	Pico 160	Pico 162 MV
<ul style="list-style-type: none"> / MMA / MMA pulse ¹⁾ / TIG DC / TIG pulse ¹⁾ <p>Pico 350 cel puls additionally:</p> <ul style="list-style-type: none"> / MIG/MAG CC/CV 			
DC (40°)	150 A / 30 %	150 A / 35 %	150 A / 35 % ²⁾
	120 A / 60 %	120 A / 60 %	120 A / 60 % ²⁾
	110 A / 100 %	100 A / 100 %	100 A / 100 % ²⁾
Details from page	419	418	422
¹⁾ Pico 160 and Pico 162 MV no pulse functions			²⁾ Input voltage 230 V

Pico	Pico 300 cel	Pico 300 cel pws
<ul style="list-style-type: none"> / MMA / TIG DC 		
DC (40°)	300 A / 25 %	300 A / 25 %
	220 A / 60 %	220 A / 60 %
	170 A / 100 %	170 A / 100 %
Details from page	425	425



2 in 1 TIG and MMA welding

Pico 180 puls	Pico 220 cel puls	Pico 350 cel puls	Pico 350 cel puls pws
			
180 A / 25 %	220 A / 30 %	350 A / 35 %	350 A / 35 %
130 A / 60 %	160 A / 60 %	280 A / 60 %	280 A / 60 %
120 A / 100 %	140 A / 100 %	230 A / 100 %	230 A / 100 %
423	424	426	426

Degaussing

- / Degaussing of pis and metal plates
- Pico 350 cel puls pws dgs additionally:**
- / MMA
- / TIG
- / MIG/MAG CC/CV
- / MMA pulse
- / TIG pulse

Pico 350 cel puls pws dgs

Degauss 600



Degaussing current

10 A–350 A

10 A–600 A

activgauss

-

10 A–250 A

DC (40°)

350 A / 35 %

-

280 A / 60 %

-

230 A / 100 %

-

Details from page

428

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MMA accessories

Remote controls

Options/accessories



Details from page

431

435

General accessories

Software

Xnet 2.0 software



Details from page

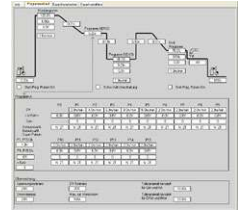
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Xbutton



459

PC300 XQ



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Accessories

Multi-voltage machines



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441

Packing units
welding machines

General accessories



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Trolleys



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Testing instrument for retition tests



499

Calibration device



500

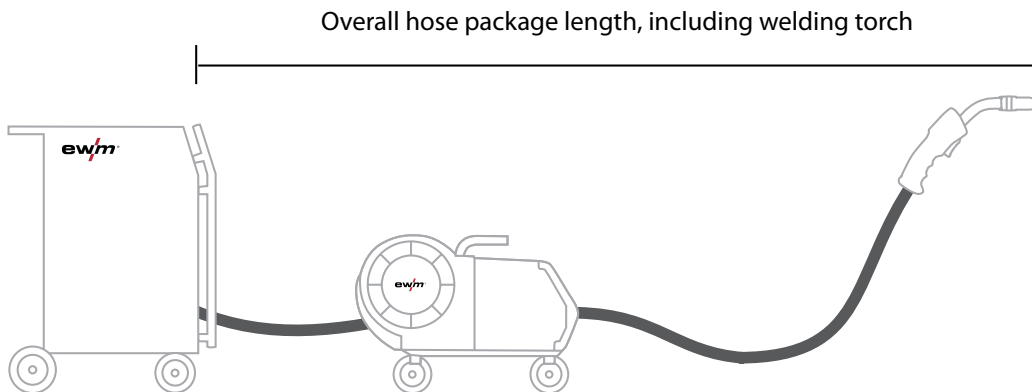
Welding Trainer Soldamatic



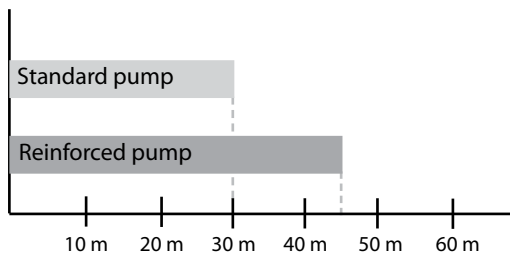
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Use of standard pump/reinforced pump EWM welding machines

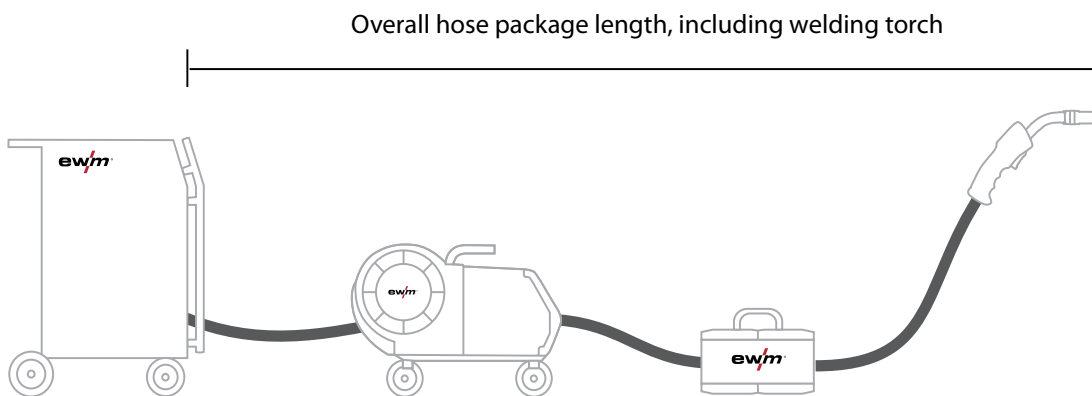
1) Welding machines with separate wire feeder



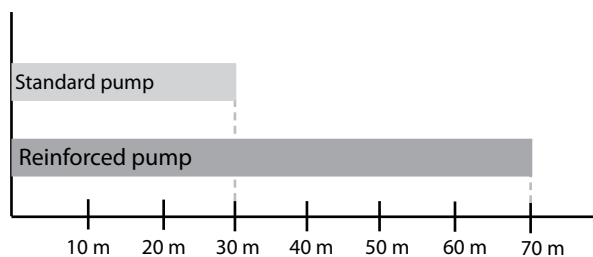
Standard pump: up to 30 m overall hose package length, including welding torch
Reinforced pump: up to 45 m overall hose package length, including welding torch



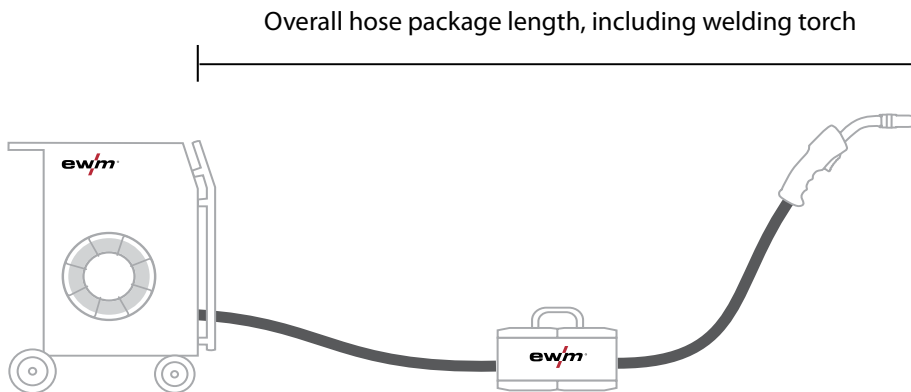
2) Welding machines with a separate wire feeder and additional miniDrive



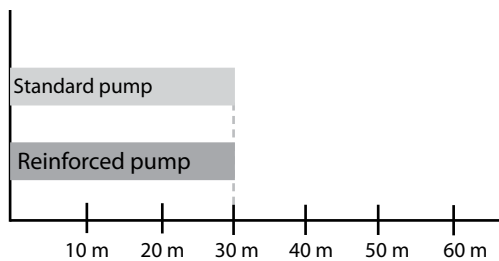
Standard pump: up to 30 m overall hose package length, including welding torch
Reinforced pump: up to 70 m overall hose package length, including welding torch



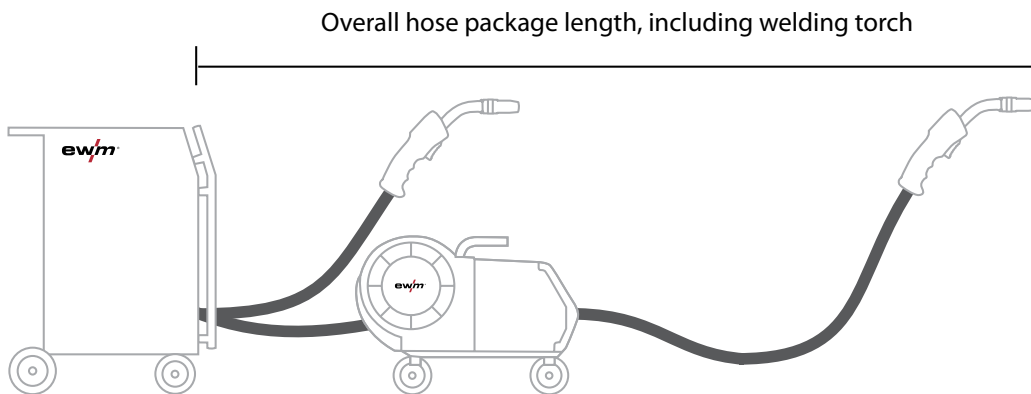
3 Compact welding machines with additional miniDrive



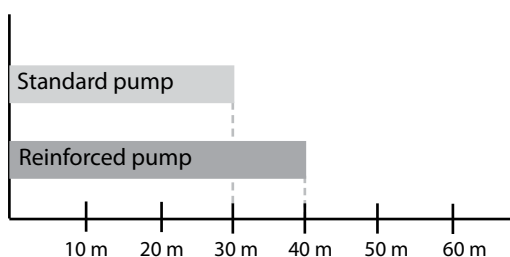
Standard pump: up to 30 m overall hose package length, including welding torch
Reinforced pump: up to 30 m overall hose package length, including welding torch



4) Compact welding machines with a second, separate wire feeder



Standard pump: up to 30 m overall hose package length, including both welding torches
Reinforced pump: up to 40 m overall hose package length, including both welding torches



Transport on trolley

In the tables below, you can see which shielding gas cylinders you can carry on our trolleys or welding machines:

Trolley 35-1



Trolley 35.2-2



Trolley 35-6



Trolley 38-2 E



Trolley 55-6/
Trolley 55-5



Classification

Transport carts	Trolley 35-1	Trolley 35.2-2	Trolley 35-6	Trolley 38-2 E	Trolley 55-6/ Trolley 55-5
Shielding gas cylinders up to 200 bar					
10 L	●	●	-	●	●
20 L	●	●	-	●	●
50 L	-	●	-	●	●
Max. shielding gas cylinder height in mm	970 (+/-20)		-	1,640 (+/-20)	
Max. diameter in mm	204 (+/-1%)		-	229 (+/-1%)	
Shielding gas cylinders up to 300 bar					
10 L	●	●	-	●	●
20 L	●	●	-	●	●
33 L	●	●	-	●	●
50 L	-	●	-	●	●
Max. shielding gas cylinder height in mm	970 (+/-20)		-	1,640 (+/-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 on mobile welding machine

Shielding gas cylinders, 200/300 bar	Titan XQ puls	Phoenix puls	Taurus Synergic	Taurus Basic
10 L	●	● ¹⁾	● ¹⁾	● ¹⁾
20 L	●	● ¹⁾	● ¹⁾	● ¹⁾
33 L (300 bar only)	●	● ¹⁾	● ¹⁾	● ¹⁾
50 L	●	●	●	●
Max. shielding gas cylinder height in mm	1,640 (+/-20)			
Max. diameter in mm	229 (+/-1%)			

Shielding gas cylinders, 200/300 bar	Mira	Saturn	Wega 401	Wega 501/601
10 L	●	●	● ¹⁾	-
20 L	●	●	● ¹⁾	-
33 L (300 bar only)	-	●	● ¹⁾	-
50 L	-	-	●	●
Max. shielding gas cylinder height in mm	970 (+/-20)	1,065 (+/-20)	1,640 (+/-20)	
Max. diameter in mm	204 (+/-1%)	229 (+/-1%)	229 (+/-1%)	

Shielding gas cylinders, 200/300 bar	Tetrix DC/Tetrix 351 AC/DC	Tetrix 451/551 AC/DC
10 L	● ¹⁾	● ²⁾
20 L	● ¹⁾	● ²⁾
33 L (300 bar only)	● ¹⁾	● ²⁾
50 L	●	●
Max. shielding gas cylinder height in mm	1,640 (+/-20)	
Max. diameter in mm	229 (+/-1%)	














¹⁾ The option ON HOLDER GAS BOTTLE<50L (092-002151-00000) must be used to transport a shielding gas cylinder for these gas cylinder sizes. Not suitable for double cylinder carts. For more detailed information, please see the respective operating instructions.

²⁾ For the marked gas cylinder sizes, the option ON HOLDER GAS BOTTLE<50L TETRIX XL (092-002345-00000) must be used to transport a shielding gas cylinder. Not suitable for double cylinder carts. Consult the respective operating instructions for more detailed information.

Symbols and abbreviations

Symbols

	1-phase connection		8-pole torch connection
	2-phase connection		12-pole torch connection
	3-phase connection		14-pole remote control connection
	3-phase connection, TNS mains		19-pole torch connection
	5-pole torch connection		28-pole connection
	7-pole remote control connection		

Abbreviations

2DV	Two wire feeders	pws	Pole reversing switch
2T	Double push-button	RD2	Remote Control control 2 with high-quality OLED display
2U/D	2 x Up/down controls	RD3	Remote Control control 3 with high-quality OLED display
4R	Four rolls	TDG	Portable, decompact, gas cooled
5P	5-pole connection socket	TDM	Portable, decompact, modular
8P	8-pole connection socket	TGD	Portable, gas cooled, decentral
ADAP	Adapter	TGE	Portable, gas cooled, Euro torch connector
ASM	Connection capability	TKM	Portable, compact, modular
AW	Filler wire connection capability	TMD	Portable, modular, decentral
cel	Cellulose electrodes	U/D	Up/down control
C	Compact	WD	Water cooled, decentral
CW	Cold wire	WD UD	Water cooled, decentral, up/down
D	Double wire feeder	WE	Water cooled, Euro torch connector
D2	Wire spool D200		
D3	Wire spool D300		
DG	Decompact, gas cooled		
DW	Decompact, water cooled		
EZA	Euro torch connector		
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	Hot wire		
KGE	Compact, gas cooled, Euro torch connector		
LED	LED lighting		
MM	Multimatrix		
MV	Multivolt		
PC1	Powercontrol 1 control		
PC2	Powercontrol 2 control		

Titan XQ puls overview

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Titan XQ puls – a rfect series

Wishful thinking becomes reality

Maximum operating convenience, long service life and all pulse, standard and innovative welding processes optimised and included in the machine at no extra charge.

The members of the Titan XQ family are taking a quantum leap in welding technology. Here, rfect weld seams are already pre-programmed for high-alloy and low-alloy steels and aluminium in all material thicknesses and all

positions. Thanks to the many options and accessories for the Titan XQ puls series, you can put together your machine in the way that best suits you, your needs and your applications.

An exceptionally long duty cycle of 100% at up to 350 A, for example, makes for effective working. rfect welding becomes sustainable – 24 hours a day, 7 days a week.



Titan XQ puls compact



Titan XQ puls



Titan XQ puls
double wire feeder



All MIG/MAG processes included in the machine at no extra charge!

With the new Rapid Current Control (RCC) inverter technology, the welding characteristics of the Titan XQ puls have been improved for all welding processes.

- / rootArc XQ/rootArc puls XQ – for rfect root welding
- / coldArc XQ/coldArc puls XQ – minimises heat for thin sheet welding
- / forceArc XQ/forceArc puls XQ – high-rformance arc with deep netration
- / wiredArc XQ/wiredArc puls XQ – high-rformance arc with netration stabilisation through dynamic wire feeding
- / Positionweld XQ – for positional welding
- / Pulse XQ and standard XQ arc
- / TIG and MMA welding, gouging

Titan XQ puls compact – with integrated eFeed wire feeder

Consistently perfect results

The Titan XQ puls compact, with its 350 A and 400 A models is ideal for welding booths, trade and training. In conjunction with the optional miniDrive intermediate drive, the action radius can be expanded to up to 30 m. Using our welding torch models with control function, you can operate the Titan XQ puls compact quite conveniently from

your workplace. The integrated eFeed wire feeder increases operating convenience for every user and optimises results. Precise wire feeding has a positive effect on welding characteristics and ensures optimal results.

Control

- / Users can choose from three controls:
 - HP-XQ
 - LP-XQ
 - Exrt XQ 2.0, also available with LAN/Wi-Fi gateway

LED status bar

- / Colour indicates the current operating status



Connection panel

- / Easy, manual polarity reversal without the need for tools

Euro torch connector

- / Worldwide standard
- / Remote control of the function torch without the need for a control cable thanks to digital X technology

Torch cooling

- / Can be gas or water cooled
- / Optimum cooling capacity 1,500 W, high performance centrifugal pump and 8-litre water tank

Wire feeding – precise and practical

- / Four driven wire feed rolls
- / Automatic wire inching saves time
- / Easy, tool-free roll change
- / Permanently secured roll fasteners

Wire spool diameter D200/300

- / Changing wires and operating the machine is easy even with poor lighting thanks to the interior lighting



Titan XQ puls – for even greater flexibility

Ideal for demanding jobs

If you are working on large components or in hard-to-reach areas, the Titan XQ puls is the right welding machine for you. Its mobile wire feeder with integrated control gives you greater flexibility in application and range.

With their wide range of options and accessories for the Drive XQ wire feeder, the models for 350 A, 400 A, 500 A and 600 A (either gas or water cooled) can be adapted to any special or exceptional requirements you may have. This

includes, for example, a wheel kit with large wheels, the heavy-duty set with a protective plate and stable crane suspension for even greater freedom of movement.

flexFit casing system with numerous mounting options – tidy equipment, tidy welding

- / Intermediate hose package holder, wire feeder cross arm – you name it: many individually used accessories and options can be fixed to the continuous cast aluminium profile of the housing's upper cross members using the practical slot nuts

EWM intermediate hose packages – the highest quality standards for a long service life

- / Industrial quality plug
- / Highly flexible control and welding cables for high bending and torsional demands
- / Fabric-sheathed hoses for high pressure and temperature loads
- / Diffusion-proof gas hoses conforming to EN 559
- / Heavy duty protective hose casings
- / Strain relief on both ends
- / Quick replacement – all connections are accessible from the outside



Optional



WHS – wire spool heater



WRS – wire reserve sensor



Drive XQ – brings all functions to the workplace

- / Wire feeder, available in three practical control variants

Protective cap – doesn't give dirt a chance

- / Protects the entire control system against contamination and knocks
- / Protective cap can be opened easily, even with gloves, thanks to the ergonomically-shaped grip

Option: Rotatable wire feeder

Handle – very practical

- / Ergonomic design
- / Can be easily gripped even when wearing gloves enabling the machine to be moved safely
- / Workpiece lead or torch hose package can be practically and neatly hung on the upper part of the handles
- / Mounting option for a torch holder on both handles, customised for right and left-handed users (optional)

Handlebar

- / Robust continuous cast aluminium bar with ergonomically rounded back and easy-to-grasp diameter for easy movement of the welding machine
- / Flexible use thanks to flexFit system on the underside for carrying accessories and options by means of slot nuts

Connection panel

- / Connections tilted slightly downwards on the front and back reduce the risk of connected cables kinking
- / Easy connection of all cable connections without tools

Optional



DGC – electronic gas flow control saves you money

Can be individually configured exactly to your needs

Customised design: with and without gas cylinder holder for one or two cylinders, mains cable length up to 15 m, versions for two wire feeders and more.

Option of two wire feeders – change welding tasks with no set-up time

- / Effortless switch between two different wires and shielding gases, e.g. for welding solid wire and flux cored wires

Safe crane transportation – levitation made easy

- / 4 sturdy holders (40 mm Ø) for easy hook-in or through connection of the crane harness



Large wheels to overcome obstacles

- / Generous 250 mm diameter means the machine can be easily moved and effortlessly overcomes obstacles such as cables or thresholds
- / Large track widths ensure stability of the stand, even on inclinations of up to 15°

Guide castors – reach your target

- / An above average diameter of 160 mm makes moving, steering and overcoming obstacles easy
- / Features a locking brake to prevent rolling away, even on slopes



Optional



WHS – wire spool heater



WRS – wire reserve sensor



Gas cylinder holder on top – for a secure grip

- / For single or double cylinders (optional)
- / Quick and easy securing of the shielding gas cylinder using straps with turnbuckles
- / Secure strain relief for intermediate hose packages using holders



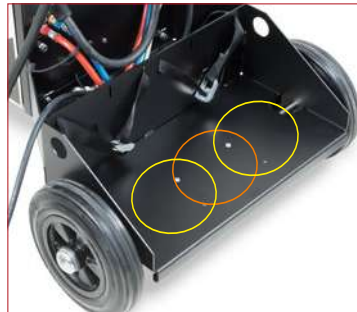
Strain relief for intermediate hose package



Gas cylinder holder for one shielding gas cylinder

Gas cylinder holder below – a good position

- / For single or double cylinders as standard
- / Low, flat loading edge of the cylinder cart makes it easy to place the shielding gas cylinder



Torch cooling – large volume for great performance

- / Excellent torch cooling reduces costs through lower consumption of torch consumables
- / Optimum cooling capacity 1,500 W, high performance centrifugal pump and 8-litre water tank

Optional



DGC – electronic gas flow control
saves you money

Titan XQ 400 AC puls – acArc puls XQ for aluminium welding

In the new Titan XQ 400 AC puls, the new AC welding process **acArc puls XQ** and all DC welding processes are included in the machine – and at no extra charge. In this way, EWM is revolutionising MIG-AC aluminium welding. The Titan XQ 400 AC puls is fitted with an Exrt 2.0 XQ control and water cooling. With many options and extensive accessories, every

user can adapt the machine to themselves and their area of application. Only one thing remains the same: optimum quality, high duty cycle and subsequently long service life, excellent welding characteristics and intuitive operation.

all in

All AC and established DC-MIG/MAG processes are included in the machine at no extra charge!

With the new Rapid Current Control (RCC) inverter technology, the welding characteristics of the Titan XQ puls have been significantly improved for all welding processes.

- / New! acArc puls XQ – ideal for aluminium welding with thin sheets
- / rootArc XQ/rootArc puls XQ – for perfect root welding
- / coldArc XQ/coldArc puls XQ – minimises heat for thin sheet welding
- / forceArc XQ/forceArc puls XQ – high-performance arc with deep penetration
- / wiredArc XQ/wiredArc puls XQ – high-performance arc with penetration stabilisation through dynamic wire feeding
- / Positionweld – for positional welding
- / Pulse XQ and standard XQ
- / TIG and MMA welding, gouging

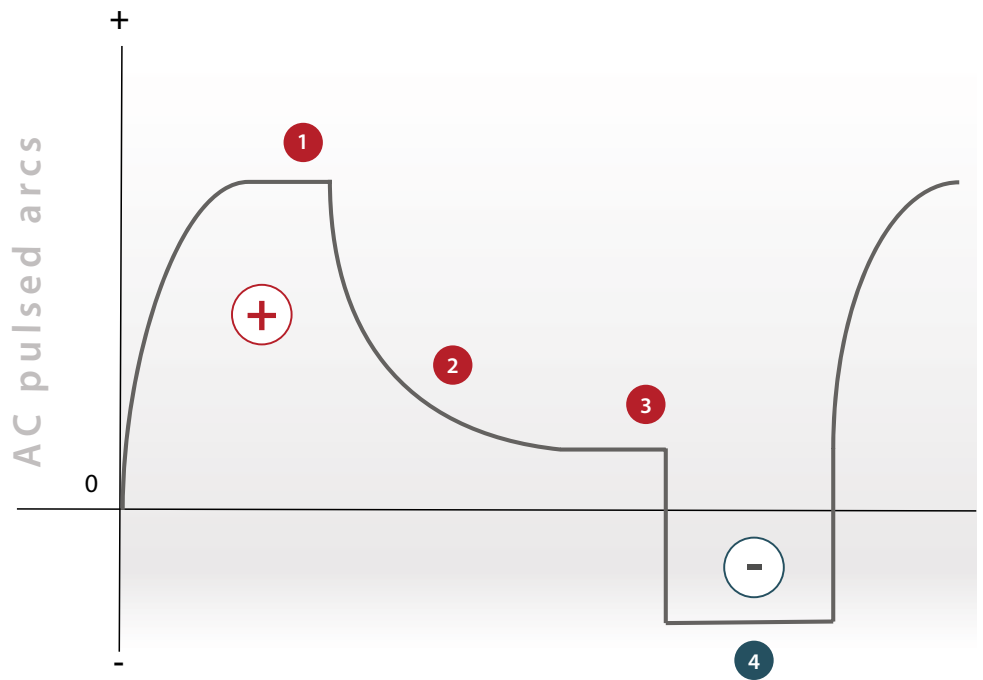
Advantages

- / perfect aluminium welding, even with thin sheets
- / Very good ignition characteristics
- / Excellent air gap bridging, even with automated applications
- / Minimised heat input
- / Faster welding speed
- / Simple and safe handling of the arc for manual and automated welding
- / Well suited for additive welding with aluminium (3D welding)
- / Clean weld seams due to heavily reduced magnesium oxide
- / Lower welding fume emissions
- / Fast digital current regulation with EWM Rapid Current Control (RCC) technology



With the AC alternating current welding process of the new Titan XQ 400 AC puls, MIG aluminium welding becomes even easier in both manual and automated sectors. Clean weld seams without traces of smoulder on thin sheets, even with AlMg alloys, are possible with MIG-AC.

With the **acArc puls XQ**, the polarity switches between positive (pulse) and negative during the process with the heat shifting from the material to the welding consumable. Air gaps are effectively bridged, and welding fume emissions reduced.



+ Positive phase

1



Droplet formation in the pulse phase

2



Droplet detachment after the pulse phase

3



Fundamental current phase

- Negative phase

4



Cleaning and warm-up of the wire in the negative phase

Overview of ex works options



DGC – electronic gas flow control saves you money

- / Prevents welding errors caused by too much or too little gas
- / Efficiency through gas savings thanks to accurate settings
- / Precise, digitally adjustable gas quantity
- / Suitable gas quantity for the respective welding task (JOB) optimally set at the factory
- / Exact gas quantity depending on the shielding gas automatically without conversion for argon mixed gas, CO₂, helium
- / No gas blast with turbulence when igniting the arc as electrical valve opens and closes gently
- / Welding stop when dropping below the critical quantity of gas (shielding gas cylinder empty or gas supply interrupted)
- / Simplified calculation by recording the exact gas consumption via the Xnet software (optional)
- / Not available with the Titan compact



WHS – wire spool heater, the new dry sll

- / Preheating prevents moisture accumulating on the welding wire
- / Controlled temperature to 40 °C
- / Reduced risk of hydrogen pores



WRS – wire reserve sensor, no surprises during welding

- / Warns at 10% residual quantity of the wire spool by means of a control lamp
- / Minimises the risk of weld defects as a result of the wire running out during the welding process
- / Forward-looking production planning reduces non-productive times and thus production costs as a new wire spool can be inserted in good time

Orating concepts – Titan XQ puls compact

Orating concepts – Exrt XQ 2.0/Xnet



Exrt XQ 2.0
Exrt XQ 2.0 LG with integrated LAN gateway
Exrt XQ 2.0 WLG with integrated LAN/Wi-Fi gateway

Optionally:

Exrt XQ 2.0/

Exrt XQ 2.0 LG with integrated LAN gateway/

Exrt XQ 2.0 WLG with integrated LAN/Wi-Fi gateway:

- / Most comprehensive orating and setting options
- / Network connection with ewm Xnet (via an integrated or external gateway)
- / Plain text display for welding parameters and functions
- / Quick change between innovative welding processes (without JOB switching)
- / WPQR welding data assistant
- / Calculation of T8/5 cooling time
- / Welding data monitoring
- / JOB favourites list
- / USB interface
- / Xbutton
- / 16 pre-installed languages*
- / USB connection and access authorisation using Xbutton

HP-XQ



- / All important setting options with direct access
- / Quick change between innovative welding processes (without JOB switching)
- / Welding sequence parameters: all parameters set using flow chart
- / Network connection with ewm Xnet (via an external gateway)
- / Click wheel oration
- / Energy r unit length calculation thanks to kW display

LP-XQ



- / All important setting options with direct access
- / Quick change between innovative welding processes (without JOB switching)
- / Favourite buttons for quick selection of frequently used JOBS
- / Network connection with ewm Xnet (via an external gateway)
- / Click wheel oration
- / Energy r unit length calculation thanks to kW display

Technical data – Titan XQ compact

XQ - Process

all in

- / rootArc® / rootArc® puls
- / coldArc® / coldArc® puls
- / forceArc® / forceArc® puls
- / wiredArc / wiredArc puls
- / Standard
- / Impuls
- / Positionweld
- / surPuls

Xnet 2.0 ready



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HP-XQ



LP-XQ






Exrt XQ 2.0



- MIG/MAG inverter welding machine, pulse, with integrated wire feeder
- Perfect MIG/MAG weld seams, even with long welding leads thanks to patented* Rapid Current Control technology (RCC)
- Synergic control with one-knob operation
- All-in – without surcharge
 - With innovative EWM Synergic characteristics rootArc® XQ/rootArc® puls XQ, coldArc® XQ/coldArc® puls XQ, forceArc® XQ/forceArc® puls XQ, wiredArc XQ/wiredArc puls XQ, pulse/surPuls and Positionweld
 - With Synergic characteristics for GMAW standard or pulsed welding for steel/CrNi/aluminium
 - Operation without Synergic for manual setting of welding parameters
 - Suitable for MMA welding, TIG welding and gouging
- 16 individually configurable programs for each welding task (JOB)
- Adjustable start- and end-crater functions
- Infinitely adjustable arc dynamics (choke effect)
- High-precision, powerful EWM eFeed 4-roll drive to reliably feed all solid and flux cored wires
- Energy-saving thanks to high efficiency and the standby function
- Ideally suited for use with long hose packages
- Connection capability for remote control and PM function torch
- Simple, tool-free reversal of the welding polarity
- Earth fault monitoring (protection)
- Splash-proof as per IP23
- Optional network connectivity with the ewm Xnet software via an integrated or external gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to the high-performance centrifugal pump and 8-litre coolant tank
- Free WPQR package for certification up to and including EXC2 as per EN 1090 and for welding unalloyed steels up to and including S355



	Titan XQ puls 350	Titan XQ puls 400
Wire feed speed in m/min.	0.5 m/min.–25 m/min.	
Wire feed speed ipm	19.68 ipm–944.88 ipm	
Mains voltage (tolerances)	3 x 400 V (-25% to +20%) 3 x 460 V (-25% to +15%) 3 x 500 V (-25% to +10%)	
Mains fuse (slow-blow)	3 x 20 A	
On circuit voltage at 3 x 400 V mains voltage	82 V	
Setting range for welding current	5 A–350 A	5 A–400 A
Duty cycle 40 °C	350 A/80%	400 A/60%
	320 A/100%	350 A/80%
	-	320 A/100%
cos φ	0.99	
Efficiency	88%	
Dimensions L x W x H in mm	1,152 x 686 x 976	
Weight	117 kg gas cooled, 131 kg water cooled	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	  	

PM welding torch



- Gas and water-cooled professional welding torches
- Choice between standard torch or function torch
- Ergonomically optimised grip
- Secure hold thanks to rubber inserts in the grip
- The flexible ball joint makes it comfortable to work with, even in difficult spots
- The torch trigger protection prevents the arc being ignited unintentionally

RD3 X function torch with high-grade graphic display:

- **Display and setting of:**
 - Welding current and wire feed speed
 - Program and JOB selection
 - Welding process switching
 - Interferences and error messages
- **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when welding torch is moved

	PM 401 G	PM 451 W
CO2 duty cycle	450 A/35%	500 A/100%
M21 duty cycle	400 A/35%	450 A/100%
M21 pulse duty cycle	260 A/35%	350 A/100%
Wire Ø	0.8 mm–2 mm	0.8 mm–1.6 mm
Cooling	Gas cooled	Water cooled
Connection	Euro torch connector	
Thread, contact tip	M9	
Approvals	CE	

Titan XQ puls compact product configurator instructions

With our product configurator, you can customise your Titan XQ puls how you like.

The following instructions will help you learn to use the configurator and select the configuration you want.

Please note that you can **only** make **one** selection per **section**. Please state the item number for each selected item with your order.

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.
Power source without base assembly			
<input type="radio"/>	Titan XQ 350 puls C	Titan XQ 350 puls compact, including all characteristics and welding processes	
<input type="radio"/>	Titan XQ 400 puls C	Titan XQ 400 puls compact, including all characteristics and welding processes	
Torch cooling			
<input type="radio"/>	OW F06G	Gas cooling	
<input type="radio"/>	OW F06W	Water cooling	
Base assembly/gas cylinder bracket			
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	
<input type="radio"/>	OW F06RS	Wheel kit with narrow gauge without gas cylinder bracket	
<input type="radio"/>	OW F06P	Pallet base	
Control power source			
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	
<input type="radio"/>	OW HP-XQ	HP-XQ	
<input type="radio"/>	OW LP-XQ	LP-XQ	
Mains connection lead			
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	
Mains connection plug			
<input type="radio"/>		Without mains plug	
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	
Interface for automated welding			
<input type="radio"/>		Without additional interface	
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	
Interface for Xnet scan function¹⁾			
<input type="radio"/>		Without additional interface	
<input type="radio"/>	OW 8Pol Scanner ²⁾	8-pole interface for barcode scanner	

Step 1.1: Select the basic version of your machine.

Example configuration selection: Titan XQ 400 puls C

Step 1.2: Select the desired cooling system for your welding torch.

Example configuration selection: Water cooled

Step 1.3: Select the desired wheel kit or pallet.

Example configuration selection: Wheel kit with single cylinder bracket

Step 1.5: Select the desired machine control for your Titan.

Example configuration selection: Expert XQ 2.0 with LAN/Wi-Fi gateway

Step 1.6: Select the length of the mains connection lead.

Example configuration selection: Mains connection lead 5 m

Step 1.7: Select your mains plug.

Example configuration selection: Without mains plug

Step 1.8: Select your optional interface for automated welding.

Example configuration selection: No additional interface

Step 1.9: Select your optional Xnet interface.

Example configuration selection: 8-pole interface for barcode scanner

¹⁾ Only in conjunction with 092-003308-00000 and 092-003309-00000 ²⁾ Contains the option 092-003300 ON SH F06 L (scanner holder, left)

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	
<input type="radio"/>	ON TS F06 R	Torch holder, right	
<input type="radio"/>	ON TS F06 L	Torch holder, left	
<input type="radio"/>	ON SH F06 L	Scanner holder, left	

Step 2: Select one or more of our practical options for self-assembly

Example configuration selection: Ram protection

Configurations – Titan XQ puls compact

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.		
Power source without base assembly					
<input type="radio"/>	Titan XQ 350 puls C	Titan XQ 350 puls compact, including all characteristics and welding processes	090-005608-00000		
<input type="radio"/>	Titan XQ 400 puls C	Titan XQ 400 puls compact, including all characteristics and welding processes	090-005609-00000		
Torch cooling					
<input type="radio"/>	OW F06G	Gas cooling	092-003305-00000		
<input type="radio"/>	OW F06W	Water cooling	092-003303-00000		
Base assembly/gas cylinder bracket					
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000		
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000		
<input type="radio"/>	OW F06RS	Wheel kit with narrow gauge without gas cylinder bracket	092-003318-00000		
<input type="radio"/>	OW F06P	Pallet base	092-003319-00000		
Control power source					
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	092-003307-00000		
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	092-003308-00000		
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	092-003309-00000		
<input type="radio"/>	OW HP-XQ	HP-XQ	092-003522-00000		
<input type="radio"/>	OW LP-XQ	LP-XQ	092-003521-00000		
Mains connection lead					
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000		
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000		
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000		
Mains connection plug					
<input type="radio"/>		Without mains plug			
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000		
Interface for automated welding					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000		
Interface for Xnet scan function ¹⁾					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW 8PoI Scanner ²⁾	8-pole interface for barcode scanner	092-003372-00000		

¹⁾ Only in conjunction with 092-003308-00000 and 092-003309-00000

²⁾ Contains the option 092-003434-00000 ON SH F06 L (scanner holder, left)

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003334-00000		
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003337-00000		
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000		
<input type="radio"/>	ON TS F06 L	Torch holder, left	092-003360-00000		
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000		

Orating concepts – Titan XQ puls decompact

Orating concepts – Exrt XQ 2.0/Xnet



Exrt XQ 2.0 LG with integrated LAN gateway
Exrt XQ 2.0 WLG with integrated LAN/Wi-Fi gateway

Optionally:

Exrt XQ 2.0 LG with integrated LAN gateway / Exrt XQ 2.0 WLG with integrated LAN/Wi-Fi gateway:

- / Most comprehensive orating and setting options
- / Network connection with ewm Xnet
- / Plain text display for welding parameters and functions
- / Quick change between innovative welding processes (without JOB switching)
- / WPQR welding data assistant
- / Calculation of T8/5 cooling time
- / Welding data monitoring
- / JOB favourites list
- / USB interface
- / Xbutton
- / 16 pre-installed languages*
- / USB connection and access authorisation using Xbutton

Exrt XQ 2.0



- / Most comprehensive orating and setting options
- / Plain text display for welding parameters and functions
- / Quick change between innovative welding processes (without JOB switching)
- / WPQR welding data assistant
- / Calculation of T8/5 cooling time
- / Welding data monitoring
- / JOB favourites list
- / USB interface
- / Xbutton
- / 16 pre-installed languages*
- / USB connection and access authorisation using Xbutton

No control in the power source



- / The parameters are set using the control in the wire feeder only

* German, English, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Swedish, Portuguese, Turkish, Romanian, Hungarian

Orating concepts – Drive XQ

EX-XQ 2.0



- / Most comprehensive orating and setting options
- / Plain text display for welding parameters and functions
- / Quick change between innovative welding processes (without JOB switching)
- / WPQR welding data assistant
- / Calculation of T8/5 cooling time
- / Welding data monitoring
- / JOB favourites list
- / USB interface
- / Xbutton
- / 16 pre-installed languages*
- / USB connection and access authorisation using Xbutton

HP-XQ



- / All important setting options with direct access
- / Quick change between innovative welding processes (without JOB switching)
- / Welding sequence parameters: all parameters set using flow chart
- / Click wheel oration
- / Energy r unit length calculation thanks to kW display

LP-XQ



- / All important setting options with direct access
- / Quick change between innovative welding processes (without JOB switching)
- / Click wheel oration
- / Energy r unit length calculation thanks to kW display

Technical data – Titan XQ decompact

XQ - Process **all in**

- / rootArc® / rootArc® puls
- / coldArc® / coldArc® puls
- / forceArc® / forceArc® puls
- / wiredArc / wiredArc puls
- / Standard
- / Impuls
- / Positionweld
- / surPuls

Xnet 2.0 ready



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HP-XQ



LP-XQ






Exrt XQ 2.0 / EX-XQ 2.0



- MIG/MAG inverter welding machine, pulse, with separate wire feeder
- rfect MIG/MAG weld seams, even with long welding leads thanks to patented* Rapid Current Control technology (RCC)
- Synergic control with one-knob oration
- All-in – without surcharge
 - With innovative EWM Synergic characteristics rootArc® XQ/rootArc® puls XQ, coldArc® XQ/coldArc® puls XQ, forceArc® XQ/forceArc® puls XQ, wiredArc XQ/wiredArc puls XQ, pulse/surPuls and Positionweld
 - With Synergic characteristics for GMAW standard or pulsed welding for steel/CrNi/aluminium
 - Oration without Synergic for manual setting of welding parameters
 - Suitable for MMA welding, TIG welding and gouging
- 16 individually configurable programs for each welding task (JOB)
- Adjustable start- and end-crater functions
- Infinitely adjustable arc dynamics (choke effect)
- High-precision, powerful EWM eFeed 4-roll drive to reliably feed all solid and flux cored wires
- Energy-saving thanks to high efficiency and the standby function
- Ideally suited for use with long hose packages
- Connection capability for remote control and PM function torch
- Simple, tool-free reversal of the welding polarity
- Earth fault monitoring (protection)
- Splash-proof as r IP23
- Optional network connectivity with the ewm Xnet software via an integrated or external gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to the high-rfor- performance centrifugal pump and 8-litre coolant tank
- Free WPQR package for certification up to and including EXC2 as r EN 1090 and for welding unalloyed steels up to and including S355



Titan XQ puls	350	400	500	600
Mains voltage (tolerances)		3 x 400 V (-25% to +20%)	3 x 460 V (-25% to +15%)	3 x 500 V (-25% to +10%)
Mains fuse (slow-blow)	3 x 20 A	3 x 25 A	3 x 32 A	
On circuit voltage at 3 x 400 V mains voltage	82 V			
Setting range for welding current	5 A–350 A	5 A–400 A	5 A–500 A	5 A–600 A
Duty cycle 40 °C	350 A/100%	400 A/80%	500 A/80%	600 A/40%
	-	-	-	550 A/60%
	-	370 A/100%	470 A/100%	470 A/100%
cos φ	0.99			
Efficiency	88%			
Dimensions L x W x H in mm	1,152 x 686 x 976			
Weight	114 kg gas cooled, 128 kg water cooled			
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	  			

Drive XQ



- MIG/MAG wire feeder for Titan XQ puls
- Portable, optional crane attachment, water cooled, Euro torch connector
- Suitable for wire spool size of up to 300 mm
- Easy transport thanks to low weight and compact design
- Interior lighting
- Stable base construction (continuous cast aluminium) with sliding rails as standard
- Transparent protective cap – welding parameters visible at all times
- Robust electronics in dust-free environment
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-specialist personnel can change hose packages without tools
- eFeed: Innovative 4-roll drive (quadruple meshing)
 - Double ball bearings on axle
 - Fully-automated wire inching until wire comes into contact with the workpiece
 - Tool-free roll change, permanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel

Wire feed speed in m/min.	0.5 m/min.–25 m/min.
Wire feed speed ipm	19.68 ipm–944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder dimensions L x W x H in mm	660 x 280 x 380
Wire feeder weight	13 kg
EMC class	A
Protection class	IP23
Approvals	CE EAC

PM welding torch



- Gas and water-cooled professional welding torches
- Choice between standard torch or function torch
- Ergonomically optimised grip
- Secure hold thanks to rubber inserts in the grip
- The flexible ball joint makes it comfortable to work with, even in difficult spots
- The torch trigger protection prevents the arc being ignited unintentionally

RD3 X function torch with high-grade graphic display:

- **Display and setting of:**
 - Welding current and wire feed speed
 - Program and JOB selection
 - Welding process switching
 - Interferences and error messages
- **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when welding torch is moved

	PM 401 G	PM 451 W	PM 551 W
CO2 duty cycle	450 A/35%	500 A/100%	650 A/100%
M21 duty cycle	400 A/35%	450 A/100%	550 A/100%
M21 pulse duty cycle	260 A/35%	350 A/100%	500 A/100%
Wire Ø	0.8 mm–2 mm	0.8 mm–1.6 mm	0.8 mm–2 mm
Cooling	Gas cooled	Water cooled	
Connection	Euro torch connector		
Thread, contact tip	M9		
Approvals	CE		

Titan XQ puls decompact product configurator instructions

With our product configurator, you can customise your Titan XQ puls how you like.

The following instructions will help you learn to use the configurator and select the configuration you want.

Please note that you can **only** make **one** selection per **section**. Please state the item number for each selected item with your order.

Step 1: Welding machine configuration

Selection	Type	Name	Item no.	PG
Power source without base assembly				
<input type="radio"/>	Titan XQ 350 puls D	Titan XQ 350 puls decompact, including all characteristics and welding processes	090-005560-00000	M1
<input type="radio"/>	Titan XQ 400 puls D	Titan XQ 400 puls decompact, including all characteristics and welding processes	090-005561-00000	M1
<input type="radio"/>	Titan XQ 500 puls D	Titan XQ 500 puls decompact, including all characteristics and welding processes	090-005562-00000	M1
<input type="radio"/>	Titan XQ 600 puls D	Titan XQ 600 puls decompact, including all characteristics and welding processes	090-005563-00000	M1
Torch cooling				
<input type="radio"/>	OW F06G	Gas cooling	092-003305-00000	M1
<input type="radio"/>	OW F06W	Water cooling	092-003306-00000	M1
<input type="radio"/>	OW F06WRF	Water cooling unit with reinforced pump	092-003304-00000	M1
Base assembly/gas cylinder bracket				
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000	M1
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000	M1
<input type="radio"/>	OW F06RS	Wheel kit with narrow gauge without gas cylinder bracket	092-003318-00000	M1
<input type="radio"/>	OW F06P	Pallet base	092-003319-00000	M1
Control power source				
<input type="radio"/>	OW Expert XQ 2.0	Expert XQ 2.0	092-003308-00000	D4
<input type="radio"/>	OW Expert XQ 2.0 LG	Expert XQ 2.0 with LAN gateway	092-003309-00000	D4
<input type="radio"/>	OW Expert XQ 2.0 WLG	Expert XQ 2.0 with LAN/Wi-Fi gateway	092-003306-00000	M1
<input type="radio"/>	OW Cover	No control	092-003306-00000	M1
Mains connection lead				
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000	M1
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000	M1
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000	M1
Mains connection plug				
<input type="radio"/>		Without mains plug	092-008215-00000	M1
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000	M1
Interface for automated welding				
<input type="radio"/>		Without additional interface	092-003312-00000	M1
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000	M1
Interface for Xnet scan function ¹⁾				
<input type="radio"/>		Without additional interface	092-003372-00000	M1
<input type="radio"/>	OW 8Pol Scanner ²⁾	8-pole interface for barcode scanner	092-003372-00000	M1
				Total:

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Type	Name	Item no.	PG
<input type="radio"/>	ON PS F06 1D01	Pivot support for wire feeder	092-003330-00000	M1
<input type="radio"/>	ON PS EXT D01	Turning mandrel extension, for mounting a wire feeder	092-003331-00000	M1
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003337-00000	M1
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003333-00000	M1
<input type="radio"/>	ON HS F06	Mount for long hose packages and welding torches	092-003333-00000	M1
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000	M1
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000	M1

Step 2: Wire feeder configuration

Wire feeder configuration

Please note: one item must be selected for each section!
x = absolutely necessary

Selection	Type	Name	Item no.	PG	
	Wire feeder				Step 2.1: Select the basic version
x	Drive XQ	Drive XQ wire feeder	090-005570-00000	M1	
	Drive XQ control				Step 2.2: Select your control
<input type="radio"/>	OW LP-XQ	LP-XQ control	092-003365-00000	M1	Example configuration selection: HP-XQ
<input type="radio"/>	OW HP-XQ	HP-XQ control	092-003366-00000	M1	
<input type="radio"/>	OW Expert XQ 2.0	Expert XQ 2.0 control	092-003367-00000	M1	
	Gas control				Step 2.3: Select your optional gas control
<input type="radio"/>	OW NO DGC D01	No gas control			Example configuration selection: Electronic gas flow control
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000	M1	
	Electrode holder connection socket options				Step 2.4: Select your optional electrode holder socket
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket			Example configuration selection: No further options
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000	M1	
	Wire spool options				Step 2.5: Select your options for the wire spool
<input type="radio"/>	OW NWO D01	No wire spool option			Example configuration selection: No further options
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000	M1	
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000	M1	
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000	M1	
				Total:	

Drive XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Type	Name	Item no.	PG	
<input type="radio"/>	ON FLOW METER	Analogue gas flow rate adjustment with gas flow meter option	092-003374-00000	M1	
<input type="radio"/>	ON TS D01/D02	Torch holder	092-002836-00000	M1	
<input type="radio"/>	ON WAK D01	Wheel assembly kit	092-002844-00000	M1	Step 2.9: Select one or more of our practical options for self-assembly
<input type="radio"/>	ON RFAK D01	Rubber feet	092-002845-00000	M1	
<input type="radio"/>	ON GK D01	Metal runners	092-003030-00000	M1	Example configuration selection: Crane suspension and rubber feet
<input type="radio"/>	ON CMF D01	Crane suspension	092-002833-00000	M1	
<input type="radio"/>	ON TCC D01	Set comprised of crane suspension bracket and protective plate, for using the wire feeder in a lateral position	092-002835-00000	M1	
<input type="radio"/>	ON CC D01	Transparent cover cap for protection of device control	092-002834-00000	M1	
<input type="radio"/>	ON CONNECTOR D01/D02	Connection for wire feeding from drum	092-002842-00000	M1	

Configure once – re-order at any time using the project number

Once you place your order, a **project number** is issued which you will then find on your order confirmation and on your invoice. You can re-order the selected configuration at any time by indicating this **project number**. This will save you time as you no longer have to list all individual items again when re-ordering the same configuration. Just quickly and easily re-order the ready-configured Titan XQ pulps by quoting the project number.



Titan XQ puls configuration with one wire feeder

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.		
Power source without base assembly					
<input type="radio"/>	Titan XQ 350 puls D	Titan XQ 350 puls decompact, including all characteristics and welding processes	090-005560-00000		
<input type="radio"/>	Titan XQ 400 puls D	Titan XQ 400 puls decompact, including all characteristics and welding processes	090-005561-00000		
<input type="radio"/>	Titan XQ 500 puls D	Titan XQ 500 puls decompact, including all characteristics and welding processes	090-005562-00000		
<input type="radio"/>	Titan XQ 600 puls D	Titan XQ 600 puls decompact, including all characteristics and welding processes	090-005563-00000		
Torch cooling					
<input type="radio"/>	OW F06G	Gas cooling	092-003305-00000		
<input type="radio"/>	OW F06W	Water cooling	092-003303-00000		
<input type="radio"/>	OW F06WRF	Water cooling unit with reinforced pump	092-003304-00000		
Base assembly/gas cylinder bracket					
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000		
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000		
<input type="radio"/>	OW F06RS	Wheel kit with narrow gauge without gas cylinder bracket	092-003318-00000		
<input type="radio"/>	OW F06P	Pallet base	092-003319-00000		
Control power source					
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	092-003307-00000		
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	092-003308-00000		
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	092-003309-00000		
<input type="radio"/>	OW Cover	No control	092-003306-00000		
Mains connection lead					
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000		
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000		
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000		
Mains connection plug					
<input type="radio"/>		Without mains plug			
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000		
Interface for automated welding					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000		
Interface for Xnet scan function ¹⁾					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW 8Pol Scanner ²⁾	8-pole interface for barcode scanner	092-003372-00000		
				Total:	

¹⁾ Only in conjunction with 092-003308-00000 and 092-003309-00000²⁾ Contains the option 092-003434-00000 ON SH F06 L (scanner holder, left)

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON PS F06 1D01	Pivot support for wire feeder	092-003330-00000		
<input type="radio"/>	ON PS EXT D01	Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	092-002871-00000		
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003334-00000		
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003337-00000		
<input type="radio"/>	ON HS F06	Mount for long hose packages and welding torches	092-003333-00000		
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000		
<input type="radio"/>	ON TS F06 L	Torch holder, left	092-003360-00000		
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000		

■ Wire feeder configuration

Please note: one item must be selected for each section!

x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ	Drive XQ wire feeder	090-005570-00000		
	Drive XQ control				
<input type="radio"/>	OW LP-XQ	LP-XQ control	092-003365-00000		
<input type="radio"/>	OW HP-XQ	HP-XQ control	092-003366-00000		
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0 control	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Drive XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON FLOW METER	Analogue gas flow rate adjustment with gas flow meter option	092-003374-00000		
<input type="radio"/>	ON TS D01/D02	Torch holder	092-002836-00000		
<input type="radio"/>	ON WAK D01	Wheel assembly kit	092-002844-00000		
<input type="radio"/>	ON RFAK D01	Rubber feet	092-002845-00000		
<input type="radio"/>	ON GK D01	Metal runners	092-003030-00000		
<input type="radio"/>	ON CMF D01	Crane susnsion	092-002833-00000		
<input type="radio"/>	ON TCC D01	Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	092-002835-00000		
<input type="radio"/>	ON CC D01	Transparent cover cap for protection of device control	092-002834-00000		
<input type="radio"/>	ON CONNECTOR D01/D02	Connection for wire feeding from drum	092-002842-00000		

■ Intermediate hose package and accessories see Page 74

MIG/MAG welding machines – Titan XQ puls

Titan XQ puls configuration with two wire feeders

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.		
Power source without base assembly					
<input type="radio"/>	Titan XQ 350 puls D	Titan XQ 350 puls decompact, including all characteristics and welding processes	090-005560-00000		
<input type="radio"/>	Titan XQ 400 puls D	Titan XQ 400 puls decompact, including all characteristics and welding processes	090-005561-00000		
<input type="radio"/>	Titan XQ 500 puls D	Titan XQ 500 puls decompact, including all characteristics and welding processes	090-005562-00000		
<input type="radio"/>	Titan XQ 600 puls D	Titan XQ 600 puls decompact, including all characteristics and welding processes	090-005563-00000		
Torch cooling					
<input checked="" type="checkbox"/>	OW F06WRF	Water cooling unit with reinforced pump	092-003304-00000		
Required accessories for Titan XQ puls ¹⁾					
<input checked="" type="checkbox"/>	OW 2 DV	Conversion kit for two wire feeders	092-003313-00000		
Base assembly/gas cylinder bracket					
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000		
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000		
<input type="radio"/>	OW F06RS 2DV	Wheel kit with narrow gauge for two wire feeders, without gas cylinder bracket	092-003761-00000		
<input type="radio"/>	OW F06P 2DV	Pallet base for two wire feeders*	092-003760-00000		
Control power source					
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	092-003307-00000		
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	092-003308-00000		
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	092-003309-00000		
<input type="radio"/>	OW Cover	No control	092-003306-00000		
Mains connection lead					
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000		
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000		
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000		
Mains connection plug					
<input type="radio"/>		Without mains plug			
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000		
Interface for automated welding					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000		
Interface for Xnet scan function ²⁾					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW 8Pol Scanner ³⁾	8-pole interface for barcode scanner	092-003372-00000		
				Total:	

¹⁾ If both wire feeders are to be installed on the welding machine, the "pivot support for two wire feeders" option (092-003331-00000) should be ordered

²⁾ Only in connection with 092-003308-00000 and 092-003309-00000

³⁾ Contains the option 092-003434-00000 ON SH F06 L (scanner holder, left)

■ Titan XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON PS F06 2D01	Pivot support for two wire feeders ²⁾	092-003331-00000		
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003334-00000		
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003337-00000		
<input type="radio"/>	ON HS F06	Mount for long hose packages and welding torches	092-003333-00000		
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000		
<input type="radio"/>	ON TS F06 L	Torch holder, left	092-003360-00000		
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000		

²⁾ Absolutely necessary if both wire feeders are to be installed on the welding machine

■ Configuration of wire feeder 1

Please note: one item must be selected for each section! x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ	Drive XQ wire feeder	090-005570-00000		
	Drive XQ control				
<input type="radio"/>	OW LP-XQ	LP-XQ control	092-003365-00000		
<input type="radio"/>	OW HP-XQ	HP-XQ control	092-003366-00000		
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0 control	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Configuration of wire feeder 2

Please note: one item must be selected for each section! x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ	Drive XQ wire feeder	090-005570-00000		
	Drive XQ control				
<input type="radio"/>	OW LP-XQ	LP-XQ control	092-003365-00000		
<input type="radio"/>	OW HP-XQ	HP-XQ control	092-003366-00000		
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0 control	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Drive XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection 1	Selection 2	Ty	Name	Item no.		
<input type="radio"/>	<input type="radio"/>	ON FLOW METER	Analogue gas flow rate adjustment with gas flow meter option	092-003374-00000		
<input type="radio"/>	<input type="radio"/>	ON TS D01/D02	Torch holder	092-002836-00000		
<input type="radio"/>	<input type="radio"/>	ON WAK D01	Wheel assembly kit	092-002844-00000		
<input type="radio"/>	<input type="radio"/>	ON RFAK D01	Rubber feet	092-002845-00000		
<input type="radio"/>	<input type="radio"/>	ON GK D01	Metal runners	092-003030-00000		
<input type="radio"/>	<input type="radio"/>	ON CMF D01	Crane susnsion	092-002833-00000		
<input type="radio"/>	<input type="radio"/>	ON TCC D01	Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	092-002835-00000		
<input type="radio"/>	<input type="radio"/>	ON CC D01	Transparent cover cap for protection of device control	092-002834-00000		
<input type="radio"/>	<input type="radio"/>	ON CONNECTOR D01/D02	Connection for wire feeding from drum	092-002842-00000		

■ Intermediate hose package and accessories see Page 74

Technical data Titan XQ AC puls

XQ - Process

all in

- / acArc puls
- / rootArc® / rootArc® puls
- / coldArc® / coldArc® puls
- / forceArc® / forceArc® puls
- / wiredArc / wiredArc puls
- / Standard
- / Impuls
- / Positionweld
- / surPuls

Xnet 2.0 ready



Controls	Page	58
Wire feed rolls	Page	264
Remote controls	Page	84
Welding torches	Page	279
Options/accessories	Page	76

Exrt XQ 2.0 / EX-XQ 2.0



- MIG/MAG inverter welding machine, pulse, with separate wire feeder
- All AC and established DC-MIG/MAG processes are included in the machine at no extra charge
- Thanks to the acArc puls XQ you can create clean weld seams on even the thinnest metal sheets without traces of smoulder, even when using AlMg alloys
- Perfect MIG/MAG weld seams, even with long welding leads thanks to patented* Rapid Current Control technology (RCC)
- Synergic control with one-knob operation
- All-in – without surcharge
 - With innovative EWM Synergic characteristics acArc puls XQ, rootArc® XQ/rootArc® puls XQ, coldArc® XQ/coldArc® puls XQ, forceArc® XQ/forceArc® puls XQ, wiredArc XQ/wiredArc puls XQ, pulse/surPuls and Positionweld
 - With Synergic characteristics for GMAW standard or pulsed welding for steel/CrNi/aluminium
 - Operation without Synergic for manual setting of welding parameters
 - Suitable for MMA welding, TIG welding and gouging
- 16 individually configurable programs for each welding task (JOB)
- Adjustable start- and end-crater functions
- Infinitely adjustable arc dynamics (choke effect)
- High-precision, powerful EWM eFeed 4-roll drive to reliably feed all solid and flux cored wires
- Energy-saving thanks to high efficiency and the standby function
- Ideally suited for use with long hose packages
- Connection capability for remote control and PM function torch
- Simple, tool-free reversal of the welding polarity
- Earth fault monitoring (protection)
- Splash-proof as r IP23
- Optional network connectivity with the ewm Xnet software via an integrated or external gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to the high-performance centrifugal pump and 8-litre coolant tank
- Free WPQR package for certification up to and including EXC2 as r EN 1090 and for welding unalloyed steels up to and including S355



Titan XQ AC puls	400
Mains voltage (tolerances)	3 x 400 V (-25% to +20%) to 3 x 500 V (-25% to +10%)
Mains fuse (slow-blow)	3 x 25 A
On circuit voltage at 3 x 400 V mains voltage	82 V
Setting range for welding current	5 A–400 A
Duty cycle 40 °C	400 A/80%
	370 A/100%
cos φ	0.99
Efficiency	88%
Dimensions L x W x H in mm	1,152 x 686 x 976
Weight	128 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	

Drive XQ AC



- MIG/MAG wire feeder for Titan XQ AC puls with EX-XQ 2.0 control
- Not compatible with other Titan XQ puls welding machines
- Equipped with 1.2 mm rolls for aluminium
- Portable, optional crane attachment, water cooled, Euro torch connector
- Suitable for wire spool size of up to 300 mm
- Easy transport thanks to low weight and compact design
- Interior lighting
- Stable base construction (continuous cast aluminium) with sliding rails as standard
- Transparent protective cap – welding parameters visible at all times
- Robust electronics in dust-free environment
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-specialist personnel can change hose packages without tools
- eFeed: Innovative 4-roll drive (quadruple meshing)
 - Double ball bearings on axle
 - Fully-automated wire inching until wire comes into contact with the workpiece
 - Tool-free roll change, permanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material

Wire feed speed in m/min.	0.5 m/min.–25 m/min.
Wire feed speed ipm	19.68 ipm–944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder dimensions L x W x H in mm	660 x 280 x 380
Wire feeder weight	13 kg
EMC class	A
Protection class	IP23
Approvals	CE EAC

PM 551 W welding torches



- The best welding torch for welding aluminium:
- Comes already completely equipped ex works, no need for retrofitting for aluminium welding. Available in 3 m and 4 m lengths, both for a wire diameter of Ø 1.0 mm or Ø 1.2 mm.
- Standard welding torches come equipped with the following components:
 - Gas nozzle (Ø 15 mm)
 - Contact tip with forced contact (Ø 1.0 mm or 1.2 mm)
 - PA liner incl. brass liner (Ø 1.0 mm or Ø 1.2 mm, both in 3 m or 4 m)
- The PM 551 W Alu welding torch guarantees perfect, consistent results when welding aluminium:
- The conical gas nozzle guarantees targeted gas flow, allowing for spatter-free welding results.
- The forced contact tip ensures consistent contact of the wire in the contact tip, guaranteeing high arc stability and a significantly longer service life.
- The PA liner guarantees even, reduced-friction wire feeding.

	PM 551 W RD 3X
CO2 duty cycle	650 A/100%
M21 duty cycle	550 A/100%
M21 pulse duty cycle	500 A/100%
Wire Ø	1.0 mm–1.2 mm
Cooling	Water cooled
Connection	Euro torch connector
Thread, contact tip	M9
Approvals	CE

MIG/MAG welding machines – Titan XQ puls

Configurations – Titan XQ AC puls

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.		
Power source without base assembly					
x	Titan XQ 400 AC puls D	Titan XQ 400 AC puls decompact, including all characteristics and welding processes	090-005607-00000		
Torch cooling					
<input type="radio"/>	OW F06W	Water cooling	092-003303-00000		
<input type="radio"/>	OW F06WRF	Water cooling unit with reinforced pump	092-003304-00000		
Base assembly/gas cylinder bracket					
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000		
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000		
<input type="radio"/>	OW F06RS 2DV	Wheel kit with narrow gauge for two wire feeders, without gas cylinder bracket	092-003761-00000		
<input type="radio"/>	OW F06P 2DV	Pallet base for two wire feeders*	092-003760-00000		
Control power source					
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	092-003307-00000		
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	092-003308-00000		
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	092-003309-00000		
<input type="radio"/>	OW Cover	No control	092-003306-00000		
Mains connection lead					
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000		
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000		
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000		
Mains connection plug					
<input type="radio"/>		Without mains plug			
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000		
Interface for automated welding					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000		
Interface for Xnet scan function ¹⁾					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW 8Pol Scanner ²⁾	8-pole interface for barcode scanner	092-003372-00000		
				Total:	

¹⁾ Only in conjunction with 092-003308-00000 and 092-003309-00000

²⁾ Contains the option 092-003434-00000 ON SH F06 L (scanner holder, left)

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON PS F06 1D01	Pivot support for wire feeder	092-003330-00000		
<input type="radio"/>	ON PS EXT D01	Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	092-002871-00000		
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003334-00000		
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003337-00000		
<input type="radio"/>	ON HS F06	Mount for long hose packages and welding torches	092-003333-00000		
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000		
<input type="radio"/>	ON TS F06 L	Torch holder, left	092-003360-00000		
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000		

■ Wire feeder configuration

Please note: one item must be selected for each section!

x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ AC	Drive XQ wire feeder	090-005613-00000		
	Control Drive XQ AC				
x	OW Exrt XQ 2.0	Control Exrt XQ 2.0	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Drive XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON FLOW METER	Analogue gas flow rate adjustment with gas flow meter option	092-003374-00000		
<input type="radio"/>	ON TS D01/D02	Torch holder	092-002836-00000		
<input type="radio"/>	ON WAK D01	Wheel assembly kit	092-002844-00000		
<input type="radio"/>	ON RFAK D01	Rubber feet	092-002845-00000		
<input type="radio"/>	ON GK D01	Metal runners	092-003030-00000		
<input type="radio"/>	ON CMF D01	Crane susnsion	092-002833-00000		
<input type="radio"/>	ON TCC D01	Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	092-002835-00000		
<input type="radio"/>	ON CC D01	Transparent cover cap for protection of device control	092-002834-00000		
<input type="radio"/>	ON CONNECTOR D01/D02	Connection for wire feeding from drum	092-002842-00000		

■ Intermediate hose package, accessories and welding torches selection see Page 74

Configurations – Titan XQ AC puls with two wire feeders

Please note: one item must be selected for each section!

Selection	Ty	Name	Item no.		
Power source without base assembly					
x	Titan XQ 400 AC puls D	Titan XQ 400 AC puls decompact, including all characteristics and welding processes	090-005607-00000		
Torch cooling					
x	OW F06WRF	Water cooling unit with reinforced pump	092-003304-00000		
Required accessories for Titan XQ puls ¹⁾					
x	OW 2 DV	Conversion kit for two wire feeders	092-003313-00000		
Base assembly/gas cylinder bracket					
<input type="radio"/>	OW F06R1	Wheel kit with single cylinder bracket	092-003316-00000		
<input type="radio"/>	OW F06R2	Wheel kit with double cylinder bracket	092-003317-00000		
<input type="radio"/>	OW F06RS	Wheel kit with narrow gauge without gas cylinder bracket	092-003318-00000		
<input type="radio"/>	OW F06P	Pallet base	092-003319-00000		
Control power source					
<input type="radio"/>	OW Exrt XQ 2.0	Exrt XQ 2.0	092-003307-00000		
<input type="radio"/>	OW Exrt XQ 2.0 LG	Exrt XQ 2.0 with LAN gateway	092-003308-00000		
<input type="radio"/>	OW Exrt XQ 2.0 WLG	Exrt XQ 2.0 with LAN/Wi-Fi gateway	092-003309-00000		
<input type="radio"/>	OW Cover	No control	092-003306-00000		
Mains connection lead					
<input type="radio"/>	OW MCord5m	Mains connection lead, 5 m	092-003349-00000		
<input type="radio"/>	OW MCord10m	Mains connection lead, 10 m	092-003350-00000		
<input type="radio"/>	OW MCord15m	Mains connection lead, 15 m	092-003351-00000		
Mains connection plug					
<input type="radio"/>		Without mains plug			
<input type="radio"/>	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000		
Interface for automated welding					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW AIF F06	19-pole interface for automated welding	092-003312-00000		
Interface for Xnet scan function ²⁾					
<input type="radio"/>		Without additional interface			
<input type="radio"/>	OW 8Pol Scanner ³⁾	8-pole interface for barcode scanner	092-003372-00000		
				Total:	

¹⁾ If both wire feeders are to be installed on the welding machine, the „pivot support for two wire feeders“ option (092-003331-00000) should be ordered

²⁾ Only in connection with 092-003308-00000 and 092-003309-00000

³⁾ Contains the option 092-003434-00000 ON SH F06 L (scanner holder, left)

■ Titan XQ puls options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON PS F06 1D01	Pivot support for wire feeder	092-003330-00000		
<input type="radio"/>	ON PS EXT D01	Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	092-002871-00000		
<input type="radio"/>	ON SHOCK PROTECT	Ram protection	092-003334-00000		
<input type="radio"/>	ON FILTER	Dirt filter for air inlet	092-003337-00000		
<input type="radio"/>	ON HS F06	Mount for long hose packages and welding torches	092-003333-00000		
<input type="radio"/>	ON TS F06 R	Torch holder, right	092-003335-00000		
<input type="radio"/>	ON TS F06 L	Torch holder, left	092-003360-00000		
<input type="radio"/>	ON SH F06 L	Scanner holder, left	092-003434-00000		

■ Wire feeder configuration 1

Please note: one item must be selected for each section! x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ AC	Drive XQ wire feeder	090-005613-00000		
	Control Drive XQ AC				
x	OW Exrt XQ 2.0	Control Exrt XQ 2.0	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Wire feeder configuration 2

Please note: one item must be selected for each section! x = absolutely necessary

Selection	Ty	Name	Item no.		
	Wire feeder				
x	Drive XQ AC	Drive XQ wire feeder	090-005613-00000		
	Control Drive XQ AC				
x	OW Exrt XQ 2.0	Control Exrt XQ 2.0	092-003367-00000		
	Gas control				
<input type="radio"/>	OW NO DGC D01	No gas control	092-003389-00000		
<input type="radio"/>	OW DGC D01	Electronic gas flow control option	092-003373-00000		
	Electrode holder connection socket options				
<input type="radio"/>	OW NMMA D01	No electrode holder connection socket	092-003421-00000		
<input type="radio"/>	OW MMA D01	Electrode holder connection socket option	092-003376-00000		
	Wire spool options				
<input type="radio"/>	OW NWO D01	No wire spool option	092-003390-00000		
<input type="radio"/>	OW WHS D01	Wire spool heater option	092-003375-00000		
<input type="radio"/>	OW WRS D01	Wire reserve sensor option	092-003377-00000		
<input type="radio"/>	OW WRS/WHs D01	Wire reserve sensor and wire spool heater option	092-003416-00000		
				Total:	

■ Drive XQ options for self-assembly/retrofitting

Please note: multiple options can be ordered!

Selection	Ty	Name	Item no.		
<input type="radio"/>	ON FLOW METER	Analogue gas flow rate adjustment with gas flow meter option	092-003374-00000		
<input type="radio"/>	ON TS D01/D02	Torch holder	092-002836-00000		
<input type="radio"/>	ON WAK D01	Wheel assembly kit	092-002844-00000		
<input type="radio"/>	ON RFAK D01	Rubber feet	092-002845-00000		
<input type="radio"/>	ON GK D01	Metal runners	092-003030-00000		
<input type="radio"/>	ON CMF D01	Crane susnsion	092-002833-00000		
<input type="radio"/>	ON TCC D01	Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	092-002835-00000		
<input type="radio"/>	ON CC D01	Transparent cover cap for protection of device control	092-002834-00000		
<input type="radio"/>	ON CONNECTOR D01/D02	Connection for wire feeding from drum	092-002842-00000		

■ Intermediate hose package, accessories and welding torches selection see Page 74

Intermediate hose package and accessories selection

■ Titan XQ puls 350 / 400 gas cooled

Selection	Ty	Length in m	Cross-section in mm ²	Duty cycle	Item no.		
<input type="radio"/>	Intermediate hose package, gas cooled, 14-pole	1,8	70	400A/80%	092-003290-00001		
<input type="radio"/>		5			092-003290-00005		
<input type="radio"/>		10			092-003290-00010		
<input type="radio"/>		15			092-003290-00015		
<input type="radio"/>		20			092-003290-00020		
<input type="radio"/>		30			092-003290-00030		
<input type="radio"/>	Workpiece lead with clamp	4	70	450A/60%	092-000013-00000		
<input type="radio"/>	Pressure regulator with manometer	-	-	-	394-002910-00030		
<input type="radio"/>	Maxex pressure regulator Necessary when using the electronic gas flow control	-	-	-	096-000000-00000		

■ Titan XQ puls 500 / 600 gas cooled

Selection	Ty	Length in m	Cross-section in mm ²	Duty cycle	Item no.		
<input type="radio"/>	Intermediate hose package, water cooled, 14-pole	1,8	95	500A/80%	092-003291-00001		
<input type="radio"/>		5			092-003291-00005		
<input type="radio"/>		10			092-003291-00010		
<input type="radio"/>		15			092-003291-00015		
<input type="radio"/>		20			092-003291-00020		
<input type="radio"/>		30			092-003291-00030		
<input type="radio"/>		40			092-003291-00040		
<input type="radio"/>	Workpiece lead with clamp	4	95	550A/60%	092-000171-00000		
<input type="radio"/>	Pressure regulator with manometer	-	-	-	394-002910-00030		
<input type="radio"/>	Maxex pressure regulator Necessary when using the electronic gas flow control	-	-	-	096-000000-00000		

■ Titan XQ puls 350 / 400 water cooled

Selection	Ty	Length in m	Cross-section in mm ²	Duty cycle	Item no.		
<input type="radio"/>	Intermediate hose package, water cooled, 14-pole	1,8	70	400A/80%	092-003288-00001		
<input type="radio"/>		5			092-003288-00005		
<input type="radio"/>		10			092-003288-00010		
<input type="radio"/>		15			092-003288-00015		
<input type="radio"/>		20			092-003288-00020		
<input type="radio"/>		30			092-003288-00030		
<input type="radio"/>	Workpiece lead with clamp	4	70	450A/60%	092-000013-00000		
<input type="radio"/>	Pressure regulator with manometer	-	-	-	394-002910-00030		
<input type="radio"/>	Maxex pressure regulator Necessary when using the electronic gas flow control	-	-	-	096-000000-00000		
<input type="radio"/>	Coolant (-10 °C), 5 l	-	-	-	094-000530-00005		

■ Titan XQ puls 500 / 600 water cooled

Selection	Ty	Length in m	Cross-section in mm ²	Duty cycle	Item no.		
<input type="radio"/>	Intermediate hose package, water cooled, 14-pole	1,8	95	500A/80%	092-003289-00001		
<input type="radio"/>		5			092-003289-00005		
<input type="radio"/>		10			092-003289-00010		
<input type="radio"/>		15			092-003289-00015		
<input type="radio"/>		20			092-003289-00020		
<input type="radio"/>		30			092-003289-00030		
<input type="radio"/>		40			092-003289-00040		
<input type="radio"/>	Workpiece lead with clamp	4	95	550A/60%	092-000171-00000		
<input type="radio"/>	Pressure regulator with manometer	-	-	-	394-002910-00030		
<input type="radio"/>	Maxex pressure regulator Necessary when using the electronic gas flow control	-	-	-	096-000000-00000		
<input type="radio"/>	Coolant (-10 °C), 5 l	-	-	-	094-000530-00005		

Welding torch selection

■ PM 551 W RD3 X Alu welding torch selection

Selection	Name	Ø wire ex works	Hose package length	Item no.		
<input type="radio"/>	MIG/MAG function torch with OLED graphic display, water cooled, X technology	1.0 mm	3 m	094-700005-40600		
<input type="radio"/>			4 m	094-700005-40604		
<input type="radio"/>		1.2 mm	3 m	094-700005-50600		
<input type="radio"/>			4 m	094-700005-50604		

■ PM 551 W 2U/D X Alu welding torch selection

Selection	Name	Ø wire ex works	Hose package length	Item no.		
<input type="radio"/>	MIG/MAG function torch, water cooled, X technology	1.0 mm	3 m	094-700005-40800		
<input type="radio"/>			4 m	094-700005-40804		
<input type="radio"/>		1.2 mm	3 m	094-700005-50800		
<input type="radio"/>			4 m	094-700005-50804		

■ PM 551 W Alu welding torch selection

Selection	Name	Ø wire ex works	Hose package length	Item no.		
<input type="radio"/>	MIG/MAG welding torch	1.0 mm	3 m	094-700005-40000		
<input type="radio"/>			4 m	094-700005-40004		
<input type="radio"/>		1.2 mm	3 m	094-700005-50000		
<input type="radio"/>			4 m	094-700005-50004		

■ Forced contact tip

Selection	Name	Ø wire ex works	Item no.	PU		
				Pc..		Pc.
<input type="radio"/>	Forced contact tip	1,0 mm	094-017007-00001			
<input type="radio"/>		1,2 mm	094-016159-00001			

Titan XQ puls options

ON 2DV



- Holder for two wire feeders
- Effortlessly change between two welding applications with two wire feeders on one machine, e.g. between welding solid wire and flux cored wire
- Easier wire spool change – wire feeders can be pulled apart

Designation	PU stk	Item no.
Pivot support for two wire feeders	1	092-003331-00000

ON DK 1DV



- Wire feeder pivots 360° on the welding machine
- Increased working radius thanks to rotatability
- Wire feeder can be mounted and removed without tools

Designation	PU stk	Item no.
Pivot support for wire feeder	1	092-003330-00000

On Filter



- Dust filter for the welding machine and cooling unit
- Protects welding machine from external contamination
- Can be assembled and disassembled without tools for cleaning
- Permanently secured fasteners
- Easy to clean

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-003337-00000

ON HS XQ



- Holder for holding long hose packages (up to 40 m), accessories and welding torch
- Can be used with pivot support for one/two wire feeders
- Suitable for decompact Titan XQ puls welding machines

Designation	PU stk	Item no.
Mount for hose packages and welding torch	1	092-003333-00000

ON Shock Protect



- Ram protection – for daily workshop transportation
- Protection for the welding machine and connected plug to prevent damage from the front

Designation	PU stk	Item no.
Ram protection	1	092-003334-00000

ON TH XQ



- Torch holder – secure place protects against damage
- For MIG/MAG and TIG welding torches
- Can be simply screwed to the handle of the system
- Individual versions for right-handed and left-handed users

Designation	Version	PU stk	Item no.
Torch holder, right	Right	1	092-003335-00000
Torch holder, left	Left	1	092-003360-00000

Barcode scanner



- Barcode scanner
- For component management in conjunction with Xnet 2.0 software
- Optional OW 8-pole scanner (092-003372-00000) required on the machine side

Designation	PU stk	Item no.
Barcode scanner	1	090-008823-00000

ON SH F06 L



- Secure holder and protection for the barcode scanner

Designation	PU stk	Item no.
Scanner holder, left	1	092-003434-00000

ON CS F06



- Crane frame – moves the crane lifting point from the bottom to the top
- Also serves as a holder for hose packages and welding torches

Designation	PU stk	Item no.
Crane frame	1	092-003485-00000

Titan XQ puls system components - Wire feed units

Options • Drive XQ

ON Flowmeter



- Flow meter for manual shielding gas flow setting
- Precise setting and checking of the gas quantity at the welding site
- Extremely advantageous with long hose packages, e.g. for shipbuilding and steel construction

Designation	PU stk	Item no.
Analogue gas flow rate adjustment with gas flow meter option	1	092-003374-00000

ON TS D01/D02



- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Designation	PU stk	Item no.
Torch holder for drive XQ, drive 4X, drive 4 Basic and drive 4X IC	1	092-002836-00000

ON WAK D01



- Wheel kit
- Ensures limitless mobility
- Large rolls (Ø 125 mm) for optimal freedom of movement
- One roll with locking brake

Designation	PU stk	Item no.
Wheel assembly kit	1	092-002844-00000

ON PS EXT D01



- Turning mandrel extension – allows a wire feeder with a wheel kit to be attached to the wire feeder pivot support
- Fast assembly – the extension is simply inserted onto the mandrel of the pivot support and secured
- A wire feeder pivot support is absolutely required for use
- Cannot be used with gas-cooled, mobile machines and Trolley 55-5/55-6!

Designation	PU stk	Item no.
Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	1	092-002871-00000

ON RFAK drive



- Rubber feet to replace sliding rails

Designation	PU stk	Item no.
Rubber feet	1	092-002845-00000

ON GK drive



- Stainless steel runners

Designation	PU stk	Item no.
Stainless steel runners	1	092-003030-00000

ON CMF D01



- Crane suspension for safe and easy transportation
- Maximum mobility even during suspension operations

Designation	PU stk	Item no.
Crane suspension	1	092-002833-00000

ON TCC D01



- 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

Designation	PU stk	Item no.
Set comprised of crane suspension bracket and protective plate, for using the wire feeder in a lateral position	1	092-002835-00000

Transparent cover lens



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Operation still possible thanks to recesses for the rotary knobs

Designation	Version	PU stk	Item no.
Transparent cover lens for wire feed controls	for LP-XQ control	1	092-003788-00000
	for HP-XQ/Taurus Steel puls/Taurus Steel Synergic/Taurus Basic S	1	092-003478-00000
	for EX XQ 2.0/EX 2.0 control	1	092-003480-00000

ON CC D01



- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Designation	PU stk	Item no.
Transparent cover cap for protecting the control	1	092-002834-00000

Options • Drive XQ

ON CONNECTOR D01/D02



- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Designation	Length m	Version	PU stk	Item no.
Connection for wire feeding from drum	-	-	1	092-002842-00000
Connection for large spool/drum	-	Large spool/drum	1	094-011517-00000
Wire guide	1.8	-	1	094-011515-00004
	3.0		1	094-011515-00000
	4.5		1	094-011515-00001
	8.0		1	094-011515-00002
	12.0		1	094-011515-00003

Intermediate drive • miniDrive

- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- 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
- Hose packages length up to 25 m possible
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m!
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- Connection capability for remote control
- It is not possible to supply the miniDrive ex works with Phoenix 355 TKM, Taurus 355 TKM/TKW and Picomig 355 machines. We are happy to offer you a customised solution. Please contact our Service Department if you are interested in such a solution.

miniDrive WS



- miniDrive with hose package

Wire speed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for gas-cooled torches	10.0	1	090-005262-00110
	15.0	1	090-005262-00115
	20.0	1	090-005262-00120
	25	1	090-005262-00125
miniDrive with hose package for water-cooled torches	10.0	1	090-005262-01110
	15.0	1	090-005262-01115
	20.0	1	090-005262-01120
	25	1	090-005262-01125

miniDrive WS V+A



- miniDrive with hose package for water-cooled torches with volt and ammeter
- Utilisation of function torch with X technology not possible

Wire speed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for water-cooled welding torches with voltmeter and ammeter	10.0	1	090-005396-01110
	15.0	1	090-005396-01115
	20.0	1	090-005396-01120
	25	1	090-005396-01125

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG XQ W 14POL 70



Connection	14-pole
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, water cooled, 14-pole	1.8	1	092-003288-00001
	5.0	1	092-003288-00005
	10.0	1	092-003288-00010
	15.0	1	092-003288-00015
	20.0	1	092-003288-00020
	30	1	092-003288-00030

MIG XQ W 14POL 95



Connection	14-pole
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, water cooled, 14-pole	1.8	1	092-003289-00001
	5.0	1	092-003289-00005
	10.0	1	092-003289-00010
	15.0	1	092-003289-00015
	20.0	1	092-003289-00020
	30	1	092-003289-00030
	40	1	092-003289-00040

Gas cooled

- Gas-cooled intermediate hose package
- 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

MIG XQ G 14POL 70



Connection	14-pole
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas cooled, 14-pole	1.8	1	092-003290-00001
	5.0	1	092-003290-00005
	10.0	1	092-003290-00010
	15.0	1	092-003290-00015
	20.0	1	092-003290-00020
	30	1	092-003290-00030

MIG XQ G 14POL 95



Connection	14-pole
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas cooled, 14-pole	1.0	1	092-003291-00001
	5.0	1	092-003291-00005
	10.0	1	092-003291-00010
	15.0	1	092-003291-00015
	20.0	1	092-003291-00020
	30	1	092-003291-00030
	40	1	092-003291-00040

Remote control • Titan XQ puls

RC XQ Exrt 2.0



- Exrt 2.0 remote control
- Welding current (amp), arc correction (volt) and arc dynamics (soft/hard) directly adjustable using two rotary knobs
- With pre-fitted connection cable
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Simple JOB selection (welding procedure, material, gas, wire dia.) using click wheel
- Easy switching of welding procedures at the press of a button, e.g. from forceArc/forceArc puls to rootArc/rootArc puls or standard/pulse
- Setting of all parameters in program sequence
- Social non-latched and social latched with adjustable start and end crater program
- Administration of access rights for different control operating levels using the Xbutton
- 16 individually configurable programmes for each welding task (JOB)
- Spot welding/tack function (spotArc/spotmatic)
- Save electricity through standby function

Weight	2 kg
Connection	7-pole
Dimensions LxWxH in mm	310 x 230 x 110

Designation	Cable length m	PU stk	Item no.
	2.0	1	090-008824-00002
Remote control for Exrt XQ 2.0 control	5.0	1	090-008824-00005
	10.0	1	090-008824-00010
	15.0	1	090-008824-00015

R10



- Voltage correction from -10 V to +10 V
- Infinitely variable setting of wire-feed speed (0.5–24 m/min)
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Weight	1 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008087-00502

RG10



- 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

Weight	0.7 kg
Cable length	5
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	PU stk	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008108-00000

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
- Cable not supplied in delivery, please order connection cable separately

Weight	2.5 kg
Connection	19-pole
Dimensions LxWxH in mm	330 x 180 x 95

Designation	PU stk	Item no.
Remote control, program switching	1	090-008263-00000

Connection cables



Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

Remote control • Titan XQ puls

Digital 7-pole cable



- Digital 7-pole cable
- Extension for 7-pole remote control with rmanently installed cable
- Connection cable for remote control and gateway without rmanently installed cable

Connection	7-pole
-------------------	--------

Designation	Cable length m	PU stk	Item no.
Digital 7-pole cable	0.5	1	092-000201-00004
	1.0	1	092-000201-00002
	5.0	1	092-000201-00003
	10.0	1	092-000201-00000
	15.0	1	092-000201-00005
	20.0	1	092-000201-00001
	25	1	092-000201-00007

Conversion options • Titan XQ puls

OU F06W Wasserkühler



- Conversion set Titan XQ puls, gas cooled to water cooled

Designation	PU stk	Item no.
Conversion set, water cooler	1	092-003492-00000
Conversion set, water cooler with reinforced pump	1	092-003493-00000

OU F06R1/R2



- Conversion set Titan XQ puls, single cylinder bracket to double cylinder bracket

Designation	PU stk	Item no.
Conversion set, single gas cylinder holder to double gas cylinder holder conversion	1	092-003494-00000

OU Exrt XQ 2.0



- Conversion set for Exrt XQ 2.0 machine control

Designation	PU stk	Item no.
Conversion set, Exrt XQ 2.0	1	092-003495-00000

OU EXRT XQ 2.0 WLG



- Conversion set for Exrt XQ 2.0 machine control with LAN/Wi-Fi gateway including barcode scanner interface

Designation	PU stk	Item no.
Conversion set, Exrt XQ 2.0 with LAN/WiFi Gateway including interface for barcode scanner	1	092-003496-00000

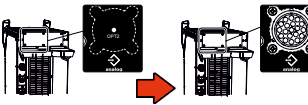
OU 2DV



- Conversion kit for two wire feeders

Designation	PU stk	Item no.
Conversion kit for two wire feeders	1	092-003497-00000

OU AIF F06



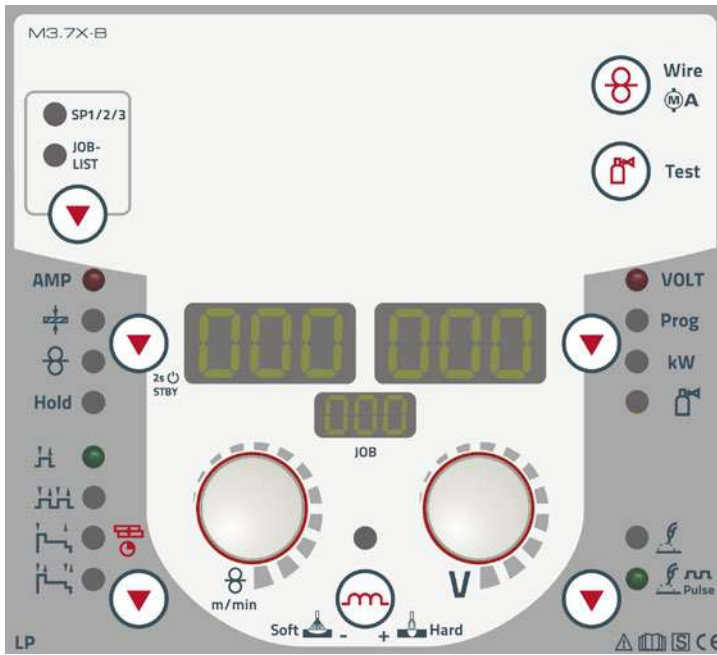
- Conversion set, 19-pole interface for automated welding

Designation	PU stk	Item no.
Conversion set, 19-pin automation interface	1	092-003498-00000

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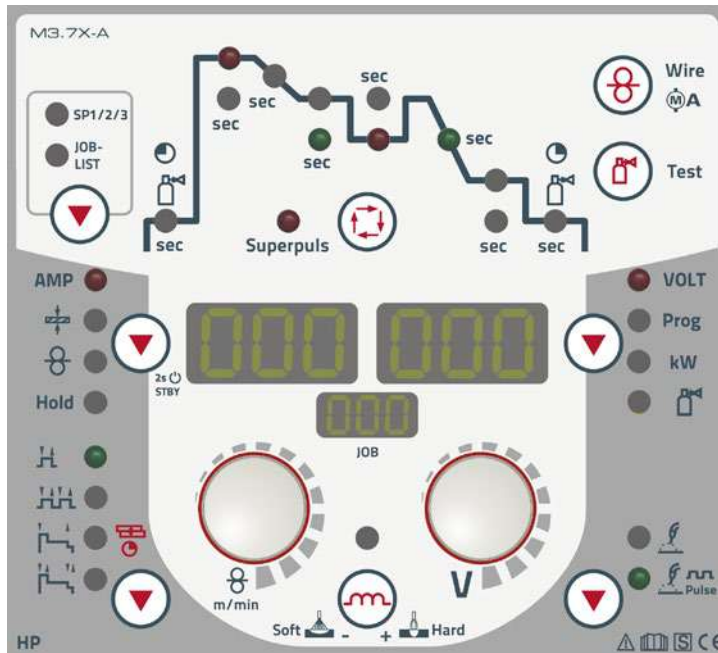
Control description LP



Oration mode	Synergic oration
Welding process	MIG/MAG
	MIG/MAG pulse
	TIG lift arc
	MMA
	forceArc®
	forceArc puls®
	rootArc®
	rootArc puls®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
	Kilowatt indicator
Freely adjustable programs r JOB	16
Number of JOBS	335
MMA functions	Hotstart
	Arcforce
	Antistick

- Synergic one-knob oration: The orating point can be set with a single knob thanks to easy JOB (welding task) preselection
- LP control: All the important setting options with direct access
- Arc length correction
- Adjusting the arc dynamics (choke effect) from soft to hard
- Standby function (save energy at the press of a button)
- Kilowatt display for calculating the energy r unit length
- Effective arc power for calculating the energy r unit length
- Electronic gas setting with control and monitoring of gas quantity (option)

Control description HP



- Synergic one-knob oration: the orating point can be set with a single knob thanks to easy JOB (welding task) preselection, including program sequence
- HP control: All the important setting options with direct access, including welding flowchart for easiest setting of all welding parameters
- Arc length correction
- Adjusting the arc dynamics (choke effect) from soft to hard
- Standby function (save energy at the press of a button)
- Kilowatt display for calculating the energy r unit length
- Effective arc power for calculating the energy r unit length
- Electronic gas setting with control and monitoring of gas quantity (option)

Oration mode	Synergic oration
Welding process	MIG/MAG
	MIG/MAG pulse
	TIG lift arc
	MMA
	forceArc®
	forceArc puls®
	rootArc®
	rootArc puls®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
Freely adjustable programs r JOB	16
Number of JOBS	335
MMA functions	Hotstart
	Arcforce
	Antistick

Control description, Exrt 2.0



Oration mode	Synergic oration
Welding process	MIG/MAG
	MIG/MAG pulse
	TIG lift arc
	MMA
	forceArc®
	forceArc puls®
	rootArc®
	rootArc puls®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
	Kilowatt indicator
Freely adjustable programs r JOB	16
Number of JOBS	335
MMA functions	Hotstart
	Arcforce
	Antistick

- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- USB connection
- Easy switching of welding procedures at the press of a button, e.g. from force-Arc/forceArc puls to rootArc/rootArc puls or standard/pulse
- Setting of all parameters in program sequence
- Administration of access rights for different control orating levels using the Xbutton
- Arc length correction
- Adjusting the arc dynamics (choke effect) from soft to hard
- Standby function (save energy at the press of a button)
- Kilowatt display for calculating the energy r unit length
- Effective arc power for calculating the energy r unit length
- Electronic gas setting with control and monitoring of gas quantity (option)

Phoenix 355 Progress puls MM HP / LP TKM

MULTIMATRIX

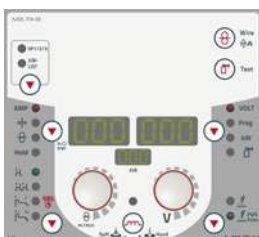
/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



HP



LP



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Wire feed rolls	Page	154
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- Compact inverter welding machine with integrated wire feed mechanism
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- 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

Version	Phoenix 355 puls
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	36 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feed m/min	0.5 m/min - 25 mm
Wire feed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Phoenix 355 Progress puls MM HP / LP TKM

Phoenix 355 puls compact gas cooled

Ty	Designation	PU	Item no.
Phoenix 355 Progress puls HP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, HP control	1	090-005403-00502
Phoenix 355 Progress puls LP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, LP control	1	090-005502-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolly 55-5/Trolly 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 puls compact water cooled

Ty	Designation	PU	Item no.
Phoenix 355 Progress puls HP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, HP control	1	090-005403-00502
Phoenix 355 Progress puls LP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, LP control	1	090-005502-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 355 Exrt 2.0 puls MM TKM

MULTIMATRIX

/rootArc° /rootArc° puls
/forceArc° /forceArc° puls
/Impuls/surPuls



Exrt 2.0



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- Compact inverter welding machine with integrated wire feed mechanism
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- 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



Version	Phoenix 355 Exrt 2.0 puls
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	36.2 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feed m/min	0.5 m/min - 25 m/min
Wire feed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Phoenix 355 Exrt 2.0 puls MM TKM

Phoenix 355 Exrt 2.0 puls compact gas cooled

Ty	Designation	PU	Item no.
Phoenix 355 Exrt 2.0 puls MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Exrt 2.0 control	1	090-005445-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolly 55-5/Trolly 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 Exrt 2.0 puls compact water cooled

Ty	Designation	PU	Item no.
Phoenix 355 Exrt 2.0 puls MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Exrt 2.0 control	1	090-005445-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 355 | 405 | 505 Progress puls MM TDM

MULTIMATRIX

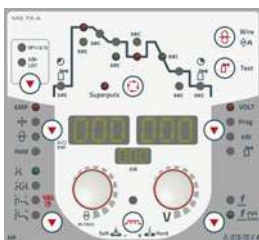
/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



drive 4X EX



drive 4X HP



drive 4X LP



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- Modular MIG/MAG inverter welding machine, pulse, with separate wire feeder; choice between drive 4X EX, drive 4X HP or drive 4X LP
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Depiction in combination with Trolley 55-5, Drive 4X and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Protective earth monitoring ()
- 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

Version	Phoenix 355	Phoenix 405	Phoenix 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 20 A	3 x 32 A	
On circuit voltage	79 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	88 %	90 %	
Dimensions machine, LxWxH in mm	625 x 298 x 531		
Weight, machine	41 kg	44.2 kg	
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals			
Wire feeder, LxWxH in mm	660 x 280 x 380		
Wire feeder weight	13 kg		
Dimensions cooling unit in mm	695 x 298 x 329		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1608 x 540 x 1150		
Trolley weight	35 kg		

Phoenix 355 | 405 | 505 Progress puls MM TDM

Phoenix 355 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 355 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005320-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 355 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005320-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 405 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 405 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005321-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1 m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 401 G M9 3 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00000
PM 401 G M9 4 m		1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 405 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 405 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005321-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 | 405 | 505 Progress puls MM TDM

Phoenix 505 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 505 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005322-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m		1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 505 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 505 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005322-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 355 | 405 | 505 Exrt 2.0 puls MM TDM

MULTIMATRIX

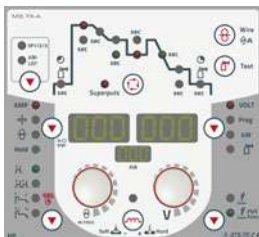
/rootArc° /rootArc° puls
/forceArc° /forceArc° puls
/Impuls/surPuls



Exrt 2.0 / drive 4X EX



drive 4X HP



drive 4X LP



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- Modular MIG/MAG inverter welding machine, pulse, with separate wire feeder; choice between drive 4X EX, drive 4X HP or drive 4X LP
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Depiction in combination with Trolley 55-5, Drive 4X and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- 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

Version	Phoenix 355 Exrt 2.0	Phoenix 405 Exrt 2.0	Phoenix 505 Exrt 2.0
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 20 A	3 x 32 A	
On circuit voltage	79 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	88 %	90 %	
Dimensions machine, LxWxH in mm	625 x 298 x 531		
Weight, machine	41 kg	44.2 kg	
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	S CE EAC		
Wire feeder, LxWxH in mm	660 x 280 x 380		
Wire feeder weight	13 kg		
Dimensions cooling unit in mm	695 x 298 x 329		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1068 x 540 x 1150		
Trolley weight	35 kg		

Phoenix 355 | 405 | 505 Exrt 2.0 puls MM TDM

Phoenix 355 Exrt 2.0 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 355 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005352-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolly 55-5/Trolly 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 Exrt 2.0 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 355 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005352-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 405 Exrt 2.0 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 405 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005353-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1 m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 405 Exrt 2.0 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 405 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005353-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1 m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 355 | 405 | 505 Exrt 2.0 puls MM TDM

Phoenix 505 Exrt 2.0 puls gas cooled

Ty	Designation	PU	Item no.
Phoenix 505 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005354-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m		1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolly 55-5/Trolly 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 505 Exrt 2.0 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 505 Exrt 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005354-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 401 | 501 Progress puls MM HP / LP FKW

MULTIMATRIX

/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



HP



LP



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- Compact inverter welding machine with integrated wire feed mechanism
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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

Version	Phoenix 401	Phoenix 501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003	
Weight, machine	127.8 kg	125.5 kg
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	S CE EAC	
Wire feed m/min	0.5 m/min - 25 m/min	
Wire feed ipm	19.68 ipm - 944.88 ipm	

Phoenix 401 | 501 Progress puls MM HP / LP FKW

Phoenix 401 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 401 Progress puls HP MM FKW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, mobile, water cooled, HP control	1	090-005404-00502
Phoenix 401 Progress puls LP MM FKW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, mobile, water cooled, LP control	1	090-005503-00502
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 501 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 501 Progress puls HP MM FKW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, mobile, water cooled, HP control	1	090-005405-00502
Phoenix 501 Progress puls LP MM FKW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, mobile, water cooled, LP control	1	090-005504-00502
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 401 Exrt 2.0 puls MM FKW

MULTIMATRIX

/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls




Exrt 2.0



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- Compact inverter welding machine with integrated wire feed mechanism
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- Connection capability for remote control and function torch
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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



Version	Phoenix 401 Exrt 2.0
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 32 A
On circuit voltage	79 V
Setting range for welding current	5 A - 400 A
Duty cycle 40 °C	400 A / 100 %
cos φ	0.99
Efficiency	90 %
Dimensions machine, LxWxH in mm	1085 x 450 x 1003
Weight, machine	127.8 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feed m/min	0.5 m/min - 25 m/min
Wire feed ipm	19.68 ipm - 944.88 ipm

Phoenix 401 Exrt 2.0 puls MM FKW

Phoenix 401 Exrt 2.0 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 401 Exrt 2.0 puls MM FKW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, mobile, water cooled, Exrt 2.0 control	1	090-005549-00502
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► Phoenix 501 Exrt 2.0 puls MM FKW (500 A) available on request

► * Only the items in bold are included in the total

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

MULTIMATRIX

/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



drive 4X EX



drive 4X HP



drive 4X LP



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- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder; choice between drive 4X EX, drive 4X HP or drive 4X LP
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Depiction in combination with Drive 4X – other wire feeders can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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

Version	Phoenix 351	Phoenix 401	Phoenix 451	Phoenix 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	118 kg		129 kg	
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

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

Phoenix 351 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 351 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005325-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 401 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 401 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005326-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 451 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 451 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005327-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 551 puls water cooled

Ty	Designation	PU	Item no.
Phoenix 551 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005328-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m		1	094-700005-00004
PM 551 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix 351 | 401 | 451 | 551 Exrt 2.0 puls MM FDW

MULTIMATRIX

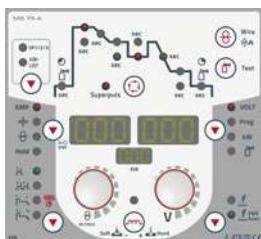
/rootArc° /rootArc° puls
/forceArc° /forceArc° puls
/Impuls/surPuls



Exrt 2.0 / drive 4X EX



drive 4X HP






drive 4X LP



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- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder; choice between drive 4X EX, drive 4X HP or drive 4X LP
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Depiction in combination with Drive 4X – other wire feeders can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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



Version	Phoenix 351 Exrt 2.0	Phoenix 401 Exrt 2.0	Phoenix 451 Exrt 2.0	Phoenix 551 Exrt 2.0
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	118 kg	129 kg		
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	  			
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

Ty	Designation	PU	Item no.
Phoenix 351 Exrt 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005329-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Phoenix 401 Exrt 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005330-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 351 | 401 | 451 | 551 Exrt 2.0 puls MM FDW

Ty	Designation	PU	Item no.
Phoenix 451 Exrt 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005331-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Phoenix 551 Exrt 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005332-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

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

MULTIMATRIX

/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



drive 4X EX






drive 4X HP



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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
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- 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

Version	Phoenix 351	Phoenix 401	Phoenix 451	Phoenix 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 %	420 A / 100 %
cos φ	0.99			
Efficiency	90 %			
Dimensions machine, LxWxH in mm	1085 x 680 x 1003			
Weight, machine	147 kg	158 kg		
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	  			
Wire feeder, LxWxH in mm	680 x 530 x 460			
Wire feeder weight	47.5 kg			

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

Phoenix 351 puls water cooled with double wire feeder

Ty	Designation	PU	Item no.
Phoenix 351 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate drive 4D	1	090-005325-10502
drive 4X IC D HP	Double wire feeder	1	090-005507-00502
drive 4X IC D EX		1	090-005598-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00004
PM 451 W M9 6,5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 401 puls water cooled with double wire feeder

Ty	Designation	PU	Item no.
Phoenix 401 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate drive 4D	1	090-005326-10502
drive 4X IC D HP	Double wire feeder	1	090-005507-00502
drive 4X IC D EX		1	090-005598-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00004
PM 451 W M9 6,5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 451 puls water cooled with double wire feeder

Ty	Designation	PU	Item no.
Phoenix 451 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate drive 4D	1	090-005327-10502
drive 4X IC D HP	Double wire feeder	1	090-005507-00502
drive 4X IC D EX		1	090-005598-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z		Workpiece lead with clamp	1
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10		Coolant (-10 °C), 5 l	1
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 551 puls water cooled with double wire feeder

Ty	Designation	PU	Item no.
Phoenix 551 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate drive 4D	1	090-005328-10502
drive 4X IC D HP	Double wire feeder	1	090-005507-00502
drive 4X IC D EX		1	090-005598-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z		Workpiece lead with clamp	1
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10		Coolant (-10 °C), 5 l	1
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

- ▶ Taurus machines available on request
- ▶ * Only the items in bold are included in the total

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

MULTIMATRIX

/rootArc® /rootArc® puls
 /forceArc® /forceArc® puls
 /Impuls/surPuls



drive 4X EX



drive 4X HP







drive 4X 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
- **Welding procedures and functions**
- Equipped at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- 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



Version	Phoenix 351	Phoenix 401	Phoenix 451	Phoenix 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 680 x 1003			
Weight, machine	1 kg			
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	   			
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

Phoenix 351 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 351 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005325-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
		1	394-002910-00030
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 401 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 401 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005326-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
		1	394-002910-00030
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

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

Phoenix 451 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 451 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005327-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 551 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 551 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005328-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
		1	094-700005-00004
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► Taurus machines available on request

► * Only the items in bold are included in the total

Phoenix 351 | 401 | 451 | 551 Exrt 2.0 puls MM 2DVX FDW

MULTIMATRIX

/rootArc® /rootArc® puls
/forceArc® /forceArc® puls
/Impuls/surPuls



Exrt 2.0 / drive 4X EX



drive 4X HP



drive 4X LP



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Wire feed units	Page	143
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Welding torches	Page	279
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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
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- **Welding procedures and functions**
- Equipd at no extra charge with EWM Synergic characteristics for forceArc, forceArc puls, rootArc, rootArc puls and surPuls
- Equipd 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
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding oration
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- 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

Version	Phoenix 351 Exrt 2.0	Phoenix 401 Exrt 2.0	Phoenix 451 Exrt 2.0	Phoenix 551 Exrt 2.0
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 %	420 A / 100 %
cos φ	0.99			
Efficiency	90 %			
Dimensions machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	118 kg		129 kg	
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

Phoenix 351 | 401 | 451 | 551 Exrt 2.0 puls MM 2DVX FDW

Phoenix 351 Exrt 2.0 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005329-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
		1	394-002910-00030
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 401 Exrt 2.0 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005330-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
		1	394-002910-00030
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Phoenix 451 Exrt 2.0 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005331-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
		1	094-700004-00004
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

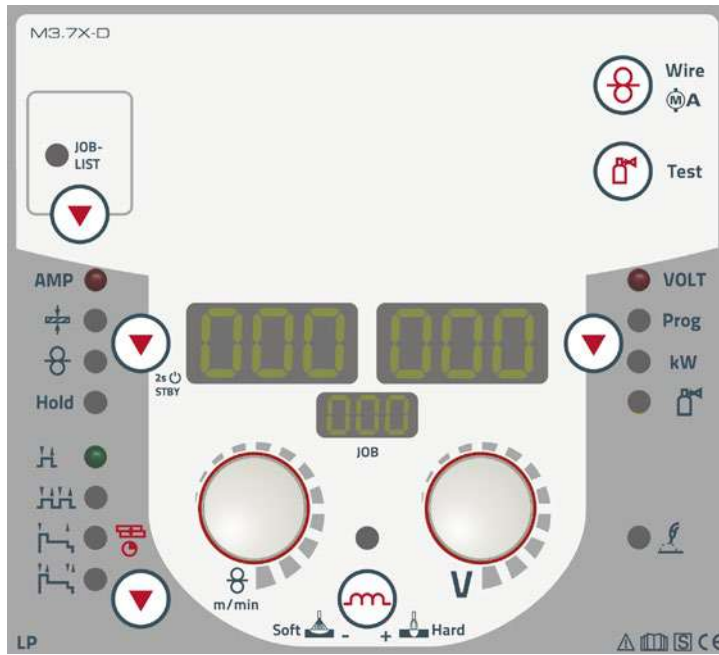
Phoenix 551 Exrt 2.0 puls water cooled with two wire feeders

Ty	Designation	PU	Item no.
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump, wheel spacer, holding plate for two drive 4X	1	090-005332-54502
drive 4X HP		1	090-005392-00502
		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
		1	090-005412-00502
drive 4X EX		1	090-005511-00502
		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
		1	094-700005-00004
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
		1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► Taurus machines available on request

► * Only the items in bold are included in the total

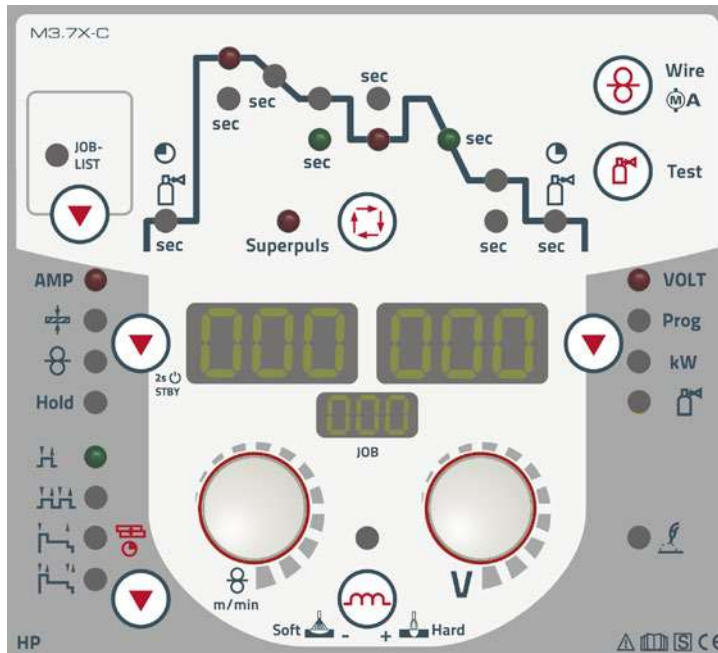
Control description LP



Oration mode	Synergic oration
Welding process	MIG/MAG
	TIG lift arc
	MMA
	forceArc®
	rootArc®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
Kilowatt indicator	
Freely adjustable programs r JOB	16
Number of JOBS	184
MMA functions	Hotstart
	Arcforce
	Antistick

- Synergic one-knob oration: The orating point can be set with a single knob thanks to easy JOB (welding task) preselection
- LP control: All the important setting options with direct access
- Arc length correction
- Adjusting the arc dynamics (choke effect) from soft to hard
- Standby function (save energy at the press of a button)
- Kilowatt display for calculating the energy r unit length
- Effective arc power for calculating the energy r unit length
- Electronic gas setting with control and monitoring of gas quantity (option)

Control description HP



- Synergic one-knob oration: the orating point can be set with a single knob thanks to easy JOB (welding task) preselection, including program sequence
- HP control: All the important setting options with direct access, including welding flowchart for easiest setting of all welding parameters
- Arc length correction
- Adjusting the arc dynamics (choke effect) from soft to hard
- Standby function (save energy at the press of a button)
- Kilowatt display for calculating the energy r unit length
- Effective arc power for calculating the energy r unit length
- Electronic gas setting with control and monitoring of gas quantity (option)

Oration mode	Synergic oration
Welding process	MIG/MAG
	TIG lift arc
	MMA
	forceArc®
	rootArc®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
	Kilowatt indicator
Freely adjustable programs r JOB	16
Number of JOBS	184
MMA functions	Hotstart
	Arcforce
	Antistick

Control description, Exrt 2.0



Oration mode	Synergic oration
Welding process	MIG/MAG
	TIG lift arc
	MMA
	forceArc®
	rootArc®
	surPuls
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
	Program number
	Error code
	Effective arc power
	Motor current
	Kilowatt indicator
Freely adjustable programs r JOB	16
Number of JOBS	184
MMA functions	Hotstart
	Arcforce
	Antistick

- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- USB connection
- Simple JOB selection (welding procedure, material, gas, wire dia.) using click wheel
- Easy switching of welding procedures at the press of a button, e.g. from force-Arc/forceArc puls to rootArc/rootArc puls or standard/pulse
- Setting of all parameters in program sequence
- Administration of access rights for different control orating levels using the Xbutton
- Electronic gas setting with control and monitoring of gas quantity (option)

Taurus 355 Synergic S MM HP / LP TKM

MULTIMATRIX

/rootArc®
/forceArc®
/surPuls



LP



HP



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Trolleys	Page	XXX

- Compact inverter welding machine with integrated wire feed mechanism
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- HP control can be easily changed for LP control at any time
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- 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

Version	Taurus 355
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	36 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feed m/min	0.5 m/min - 25 m/min
Wire feed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Taurus 355 Synergic S MM HP / LP TKM

Taurus 355 Synergic S compact gas cooled

Ty	Designation	PU	Item no.
Taurus 355 Synergic S HP MM TKM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, portable, HP control	1	090-005407-00502
Taurus 355 Synergic S LP MM TKM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, portable, LP control	1	090-005421-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 Synergic S compact water cooled

Ty	Designation	PU	Item no.
Taurus 355 Synergic S HP MM TKM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, portable	1	090-005407-00502
Taurus 355 Synergic S LP MM TKM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, portable, LP control	1	090-005421-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 355 | 405 | 505 Synergic S MM TDM

MULTIMATRIX

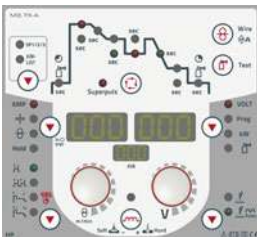
/rootArc®
/forceArc®
/surPuls



drive 4X EX



drive 4X HP



drive 4X LP



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- Depiction in combination with Trolley 55-5, Drive 4X and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- Inverter welding machine with separate wire feeder, choice between drive 4X EX, drive 4X HP or drive 4X LP
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- 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

Version	Taurus 355	Taurus 405	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 20 A	3 x 32 A	
On circuit voltage	79 V	79 V	79 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	88 %	90 %	
Dimensions machine, LxWxH in mm	625 x 298 x 531		
Weight, machine	41 kg		45 kg
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals			
Wire feeder, LxWxH in mm	660 x 280 x 380		
Wire feeder weight	13 kg		
Dimensions cooling unit in mm	695 x 298 x 329		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1063 x 540 x 1150		
Trolley weight	35 kg		

Taurus 355 | 405 | 505 Synergic S MM TDM

Taurus 355 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 355 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005336-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 355 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005336-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 405 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005337-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1 m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 20m		1	094-000580-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 405 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005337-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 | 405 | 505 Synergic S MM TDM

Taurus 505 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 505 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005338-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m		1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00000
PM 401 G M9 4 m		1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 505 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	1	090-005338-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700005-00000
PM 551 W M9 4 m		1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 Synergic S MM HP / LP FKG

MULTIMATRIX

/rootArc®
/forceArc®
/surPuls



LP



HP



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- Compact MIG/MAG inverter welding machine with one-knob Synergic control and integrated wire feed mechanism
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- 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 (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- HP control can be easily changed for LP control at any time
- PC interface for PC300 XQ software
- 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

Version	Taurus 351	Taurus 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003	
Weight, machine	110 kg	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	S CE EAC	
Wire feed m/min	0.5 m/min - 25 m/min	
Wire feed ipm	19.68 ipm - 944.88 ipm	

Taurus 351 | 401 Synergic S MM HP / LP FKG

Taurus 351 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 351 Synergic S HP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas cooled, HP control	1	090-005431-00502
Taurus 351 Synergic S LP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas cooled, LP control	1	090-005428-00502
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 401 Synergic S HP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas cooled, HP control	1	090-005432-00502
Taurus 401 Synergic S LP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas cooled, LP control	1	090-005429-00502
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 | 501 Synergic S MM HP / LP FKW

MULTIMATRIX

/rootArc®
/forceArc®
/surPuls



LP






HP



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- Compact MIG/MAG inverter welding machine with one-knob Synergic control and integrated wire feed mechanism
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- HP control can be easily changed for LP control at any time
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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

Version	Taurus 351	Taurus 401	Taurus 501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003		
Weight, machine	121.5 kg	128.4 kg	
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	  		
Wire feed m/min	0.5 m/min - 25 m/min		
Wire feed ipm	19.68 ipm - 944.88 ipm		

Taurus 351 | 401 | 501 Synergic S MM HP / LP FKW

Taurus 351 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 351 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with	1	090-005420-00502
Taurus 351 Synergic S LP MM FKW	MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	1	090-005422-00502
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 401 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with	1	090-005409-00502
Taurus 401 Synergic S LP MM FKW	MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	1	090-005423-00502
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 501 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 501 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with	1	090-005411-00502
Taurus 501 Synergic S LP MM FKW	MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	1	090-005424-00502
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 | 451 | 551 Synergic S MM FDG

MULTIMATRIX

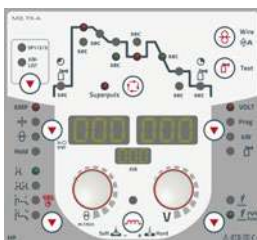
/rootArc®
/forceArc®
/surPuls



drive 4X EX



drive 4X HP



drive 4X LP



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- Inverter welding machine with separate wire feeder, choice between drive 4X EX, drive 4X HP or drive 4X LP
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Depiction in combination with Drive 4X – other wire feeders can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- 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

Version	Taurus 351	Taurus 401	Taurus 451	Taurus 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	107 kg		118 kg	
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

Taurus 351 | 401 | 451 | 551 Synergic S MM FDG

Taurus 351 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 351 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	1	090-005341-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 401 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	1	090-005342-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 451 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 451 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	1	090-005343-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 551 Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 551 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	1	090-005344-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
drive 4X LP		1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m		1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 | 451 | 551 Synergic S MM FDW

MULTIMATRIX

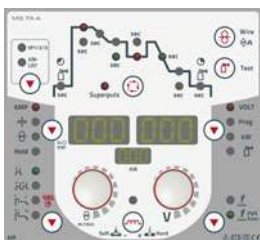
/rootArc®
/forceArc®
/surPuls



drive 4X EX



drive 4X HP



drive 4X LP



Controls	Page	124
Wire feed rolls	Page	154
Remote controls	Page	279
Welding torches	Page	322
Options/accessories	Page	470
Trolleys	Page	XXX

- Water-cooled MIG/MAG welding machine with separate wire feeder; choice between drive 4X EX, drive 4X HP or drive 4X LP
- **Welding procedures and functions**
- 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
- Equipped at no extra charge with EWM certified Synergic characteristics for forceArc, rootArc and suPuls
- 16 individually configurable programmes for each welding task (JOB)
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- **Your benefits**
- Depiction in combination with Drive 4X – other wire feeders can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Connection capability for remote control and function torch
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- 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



Version	Taurus 351	Taurus 401	Taurus 451	Taurus 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	118 kg	129 kg		
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	13 kg			

Taurus 351 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 351 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005345-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled,	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m	7-pole	1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 401 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005346-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled,	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m	7-pole	1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m	MIG/MAG welding torch, water-cooled	1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 351 | 401 | 451 | 551 Synergic S MM FDW

Taurus 451 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 451 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005347-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled,	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m	7-pole	1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 551 Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 551 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	1	090-005348-00502
drive 4X HP		1	090-005392-00502
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
drive 4X EX		1	090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled,	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m	7-pole	1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Phoenix puls/Taurus Synergic S system components - Wire feed units

drive 4X

- MIG/MAG wire feeder with Multimatrix technology
- 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
- Equipd with key switch for locking the control as standard
- Standard sliding rails as well as transparent cover cap for protection of the control system
- Rugged electronics in a dust-free enclosure
- Adjustable start and end-crater functions
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical rsonnel can change hose packages without tools
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel

drive 4X LP



- LP control: All the important setting options with direct access
 - JOB display: Current welding task (JOB number) visible at all times
 - Kilowatt display for calculating the energy r unit length
 - Standby function

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU	Item no.
	stk	
Wire feeder, water-cooled, Euro torch connector	1	090-005412-00502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	1	090-005412-51502
Wire feeder, water-cooled, Euro torch connector, electronic gas flow control	1	090-005412-55502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch, electronic gas flow control	1	090-005412-60502

Phoenix puls/Taurus Synergic S system components - Wire feed units

drive 4X

drive 4X HP



- HP control: All the important setting options with direct access, including welding flow-chart for easiest setting of all welding parameters
 - JOB display: Current welding task (JOB number) visible at all times
 - Kilowatt display for calculating the energy r unit length
 - Standby function

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	1	090-005392-00502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	1	090-005392-51502
Wire feeder, water-cooled, Euro torch connector, electronic gas flow control	1	090-005392-55502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch, electronic gas flow control	1	090-005392-60502

drive 4X EX



- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- USB connection
- All welding parameters directly adjustable on wire feeder
- Administration of access rights for different control orating levels using the Xbutton

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	1	090-005511-00502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	1	090-005511-51502
Wire feeder, water-cooled, Euro torch connector, electronic gas flow control	1	090-005511-55502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch, electronic gas flow control	1	090-005511-60502

Options Drive 4X

ON Flowmeter



- Flow meter for manual shielding gas flow setting
- Precise setting and checking of the gas quantity at the welding site
- Extremely advantageous with long hose packages, e.g. for shipbuilding and steel construction

Designation	PU stk	Item no.
Analogue gas flow rate adjustment with gas flow meter option	1	092-003374-00000

ON TS D01/D02



- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Designation	PU stk	Item no.
Torch holder for drive XQ, drive 4X, drive 4 Basic and drive 4X IC	1	092-002836-00000

ON WAK D01



- Wheel kit
- Ensures limitless mobility
- Large rolls (Ø 125 mm) for optimal freedom of movement
- One roll with locking brake

Designation	PU stk	Item no.
Wheel assembly kit	1	092-002844-00000

ON PS EXT D01



- Turning mandrel extension – allows a wire feeder with a wheel kit to be attached to the wire feeder pivot support
- Fast assembly – the extension is simply inserted onto the mandrel of the pivot support and secured
- A wire feeder pivot support is absolutely required for use
- Cannot be used with gas-cooled, mobile machines and Trolley 55-5/55-6!

Designation	PU stk	Item no.
Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	1	092-002871-00000

ON RFAK drive 4X



- Rubber feet to replace sliding rails

Designation	PU stk	Item no.
Rubber feet	1	092-002845-00000

Options Drive 4X

ON GK drive 4X



- Stainless steel runners

Designation	PU stk	Item no.
Stainless steel runners	1	092-003030-00000

ON CMF D01



- Crane susnsion for safe and easy transportation
- Maximum mobility even during susnsion orations

Designation	PU stk	Item no.
Crane susnsion	1	092-002833-00000

ON TCC D01



- Heavy-duty set: safety plate and crane susnsion
- For optimised protection under tough conditions
- For standing, vertical and susnsion oration
- Temrature- and impact-resistant sliding safety plate
- Crane susnsion for maximum mobility and easy, safe transport

Designation	PU stk	Item no.
Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	1	092-002835-00000

ON PDM drive 4X



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Oration still possible thanks to recesses for the rotary knobs

Designation	Version	PU stk	Item no.
Transparent cover lens for machine control	for HP/LP control	1	092-002987-00000
Transparent cover lens for wire feed controls	for EX XQ 2.0/EX 2.0 control	1	092-003480-00000

ON CC D01



- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Designation	PU stk	Item no.
Transparent cover cap for protecting the control	1	092-002834-00000

ON CONNECTOR D01/D02



- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Designation	Length m	PU stk	Item no.
Connection for wire feeding from drum	-	1	092-002842-00000
Connection for large spool/drum	-	1	094-011517-00000
	1.8	1	094-011515-00004
	3.0	1	094-011515-00000
Wire guide	4.5	1	094-011515-00001
	8.0	1	094-011515-00002
	12.0	1	094-011515-00003

Phoenix puls/Taurus Synergic S system components - Wire feed units

drive 4X IC

- MIG/MAG wire feeder with Multimatrix technology
- Steel housing, closed
- Robust, for tough production applications
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

drive 4X IC LP



- LP control: All the important setting options with direct access

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Wire feeder weight	22 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder, water-cooled, Euro torch connector

PU
stk

1 090-005415-00502

drive 4X IC HP



- HP control: All the important setting options with direct access, including welding flow-chart for easiest setting of all welding parameters

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Wire feeder weight	22 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder, water-cooled, Euro torch connector

PU
stk

1 090-005414-00502

drive 4X IC D

- Double wire feeder for welding two welding tasks with only one power source
- 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 scial torch or changeover on the machine required!
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

drive 4X IC D HP



- HP control: All the important setting options with direct access, including welding flow-chart for easiest setting of all welding parameters

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	680 x 530 x 460
Wire feeder weight	47.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Double wire feeder

PU
stk

1 090-005507-00502

drive 4X IC D EX



- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- USB connection
- Administration of access rights for different control orating levels using the Xbutton

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	680 x 530 x 460
Wire feeder weight	47.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Double wire feeder

PU
stk

1 090-005598-00502

Options Drive 4X IC

ON CMF D.0007



Designation	PU stk	Item no.
Crane susnsion for double wire feeder	1	092-002147-00000

ON PDM drive 4X IC

- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Oration still possible thanks to recesses for the rotary knobs

Version	
	for drive 4X IC with Exrt 2.0 control

Designation	PU stk	Item no.	
Transparent cover lens for machine control	1	092-003481-00000	on request

ON WAKD D.0002



- 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)!

Designation	PU stk	Item no.
Wheel assembly kit for drive 4 IC and drive 4/41	1	090-008035-00000

Intermediate drive • miniDrive

- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- 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
- Hose packages length up to 25 m possible
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m!
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- Connection capability for remote control
- It is not possible to supply the miniDrive ex works with Phoenix 355 TKM, Taurus 355 TKM/TKW and Picomig 355 machines. We are happy to offer you a customised solution. Please contact our Service Department if you are interested in such a solution.

miniDrive WS



Wire speed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for gas-cooled torches	10.0	1	090-005262-00110
	15.0	1	090-005262-00115
	20.0	1	090-005262-00120
	25	1	090-005262-00125
miniDrive with hose package for water-cooled torches	10.0	1	090-005262-01110
	15.0	1	090-005262-01115
	20.0	1	090-005262-01120
	25	1	090-005262-01125

miniDrive WS V+A



- miniDrive with hose package for water-cooled torches with volt and ammeter
- Utilisation of function torch with X technology not possible

Wire speed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for water-cooled welding torches with voltmeter and ammeter	10.0	1	090-005396-01110
	15.0	1	090-005396-01115
	20.0	1	090-005396-01120
	25	1	090-005396-01125

Gas-cooled

- Gas-cooled intermediate hose package
- 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

MIG G 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-000580-00000
	5.0	1	094-000580-00001
	10.0	1	094-000580-00002
	15.0	1	094-000580-00005
	20.0	1	094-000580-00003
	30	1	094-000580-00006

MIG G 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-007726-00000
	5.0	1	094-007726-00001
	10.0	1	094-007726-00002
	15.0	1	094-007726-00003
	20.0	1	094-007726-00004
	30	1	094-007726-00005
	40	1	094-007726-00007

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG W 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A, 60 %
Cross-section	70 mm ²

Designation	Hose package length	PU	Item no.
	m	stk	
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000406-00000
	5.0	1	094-000406-00001
	10.0	1	094-000406-00002
	15.0	1	094-000406-00004
	20.0	1	094-000406-00005
	30	1	094-000406-00006

MIG W 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A, 60 %
Cross-section	95 mm ²

Designation	Hose package length	PU	Item no.
	m	stk	
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000407-00000
	5.0	1	094-000407-00001
	10.0	1	094-000407-00002
	15.0	1	094-000407-00006
	20.0	1	094-000407-00007
	30	1	094-000407-00003
	40	1	094-000407-00008

Remote control Phoenix puls/Taurus Synergic S

RCX 2.0



- Exrt 2.0 remote control
- Welding current (amp), arc correction (volt) and arc dynamics (soft/hard) directly adjustable using two rotary knobs
- With pre-fitted connection cable
- Exrt 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Simple JOB selection (welding procedure, material, gas, wire dia.) using click wheel
- Easy switching of welding procedures at the press of a button, e.g. from forceArc/forceArc puls to rootArc/rootArc puls or standard/pulse
- Setting of all parameters in program sequence
- Social non-latched and social latched with adjustable start and end crater program
- Administration of access rights for different control orating levels using the Xbutton
- 16 individually configurable programmes for each welding task (JOB)
- 16 programs r JOB
- Spot welding/tack function (spotArc/spotmatic)
- Save electricity through standby function

Weight	2 kg
Dimensions LxWxH in mm	310 x 230 x 110

Designation	Cable length m	PU stk	Item no.
Exrt 2.0 remote control	2.0	1	090-008808-00002
	5.0	1	090-008808-00005
	10.0	1	090-008808-00010
	15.0	1	090-008808-00015

R50



- Remote control R50 7POL enables all Taurus Synergic S, Phoenix and alpha Q machines to be equipd 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
- Cable not supplied in delivery, please order connection cable separately

Weight	3.2 kg
Connection	7-pole
Dimensions LxWxH in mm	250 x 230 x 108

Designation	PU stk	Item no.
Remote control with complete range of functions	1	090-008776-00000

RG10

- 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

Weight	0.7 kg
Cable length	5
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	PU	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008108-00000

R10

- Voltage correction from -10 V to +10 V
- Infinitely variable setting of wire-feed speed (0.5–24 m/min)
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Weight	1 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008087-00502

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
- Cable not supplied in delivery, please order connection cable separately

Weight	2.5 kg
Connection	19-pole
Dimensions LxWxH in mm	330 x 180 x 95

Designation	PU	Item no.
Remote control, program switching	1	090-008263-00000

Remote control Phoenix puls/Taurus Synergic S

R40



- Switch between MIG standard welding and pulsed arc welding
- Switch sur 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
- Cable not supplied in delivery, please order connection cable separately

Weight	1.8 kg
Connection	7-pole
Dimensions LxWxH in mm	270 x 150 x 75

Designation	PU stk	Item no.
Remote control, 16 programs	1	090-008088-00000

Connection cables



Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

Digital 7-pole cable



- Digital 7-pole cable
- Extension for 7-pole remote control with rmanently installed cable
- Connection cable for remote control and gateway without rmanently installed cable

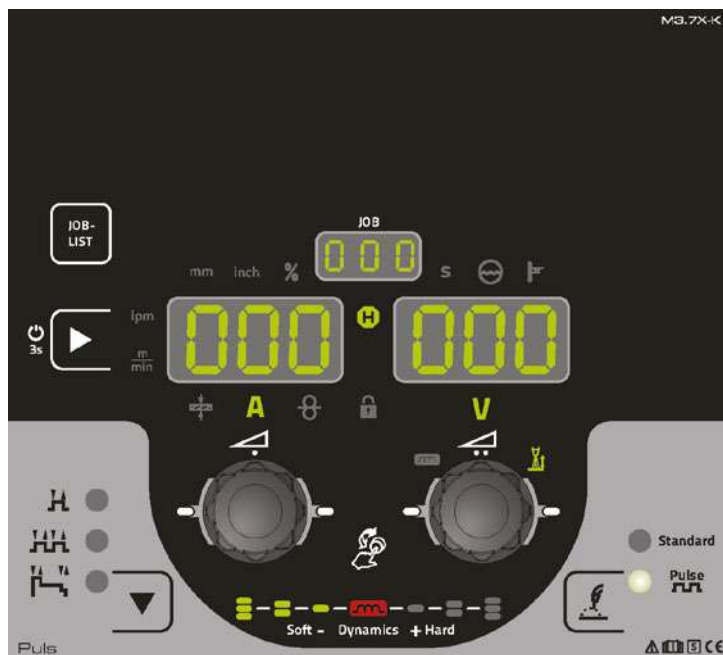
Connection	7-pole
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Designation	Cable length m	PU stk	Item no.
Digital 7-pole cable	0.5	1	092-000201-00004
	1.0	1	092-000201-00002
	5.0	1	092-000201-00003
	10.0	1	092-000201-00000
	15.0	1	092-000201-00005
	20.0	1	092-000201-00001
	25	1	092-000201-00007

Overview Taurus Steel

MIG/MAG welding machines			Page
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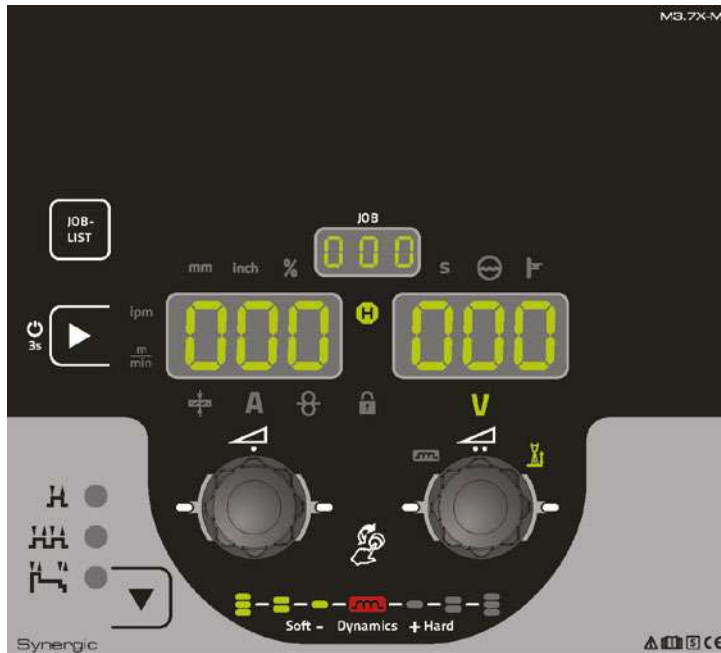
Control overview Taurus Steel puls S



Oration mode	Synergic oration
Welding process	MIG/MAG
	MIG/MAG pulse
	MMA
	Gouging
Pulse ty	Puls
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
Number of JOBs	32
MMA functions	Hotstart
	Arcforce
	Antistick

- Clear Synergic orating concept guarantees simplest setting of the welding parameters and quick finding of the orating point
- Locking of controls e.g. for transport
- Adjusting the arc dynamics (choke effect) from soft to hard

Control overview Taurus Steel Synergic S



- Clear Synergic orating concept guarantees simplest setting of the welding parameters and quick finding of the orating point
- Locking of controls e.g. for transport
- Adjusting the arc dynamics (choke effect) from soft to hard

Oration mode	Synergic oration
Welding process	MIG/MAG
	MMA
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Plate thickness
	JOB number
Number of JOBs	24
MMA functions	Hotstart
	Arcforce
	Antistick




Taurus 405 | 505 Steel puls S



Steel puls S



- MIG/MAG pulse welding machine with optimised synergic characteristics for welding steel
- Pulsed MIG/MAG welding, MIG/MAG welding, MMA welding and gouging
- Significantly less spatter formation and therefore less finishing work thanks to the pulse function
- **Welding procedures and functions**
 - Welding with solid wire and flux cored wire
 - Infinitely adjustable arc dynamics (choke effect)
 - Adjustable start and end-crater functions
 - Synergic or manual welding oration
- **Your benefits**
 - Depiction in combination with Trolley 55-5, Drive 4X Steel and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
 - Factory-fit option: Extra gas valve for increased safety
 - High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
 - Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
 - High on circuit voltage for excellent ignition characteristics
 - Energy-saving thanks to high efficiency and standby function
 - Easy, tool-free change of welding polarity
 - IP23 spray water protected
 - Connection capability for remote control and function torch (only up/down)
 - PC interface for PC300 XQ software
 - Protective earth monitoring ()
 - 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

Version	Taurus 405	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
On circuit voltage	79 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 machine, LxWxH in mm	625 x 298 x 531	
Weight, machine	41 kg	45 kg
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	  	
Wire feeder, LxWxH in mm	660 x 280 x 380	
Wire feeder weight	13 kg	
Dimensions cooling unit in mm	695 x 298 x 329	
Weight, cooling unit	16.5 kg	
Trolley dimensions L x W x H in mm	1068 x 540 x 1150	
Trolley weight	35 kg	

Taurus 405 Steel puls S gas cooled

Ty	Designation	PU	Item no.
Taurus 405 Steel puls S	MIG/MAG pulse welding machine, decompact, modular	1	090-005589-00502
Drive 4X Steel puls S	Wire feeder, Euro torch connector	1	090-005593-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Steel puls S water cooled

Ty	Designation	PU	Item no.
Taurus 405 Steel puls S	MIG/MAG pulse welding machine, decompact, modular	1	090-005589-00502
Drive 4X Steel puls S	Wire feeder, Euro torch connector	1	090-005593-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 | 505 Steel puls S

Taurus 505 Steel puls S gas cooled

Ty	Designation	PU	Item no.
Taurus 505 Steel puls S	MIG/MAG pulse welding machine, decompact, modular	1	090-005599-00502
Drive 4X Steel puls S	Wire feeder, Euro torch connector	1	090-005593-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 95qmm 550A/60% 1m		1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Steel puls S water cooled

Ty	Designation	PU	Item no.
Taurus 505 Steel puls S	MIG/MAG pulse welding machine, decompact, modular	1	090-005599-00502
Drive 4X Steel puls S	Wire feeder, Euro torch connector	1	090-005593-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 405 | 505 Steel Synergic S





Steel Synergic S



- MIG/MAG inverter welding machine with optimised synergic characteristics for welding steel
- MIG/MAG welding, MMA welding and gouging
- **Welding procedures and functions**
- Welding with solid wire and flux cored wire
- Infinitely adjustable arc dynamics (choke effect)
- Adjustable start and end-crater functions
- Synergic or manual welding oration
- **Your benefits**
- Depiction in combination with Trolley 55-5, Drive 4X Steel and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- Factory-fit option: Extra gas valve for increased safety
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- High on circuit voltage for excellent ignition characteristics
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Connection capability for remote control and function torch (only up/down)
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Protective earth monitoring ()
- 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



Version	Taurus 405	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
On circuit voltage	79 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 machine, LxWxH in mm	625 x 298 x 531	
Weight, machine	41 kg	45 kg
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	 	
Wire feeder, LxWxH in mm	660 x 280 x 380	
Wire feeder weight	13 kg	
Dimensions cooling unit in mm	695 x 298 x 329	
Weight, cooling unit	16.5 kg	
Trolley dimensions L x W x H in mm	1068 x 540 x 1150	
Trolley weight	35 kg	

Taurus 405 | 505 Steel Synergic S

Taurus 405 Steel Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 405 Steel Synergic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005590-00502
Drive 4X Steel Synergic S	Wire feeder, Euro torch connector	1	090-005595-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Steel Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 405 Steel Synergic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005590-00502
Drive 4X Steel Synergic S	Wire feeder, Euro torch connector	1	090-005595-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Steel Synergic S gas cooled

Ty	Designation	PU	Item no.
Taurus 505 Steel Synergic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005600-00502
Drive 4X Steel Synergic S	Wire feeder, Euro torch connector	1	090-005595-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 95qmm 550A/60% 1m		1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Steel Synergic S water cooled

Ty	Designation	PU	Item no.
Taurus 505 Steel Synergic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005600-00502
Drive 4X Steel Synergic S	Wire feeder, Euro torch connector	1	090-005595-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus Steel system components - Wire feed units

Drive 4X Steel puls S

- MIG/MAG wire feeder for Taurus Steel puls S
- Pulsed MIG/MAG welding, MIG/MAG welding, MMA welding and gouging
- Significantly less spatter formation and therefore less finishing work thanks to the pulse function
- Adjustable start and end-crater functions
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical rsonnel can change hose packages without tools
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires

Drive 4X Steel puls S



- 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
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Connection socket for electrode holder as standard
- Standard sliding rails as well as transparent cover cap for protection of the control system
- Rugged electronics in a dust-free enclosure
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder, Euro torch connector

PU
stk

Item no.
1 090-005593-00502

Drive 4X Steel puls S D200



- Wire feeder housing: Plastic
- D200 spool holder
- Can pass through manholes
- Low weight thanks to the plastic casing
- Adjustment of the gas quantity directly on the wire feeder via the gas control valve
- Spool diameter up to 200 mm

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200
Roller diameter	37 mm
Wire feeder, LxWxH in mm	585 x 276 x 340
Wire feeder weight	13.8 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder for D200 spools, Euro torch connector

PU
stk

Item no.
1 090-005592-00502

Drive 4X Steel Synergic S

- MIG/MAG wire feeder for Taurus Steel Synergic S
- MIG/MAG welding, MMA welding and gouging
- Adjustable start and end-crater functions
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical rsonnel can change hose packages without tools
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires

Drive 4X Steel Synergic S



- 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
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Connection socket for electrode holder as standard
- Standard sliding rails as well as transparent cover cap for protection of the control system
- Rugged electronics in a dust-free enclosure
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU stk	Item no.
Wire feeder, Euro torch connector	1	090-005595-00502

Drive 4X Steel Synergic S D200



- Wire feeder housing: Plastic
- D200 spool holder
- Can pass through manholes
- Low weight thanks to the plastic casing
- Adjustment of the gas quantity directly on the wire feeder via the gas control valve
- Spool diameter up to 200 mm

Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200
Roller diameter	37 mm
Wire feeder, LxWxH in mm	585 x 276 x 340
Wire feeder weight	13.8 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU stk	Item no.
Wire feeder for D200 spools, Euro torch connector	1	090-005594-00502

Drive 4X Steel options

ON Flowmeter



- Flow meter for manual shielding gas flow setting
- Precise setting and checking of the gas quantity at the welding site
- Extremely advantageous with long hose packages, e.g. for shipbuilding and steel construction

Designation	PU stk	Item no.
Analogue gas flow rate adjustment with gas flow meter option	1	092-003374-00000

ON TS D01/D02



- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Designation	PU stk	Item no.
Torch holder for drive XQ, drive 4X, drive 4 Basic and drive 4X IC	1	092-002836-00000

ON WAK D01



- Wheel kit
- Ensures limitless mobility
- Large rolls (Ø 125 mm) for optimal freedom of movement
- One roll with locking brake

Designation	PU stk	Item no.
Wheel assembly kit	1	092-002844-00000

ON PS EXT D01



- Turning mandrel extension – allows a wire feeder with a wheel kit to be attached to the wire feeder pivot support
- Fast assembly – the extension is simply inserted onto the mandrel of the pivot support and secured
- A wire feeder pivot support is absolutely required for use
- Cannot be used with gas-cooled, mobile machines and Trolley 55-5/55-6!

Designation	PU stk	Item no.
Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	1	092-002871-00000

ON RFAK drive



- Rubber feet to replace sliding rails

Designation	PU stk	Item no.
Rubber feet	1	092-002845-00000

ON GK drive



- Stainless steel runners

Designation	PU stk	Item no.
Stainless steel runners	1	092-003030-00000

ON CMF D01



- Crane susnsion for safe and easy transportation
- Maximum mobility even during susnsion orations

Designation	PU stk	Item no.
Crane susnsion	1	092-002833-00000

ON TCC D01



- Heavy-duty set: safety plate and crane susnsion
- For optimised protection under tough conditions
- For standing, vertical and susnsion oration
- Temrature- and impact-resistant sliding safety plate
- Crane susnsion for maximum mobility and easy, safe transport

Designation	PU stk	Item no.
Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	1	092-002835-00000

Transparent cover lens



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Oration still possible thanks to recesses for the rotary knobs

Version	for HP-XQ/Taurus Steel puls/Taurus Steel Syner- gic/Taurus Basic S
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Designation	PU stk	Item no.
Transparent cover lens for wire feed controls	1	092-003478-00000

ON CC D01



- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Designation	PU stk	Item no.
Transparent cover cap for protec- ting the control	1	092-002834-00000

Drive 4X Steel options

ON CONNECTOR D01/D02



- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Designation	Length m	PU stk	Item no.
Connection for wire feeding from drum	-	1	092-002842-00000
Connection for large spool/drum	-	1	094-011517-00000
	1.8	1	094-011515-00004
	3.0	1	094-011515-00000
Wire guide	4.5	1	094-011515-00001
	8.0	1	094-011515-00002
	12.0	1	094-011515-00003

Drive 4X Steel D200 options

ON PS Trolley 55-5 / 55-6 drive D200



- Pivot support for D200 wire feeders
- Necessary for safe installation of D200 wire feeder on ON PS Trolley 55-5/55-6
- Wire feeder pivots 360° on the welding machine
- Option 092-002712-00000 is absolutely necessary to connected a wire feeder!
- For drive D200 on Trolley 55-5/55-6

Designation	PU stk	Item no.
Pivot support for D200 wire feeders	1	092-002634-00000

Transparent cover lens



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Operation still possible thanks to recesses for the rotary knobs

Version	
	for HP-XQ/Taurus Steel puls/Taurus Steel Synergic/Taurus Basic S

Designation	PU stk	Item no.
Transparent cover lens for machine control	1	092-003479-00000

Intermediate drive • miniDrive

- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- 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
- Hose packages length up to 25 m possible
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m!
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- Connection capability for remote control
- It is not possible to supply the miniDrive ex works with Phoenix 355 TKM, Taurus 355 TKM/TKW and Picomig 355 machines. We are happy to offer you a customised solution. Please contact our Service Department if you are interested in such a solution.

miniDrive WS



Wire feed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for gas-cooled torches	10.0	1	090-005262-00110
	15.0	1	090-005262-00115
	20.0	1	090-005262-00120
	25	1	090-005262-00125
miniDrive with hose package for water-cooled torches	10.0	1	090-005262-01110
	15.0	1	090-005262-01115
	20.0	1	090-005262-01120
	25	1	090-005262-01125

miniDrive WS V+A



- miniDrive with hose package for water-cooled torches with volt and ammeter
- Utilisation of function torch with X technology not possible

Wire feed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for water-cooled welding torches with voltmeter and ammeter	10.0	1	090-005396-01110
	15.0	1	090-005396-01115
	20.0	1	090-005396-01120
	25	1	090-005396-01125

Taurus Steel system components - Intermediate hose packages

Gas-cooled

- Gas-cooled intermediate hose package
- 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

MIG G 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A, 60 %
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-000580-00000
	5.0	1	094-000580-00001
	10.0	1	094-000580-00002
	15.0	1	094-000580-00005
	20.0	1	094-000580-00003
	30	1	094-000580-00006

MIG G 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A, 60 %
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-007726-00000
	5.0	1	094-007726-00001
	10.0	1	094-007726-00002
	15.0	1	094-007726-00003
	20.0	1	094-007726-00004
	30	1	094-007726-00005
	40	1	094-007726-00007

Taurus Steel system components - Intermediate hose packages

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG W 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000406-00000
	5.0	1	094-000406-00001
	10.0	1	094-000406-00002
	15.0	1	094-000406-00004
	20.0	1	094-000406-00005
	30	1	094-000406-00006

MIG W 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000407-00000
	5.0	1	094-000407-00001
	10.0	1	094-000407-00002
	15.0	1	094-000407-00006
	20.0	1	094-000407-00007
	30	1	094-000407-00003
	40	1	094-000407-00008

Remote control Taurus Steel puls S • Taurus Steel Synergic S

RG10



- 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

Weight	0.7 kg
Cable length	5
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	PU stk	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008108-00000

R10



- Voltage correction from -10 V to +10 V
- Infinitely variable setting of wire-feed speed (0.5–24 m/min)
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Weight	1 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control, wire speed setting, welding voltage correction	1	090-008087-00502

Connection cables



Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



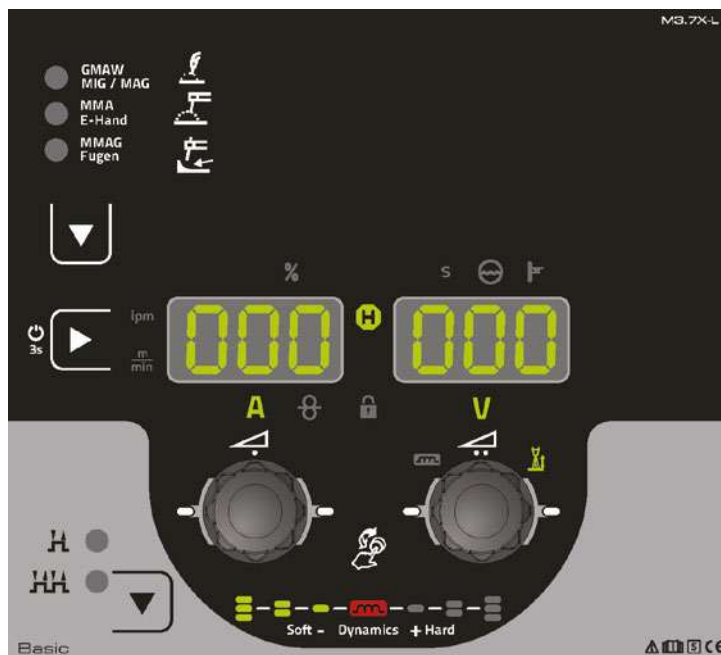
Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	w

Overview Taurus Basic S

MIG/MAG welding machines			Page	
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Extension cable			189	

Control overview Taurus Basic S



Oration mode	Twin-knob oration
Welding process	MIG/MAG
	MMA
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Error code
MMA functions	Hotstart
	Arcforce
	Antistick

- Locking of controls e.g. for transport
- Adjusting the arc dynamics (choke effect) from soft to hard
- Twin-knob oration: configuration of orating point using wire feed sed and welding voltage

Taurus 405 | 505 Basic S



Basic S



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Remote controls	Page	189
Welding torches	Page	279
Options/accessories	Page	322
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- MIG/MAG inverter welding machine with manual orating point adjustment
- MIG/MAG welding, MMA welding and gouging
- **Welding procedures and functions**
- Most simple oration and selection of the welding tasks CV (MAG)/CC (MMA)
- Welding with solid wire and flux cored wire
- Infinitely adjustable arc dynamics (choke effect)
- **Your benefits**
- Depiction in combination with Trolley 55-5, Drive 4 Basic S and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- Factory-fit option: Extra gas valve for increased safety
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- High on circuit voltage for excellent ignition characteristics
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Connection capability for remote control and function torch (only up/down)
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Protective earth monitoring ()



Version	Taurus 405	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
On circuit voltage	79 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 machine, LxWxH in mm	625 x 298 x 531	
Weight, machine	41 kg	45 kg
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	S CE EAC	
Wire feeder, LxWxH in mm	660 x 280 x 380	
Wire feeder weight	13 kg	
Dimensions cooling unit in mm	695 x 298 x 329	
Weight, cooling unit	16.5 kg	
Trolley dimensions L x W x H in mm	1068 x 540 x 1150	
Trolley weight	35 kg	

Taurus 405 | 505 Basic S

Taurus 405 Basic S gas cooled

Ty	Designation	PU	Item no.
Taurus 405 Basic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005591-00502
Drive 4 Basic S	Wire feeder, Euro torch connector	1	090-005597-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 70qmm 450A/60% 1m		1	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		1	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		1	094-000580-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Basic S water cooled

Ty	Designation	PU	Item no.
Taurus 405 Basic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005591-00502
Drive 4 Basic S	Wire feeder, Euro torch connector	1	090-005597-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Basic S gas cooled

Ty	Designation	PU	Item no.
Taurus 505 Basic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005601-00502
Drive 4 Basic S	Wire feeder, Euro torch connector	1	090-005597-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
MIG G 7POL 95qmm 550A/60% 1m		1	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		1	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		1	094-007726-00003
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Basic S water cooled

Ty	Designation	PU	Item no.
Taurus 505 Basic S	MIG/MAG inverter welding machine, decompact, modular	1	090-005601-00502
Drive 4 Basic S	Wire feeder, Euro torch connector	1	090-005597-00502
OW Gasrelais	Factory-fit option: Additional gas valve in welding machine	1	092-003464-00001
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
PM 551 W M9 3 m		1	094-700005-00000
PM 551 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus Basic S system components - Wire feed units

Drive 4 Basic S

- MIG/MAG wire feeder for Taurus Basic S
- MIG/MAG welding, MMA welding and gouging
- Most simple operation and selection of the welding tasks CV (MAG)/CC (MMA)
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical personnel can change hose packages without tools
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires

Drive 4 Basic S



- 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
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Connection socket for electrode holder as standard
- Standard sliding rails
- Rugged electronics in a dust-free enclosure
 - Double ball bearings on axle
 - Tool-free roll change, permanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires

Wire speed m/min	0.5 m/min: 25 m/min
Wire speed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	13 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder, Euro torch connector

PU
stk

1 090-005597-00502

Drive 4 Basic S D200



- Wire feeder housing: Plastic
- D200 spool holder
- Can pass through manholes
- Low weight thanks to the plastic casing
- Adjustment of the gas quantity directly on the wire feeder via the gas control valve
- 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
Spool size	D200
Roller diameter	37 mm
Wire feeder, LxWxH in mm	585 x 276 x 340
Wire feeder weight	13.8 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation

Wire feeder for D200 spools, Euro torch connector

PU
stk

1 090-005596-00502

Drive 4 Basic S options

ON Flowmeter



- Flow meter for manual shielding gas flow setting
- Precise setting and checking of the gas quantity at the welding site
- Extremely advantageous with long hose packages, e.g. for shipbuilding and steel construction

Designation	PU stk	Item no.
Analogue gas flow rate adjustment with gas flow meter option	1	092-003374-00000

ON TS D01/D02



- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Designation	PU stk	Item no.
Torch holder for drive XQ, drive 4X, drive 4 Basic and drive 4X IC	1	092-002836-00000

ON WAK D01



- Wheel kit
- Ensures limitless mobility
- Large rolls (Ø 125 mm) for optimal freedom of movement
- One roll with locking brake

Designation	PU stk	Item no.
Wheel assembly kit	1	092-002844-00000

ON PS EXT D01



- Turning mandrel extension – allows a wire feeder with a wheel kit to be attached to the wire feeder pivot support
- Fast assembly – the extension is simply inserted onto the mandrel of the pivot support and secured
- A wire feeder pivot support is absolutely required for use
- Cannot be used with gas-cooled, mobile machines and Trolley 55-5/55-6!

Designation	PU stk	Item no.
Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	1	092-002871-00000

ON RFAK drive



- Rubber feet to replace sliding rails

Designation	PU stk	Item no.
Rubber feet	1	092-002845-00000

Drive 4 Basic S options

ON GK drive



- Stainless steel runners

Designation	PU stk	Item no.
Stainless steel runners	1	092-003030-00000

ON CMF D01



- Crane susnsion for safe and easy transportation
- Maximum mobility even during susnsion orations

Designation	PU stk	Item no.
Crane susnsion	1	092-002833-00000

ON TCC D01



- Heavy-duty set: safety plate and crane susnsion
- For optimised protection under tough conditions
- For standing, vertical and susnsion oration
- Temrature- and impact-resistant sliding safety plate
- Crane susnsion for maximum mobility and easy, safe transport

Designation	PU stk	Item no.
Set comprised of crane susnsion bracket and protective plate, for using the wire feeder in a lateral position	1	092-002835-00000

Transparent cover lens



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Oration still possible thanks to recesses for the rotary knobs

Version	
	for HP-XQ/Taurus Steel puls/Taurus Steel Synergic/Taurus Basic S

Designation	PU stk	Item no.
Transparent cover lens for wire feed controls	1	092-003478-00000

ON CC D01



- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Designation	PU stk	Item no.
Transparent cover cap for protecting the control	1	092-002834-00000

ON CONNECTOR D01/D02



- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Designation	Length m	PU stk	Item no.
Connection for wire feeding from drum	-	1	092-002842-00000
Connection for large spool/drum	-	1	094-011517-00000
Wire guide	1.8	1	094-011515-00004
	3.0	1	094-011515-00000
	4.5	1	094-011515-00001
	8.0	1	094-011515-00002
	12.0	1	094-011515-00003

Drive 4 Basic S D200 options

ON PS Trolley 55-5 / 55-6 drive D200



- Pivot support for D200 wire feeders
- Necessary for safe installation of D200 wire feeder on ON PS Trolley 55-5/55-6
- Wire feeder pivots 360° on the welding machine
- Option 092-002712-00000 is absolutely necessary to connected a wire feeder!
- For drive D200 on Trolley 55-5/55-6

Designation	PU stk	Item no.
Pivot support for D200 wire feeders	1	092-002634-00000

Transparent cover lens



- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Operation still possible thanks to recesses for the rotary knobs

Version	PU stk	Item no.
for HP-XQ/Taurus Steel puls/Taurus Steel Synergic/Taurus Basic S	1	092-003479-00000

Intermediate drive • miniDrive

- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- 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
- Hose packages length up to 25 m possible
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m!
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- Connection capability for remote control
- It is not possible to supply the miniDrive ex works with Phoenix 355 TKM, Taurus 355 TKM/TKW and Picomig 355 machines. We are happy to offer you a customised solution. Please contact our Service Department if you are interested in such a solution.

miniDrive WS



Wire feed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for gas-cooled torches	10.0	1	090-005262-00110
	15.0	1	090-005262-00115
	20.0	1	090-005262-00120
	25	1	090-005262-00125
miniDrive with hose package for water-cooled torches	10.0	1	090-005262-01110
	15.0	1	090-005262-01115
	20.0	1	090-005262-01120
	25	1	090-005262-01125

miniDrive WS V+A



- miniDrive with hose package for water-cooled torches with volt and ammeter
- Utilisation of function torch with X technology not possible

Wire feed m/min	1 m/min: 20 m/min
Welding current	400 A
Roller diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Cross-section	70 mm ²
Weight without accessories	7.5 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Length m	PU stk	Item no.
miniDrive with hose package for water-cooled welding torches with voltmeter and ammeter	10.0	1	090-005396-01110
	15.0	1	090-005396-01115
	20.0	1	090-005396-01120
	25	1	090-005396-01125

Gas-cooled

- Gas-cooled intermediate hose package
- 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

MIG G 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-000580-00000
	5.0	1	094-000580-00001
	10.0	1	094-000580-00002
	15.0	1	094-000580-00005
	20.0	1	094-000580-00003
	30	1	094-000580-00006

MIG G 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-007726-00000
	5.0	1	094-007726-00001
	10.0	1	094-007726-00002
	15.0	1	094-007726-00003
	20.0	1	094-007726-00004
	30	1	094-007726-00005
	40	1	094-007726-00007

Taurus Basic S system components - Intermediate hose packages

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG W 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000406-00000
	5.0	1	094-000406-00001
	10.0	1	094-000406-00002
	15.0	1	094-000406-00004
	20.0	1	094-000406-00005
	30	1	094-000406-00006

MIG W 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000407-00000
	5.0	1	094-000407-00001
	10.0	1	094-000407-00002
	15.0	1	094-000407-00006
	20.0	1	094-000407-00007
	30	1	094-000407-00003
	40	1	094-000407-00008

Remote control Taurus Basic S

RG11



- Remote control to set the wire feed 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 feed (0.5–24 m/min)
- With pre-fitted 5-m connection cable

Weight	0.7 kg
Cable length	5
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	PU stk	Item no.
Remote control to set the wire feed and welding voltage	1	090-008107-00000

R11



- Remote control to set the wire feed and welding voltage
- Infinite setting of the welding voltage (10–50 V)
- Infinitely variable setting of wire-feed feed (0.5–24 m/min)
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Weight	1 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control to set the wire feed and welding voltage	1	090-008601-00502

Connection cables



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection	19-pole
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Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	w

Overview Taurus Basic

MIG/MAG welding machines		Page	
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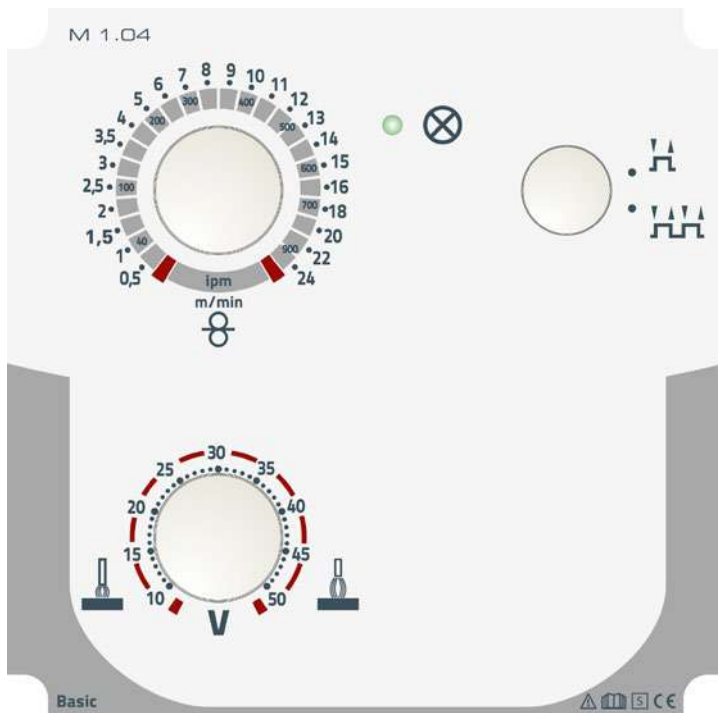
Control overview Taurus 400 Basic



Oration mode	Twin-knob oration
Welding process	MIG/MAG
	MMA
Orating modes	Non-latched
Parameters in display	Welding current
	Welding voltage
MMA functions	Hotstart
	Antistick
	Arcforce

- Manual orating point setting using wire feed sed and welding voltage
- Mixed gas or CO2 characteristics – simply press button to change over
- Infinitely adjustable arc dynamics (choke effect) from soft to hard
- Adjusted parameters for welding with mixed gas or 100% CO2 at the push of a button

Taurus Basic 400 wire feeder



Oration mode	Twin-knob oration
Welding process	MIG/MAG
	MMA

- Twin-knob oration: configuration of orating point using wire feed sed and welding voltage

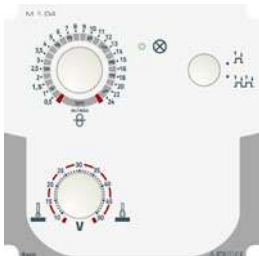
Taurus 400 Basic



Taurus Basic



drive 4L Basic



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Welding torches	Page	279
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- MIG/MAG welding machine with separate Taurus drive 4L Basic wire feeder
- **Welding procedures and functions**
- 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
- **Your benefits**
- Robust design suitable for construction site use
- Impact-resistant casing
- Inscted protection against splash water (IP-34s)
- Energy-saving thanks to high efficiency and standby function

Version	Taurus 400 Basic
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	539 x 210 x 415
Weight, machine	23.5 kg
EMC class	A
Insulation class	H
Protection class	IP34s
Approvals	
Wire sed m/min	0.5 m/min - 24 m/min
Wire sed ipm	19.68 ipm - 944.88 ipm

Ty	Designation	PU	Item no.
		stk	
Taurus 400 Basic TDG	MIG/MAG inverter welding machine, portable	1	090-005446-00502
Taurus drive 4L Basic	Wire feeder	1	090-005447-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000

► * Only the items in bold are included in the total

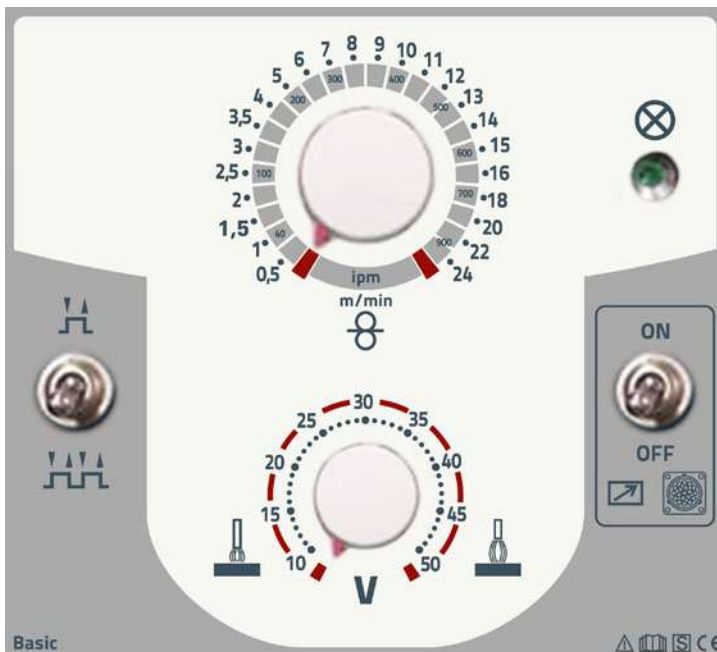
Control description machine controller Taurus Basic



Oration mode	Twin-knob oration
Welding process	MIG/MAG
	MMA
	Gouging
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
	Error code
MMA functions	Hotstart
	Arcforce
	Antistick

- Twin-knob oration: Configuration of orating point using wire feed sed and welding voltage

Control description Basic wire feeder



Oration mode	Twin-knob oration
Welding process	MIG/MAG
	MMA
	Gouging

- Twin-knob oration: configuration of orating point using wire feed sed and welding voltage

Taurus 355 Basic TKM






Basic



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- Compact inverter welding machine with Basic control and integrated wire feed mechanism
- **Welding procedures and functions**
- Manual twin-knob oration (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)
- **Your benefits**
- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- 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 (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)



Version	Taurus 355 Basic
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	36 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	  
Wire sed m/min	0.5 m/min - 25 m/min
Wire sed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Taurus 355 Basic TKM

Taurus 355 Basic compact gas cooled

Ty	Designation	PU	Item no.
Taurus 355 Basic TKM	Multiprocess MIG/MAG welding machine, compact with eFeed drive, portable, Basic control	1	090-005406-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 Basic compact water cooled

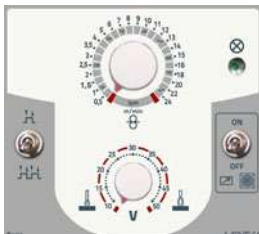
Ty	Designation	PU	Item no.
Taurus 355 Basic TKM	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	1	090-005406-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 355 | 405 | 505 Basic TDM



drive 4 Basic



Basic



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- Inverter welding machine with separate drive 4 Basic wire feeder and Basic control
- **Welding procedures and functions**
- Manual twin-knob oration (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)
- **Your benefits**
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Depiction in combination with Trolley 55-5, Drive 4 Basic and Cool50-2 U40 – other wire feeders and components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)

Version	Taurus 355	Taurus 405	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 20 A	3 x 32 A	
On circuit voltage	79 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	88 %	90 %	
Dimensions machine, LxWxH in mm	625 x 298 x 531		
Weight, machine	41 kg		44.2 kg
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals			
Wire feeder, LxWxH in mm	660 x 280 x 380		
Wire feeder weight	12 kg		
Dimensions cooling unit in mm	695 x 298 x 329		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1068 x 540 x 1150		
Trolley weight	35 kg		

Taurus 355 | 405 | 505 Basic TDM

Taurus 355 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 355 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005286-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 355 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005286-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 19POL 70qmm 450A/60% 1m		1	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		1	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		1	094-009082-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 405 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005241-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 405 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 405 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005241-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 19POL 70qmm 450A/60% 1m		1	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		1	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		1	094-009082-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolley 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolley 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 355 | 405 | 505 Basic TDM

Taurus 505 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005221-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 95qmm 550A/60% 1m		1	094-011091-00000
MIG G 19POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011091-00001
MIG G 19POL 95qmm 550A/60% 10m		1	094-011091-00002
MIG G 19POL 95qmm 550A/60% 15m		1	094-011091-00005
PM 401 G M9 3 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00000
PM 401 G M9 4 m		1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
ON Case	Tool box for mounting to transport cart Trolly 55-5/Trolly 55-6	1	092-002899-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 505 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005221-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
cool50-2 U40	Cooling unit with centrifugal pump	1	090-008603-00502
MIG W 19POL 95qmm 550A/60% 1m		1	094-009083-00000
MIG W 19POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009083-00001
MIG W 19POL 95qmm 550A/60% 10m		1	094-009083-00002
MIG W 19POL 95qmm 550A/60% 15m		1	094-009083-00005
PM 551 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700005-00000
PM 551 W M9 4 m		1	094-700005-00004
PM 551 W M9 5 m		1	094-700005-00005
PM 551 W M9 6,5 m		1	094-700005-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolly 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON TR Trolly 55-5 / 55-6	Cross arm and holder for wire feeder	1	092-002700-00000
ON PS Trolly 55-5 / 55-6	Pivot support (360°) for wire feeders	1	092-002712-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Set Taurus 505 Basic Duo Gouging



- Scial set for gouging consisting of two Taurus 505 Basic
- Gouging with up to 13 mm carbon electrode (1000 A)
- **Welding procedures and functions**
- 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
- **Your benefits**
- High on circuit voltage for excellent ignition characteristics
- Trolley 39-1 trolley available for delivery
- Save electricity through standby function
- Protective earth monitoring ()

Version	Set Taurus 505 Basic Duo Gouging
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 %

Basic



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Ty	Designation	PU stk	Item no.
Set Taurus 505 Basic Duo Gouging	Set consisting of 2 Taurus 505 Basic, remote control, gouging torch, workpiece lead, transport cart	1	092-008313-00000

Taurus 505 Basic for gouging



Basic



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- Inverter welding machine, DC
- **Welding procedures and functions**
- Suitable for MMA welding at no extra charge
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Gouging with up to 8 mm carbon electrodes
- GMAW welding with separate drive 4 Basic wire feeder and Basic control possible
- Infinitely adjustable arc dynamics (choke effect)
- **Your benefits**
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control and function torch



Version	Taurus 505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 32 A
On circuit voltage	79 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 machine, LxWxH in mm	625 x 298 x 531
Weight, machine	44.2 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	S CE EAC

Ty	Designation	PU	Item no.
Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	1	090-005221-00502
GT 600 SKK95	Gouging torch	1	094-016099-00000
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
EH 95m² 550A/60% 4m	Electrode holder with cable	1	092-000010-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 Basic FKG



- Compact MIG/MAG inverter welding machine with integrated wire feeder and Basic control
- **Welding procedures and functions**
 - Manual twin-knob oration (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)
- **Your benefits**
 - High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
 - 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 (protection)
 - Connection capability for remote control and function torch

Basic



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Version	Taurus 351	Taurus 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003	
Weight, machine	110 kg	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals		
Wire sed m/min	0.5 m/min - 25 m/min	
Wire sed ipm	19.68 ipm - 944.88 ipm	

Taurus 351 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 351 Basic FKG	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, gas cooled, Basic control	1	090-005425-00502
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 351 | 401 Basic FKG

Taurus 401 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 401 Basic FKG	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, gas cooled, Basic control	1	090-005426-00502
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 Basic FKW



- Compact MIG/MAG inverter welding machine with Basic control and integrated wire feed mechanism
- **Welding procedures and functions**
 - Manual twin-knob oration (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)
- **Your benefits**
 - High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
 - Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
 - 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 (protection)
 - Connection capability for remote control and function torch
 - Excellent torch cooling, resulting in cost savings on consumables due to high-rfor- performance centrifugal pump and 12-litre water tank

Basic



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Version	Taurus 351	Taurus 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003	
Weight, machine	121.5 kg	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals		
Wire sed m/min	0.5 m/min - 25 m/min	
Wire sed ipm	19.68 ipm - 944.88 ipm	

Taurus 351 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 351 Basic FKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, water-cooled	1	090-005419-00502
PM 451 W M9 3 m	MIG/MAG welding torch, water-cooled	1	094-700004-00000
PM 451 W M9 4 m		1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 351 | 401 Basic FKW

Taurus 401 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 401 Basic FKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, water-cooled	1	090-005408-00502
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

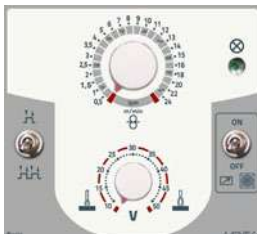
► * Only the items in bold are included in the total

Taurus 351 | 401 | 451 | 551 Basic FDG



- Inverter welding machine with separate drive 4 Basic wire feeder and Basic control
- **Welding procedures and functions**
- Manual twin-knob oration (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)
- **Your benefits**
- Depiction in combination with Drive 4 Basic – other wire feeders and components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Connection capability for remote control and function torch




drive 4 Basic



Basic



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Version	Taurus 351	Taurus 401	Taurus 451	Taurus 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	107 kg		118 kg	
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	  			
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	12 kg			

Taurus 351 | 401 | 451 | 551 Basic FDG

Taurus 351 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 351 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	1	090-005389-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 401 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	1	090-005249-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 451 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 451 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	1	090-005176-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m		1	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m	Intermediate hose package, gas-cooled, 19-pole	1	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		1	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		1	094-011063-00004
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 551 Basic gas cooled

Ty	Designation	PU	Item no.
Taurus 551 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	1	090-005178-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG G 19POL 95qmm 550A/60% 1m		1	094-011091-00000
MIG G 19POL 95qmm 550A/60% 5m	Intermediate hose package, gas-cooled,	1	094-011091-00001
MIG G 19POL 95qmm 550A/60% 10m	19-pole	1	094-011091-00002
MIG G 19POL 95qmm 550A/60% 15m		1	094-011091-00005
PM 401 G M9 3 m		1	094-700002-00000
PM 401 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700002-00004
PM 401 G M9 5 m		1	094-700002-00005
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus 351 | 401 | 451 | 551 Basic FDW



drive 4 Basic



Basic



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- Water-cooled welding machine with separate drive 4 Basic wire feeder and Basic control






● **Welding procedures and functions**

- Manual twin-knob oration (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)

● **Your benefits**

- Depiction in combination with Drive 4 Basic – other wire feeders and components can be found in the corresponding chapters on accessories
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Connection capability for remote control and function torch
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank

Version	Taurus 351	Taurus 401	Taurus 451	Taurus 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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 machine, LxWxH in mm	1085 x 450 x 1003			
Weight, machine	118 kg		129 kg	
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals	  			
Wire feeder, LxWxH in mm	660 x 280 x 380			
Wire feeder weight	12 kg			

Taurus 351 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 351 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	1	090-005390-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m		1	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		1	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		1	094-009082-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 401 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 401 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	1	090-005250-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m		1	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		1	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		1	094-009082-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 451 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 451 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	1	090-005150-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m		1	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		1	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		1	094-009082-00004
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Taurus 351 | 401 | 451 | 551 Basic FDW

Taurus 551 Basic water cooled

Ty	Designation	PU	Item no.
Taurus 551 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	1	090-005151-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	1	090-005401-00502
MIG W 19POL 95qmm 550A/60% 1m		1	094-009083-00000
MIG W 19POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled, 19-pole	1	094-009083-00001
MIG W 19POL 95qmm 550A/60% 10m		1	094-009083-00002
MIG W 19POL 95qmm 550A/60% 15m		1	094-009083-00005
PM 451 W M9 3 m		1	094-700004-00000
PM 451 W M9 4 m	MIG/MAG welding torch, water-cooled	1	094-700004-00004
PM 451 W M9 5 m		1	094-700004-00005
PM 451 W M9 6,5 m		1	094-700004-00065
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Taurus Basic system components - Wire feed units

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 as well as transparent cover cap for protection of the control system
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical rsonnel can change hose packages without tools
- eFeed: Innovative 4-roll drive (4x toothed)
 - Double ball bearings r axle
 - Tool-free roll change, rmanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel

drive 4 Basic



Wire sed m/min	0.5 m/min: 25 m/min
Wire sed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Wire feeder weight	12 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	Model	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	Wire feeder	1	090-005401-00502
Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	Wire feeder with connection for electrode holder or gouging torch	1	090-005401-51502

Drive 4 Basic options

ON Flowmeter



- Flow meter for manual shielding gas flow setting
- Precise setting and checking of the gas quantity at the welding site
- Extremely advantageous with long hose packages, e.g. for shipbuilding and steel construction

Designation	PU stk	Item no.
Analogue gas flow rate adjustment with gas flow meter option	1	092-003374-00000

ON TS D01/D02



- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Designation	PU stk	Item no.
Torch holder for drive XQ, drive 4X, drive 4 Basic and drive 4X IC	1	092-002836-00000

ON WAK D01



- Wheel kit
- Ensures limitless mobility
- Large rolls (Ø 125 mm) for optimal freedom of movement
- One roll with locking brake

Designation	PU stk	Item no.
Wheel assembly kit	1	092-002844-00000

ON PS EXT D01



- Turning mandrel extension – allows a wire feeder with a wheel kit to be attached to the wire feeder pivot support
- Fast assembly – the extension is simply inserted onto the mandrel of the pivot support and secured
- A wire feeder pivot support is absolutely required for use
- Cannot be used with gas-cooled, mobile machines and Trolley 55-5/55-6!

Designation	PU stk	Item no.
Turning mandrel extension, for mounting a wire feeder with wheel assembly kit	1	092-002871-00000

ON RFAK drive



- Rubber feet to replace sliding rails

Designation	PU stk	Item no.
Rubber feet	1	092-002845-00000

ON GK drive



- Stainless steel runners

Designation	PU stk	Item no.
Stainless steel runners	1	092-003030-00000

ON CMF D01



- Crane suspension for safe and easy transportation
- Maximum mobility even during suspension operations

Designation	PU stk	Item no.
Crane suspension	1	092-002833-00000

ON TCC D01



- 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

Designation	PU stk	Item no.
Set comprised of crane suspension bracket and protective plate, for using the wire feeder in a lateral position	1	092-002835-00000

ON CC D01



- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Designation	PU stk	Item no.
Transparent cover cap for protecting the control	1	092-002834-00000

ON CONNECTOR D01/D02



- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Designation	Length m	PU stk	Item no.
Connection for wire feeding from drum		1	092-002842-00000
Connection for large spool/drum		1	094-011517-00000
Wire guide	1.8	1	094-011515-00004
	3.0	1	094-011515-00000
	4.5	1	094-011515-00001
	8.0	1	094-011515-00002
	12.0	1	094-011515-00003

Taurus Basic system components - Wire feed units

drive 4 IC

- 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
 - Tool-free roll change, permanently secured roll fasteners
 - Adjustable contact pressure for each roll pair
 - Rolls colour-coded for wire diameter and material
- Equipped with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

drive 4 IC Basic



Wire speed m/min	0.5 m/min: 25 m/min
Wire speed ipm	19.68 ipm: 944.88 ipm
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Wire feeder weight	21.3 kg
Torch connection	Euro torch connector
EMC class	A
Protection class	IP23

Designation	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	1	090-005416-00502

Drive 4 Basic IC options

ON WAKD D.0002



- 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)!

Designation	PU stk	Item no.
Wheel assembly kit for drive 4 IC and drive 4/41	1	090-008035-00000

Taurus Basic system components - Intermediate hose packages

Gas-cooled

- Gas-cooled intermediate hose package
- 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

MIG G 19POL 70qmm 450A/60%



Connection	19-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 19-pole	1.0	1	094-011063-00000
	5.0	1	094-011063-00001
	10.0	1	094-011063-00002
	15.0	1	094-011063-00004
	20.0	1	094-011063-00003
	30	1	094-011063-00006

MIG G 19POL 95qmm 550A/60%



Connection	19-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 19-pole	1.0	1	094-011091-00000
	5.0	1	094-011091-00001
	10.0	1	094-011091-00002
	15.0	1	094-011091-00005
	20.0	1	094-011091-00003
	30	1	094-011091-00004
	40	1	094-011091-00006

Taurus Basic system components - Intermediate hose packages

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG W 19POL 70qmm 450A/60%



Connection	19-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 19-pole	1.0	1	094-009082-00000
	5.0	1	094-009082-00001
	10.0	1	094-009082-00002
	15.0	1	094-009082-00004
	20.0	1	094-009082-00005
	30	1	094-009082-00006

MIG W 19POL 95qmm 550A/60%



Connection	19-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length	PU	Item no.
	m		
Intermediate hose package, water-cooled, 19-pole	1.0	1	094-009083-00000
	5.0	1	094-009083-00001
	10.0	1	094-009083-00002
	15.0	1	094-009083-00005
	20.0	1	094-009083-00003
	30	1	094-009083-00004
	40	1	094-009083-00006

Remote control Taurus Basic

RG11



- Remote control to set the wire feed 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 feed (0.5–24 m/min)
- With pre-fitted 5-m connection cable

Weight	0.7 kg
Cable length	5
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	PU stk	Item no.
Remote control to set the wire feed and welding voltage	1	090-008107-00000

R11



- Remote control to set the wire feed and welding voltage
- Infinite setting of the welding voltage (10–50 V)
- Infinitely variable setting of wire-feed feed (0.5–24 m/min)
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Weight	1 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control to set the wire feed and welding voltage	1	090-008601-00502

Connection cables



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

Remote control/accessories Taurus Basic 400

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
- Orating point setting directly at the site of welding

Weight	0.7 kg
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	Cable length m	PU stk	Item no.
Remote control, current	5.0	1	090-008106-00000
	10.0	1	090-008106-00010

RT1



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	1.2 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control, current	1	090-008097-00000

Connection cables



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection	19-pole
-------------------	---------

Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

ON Filter TG.0001



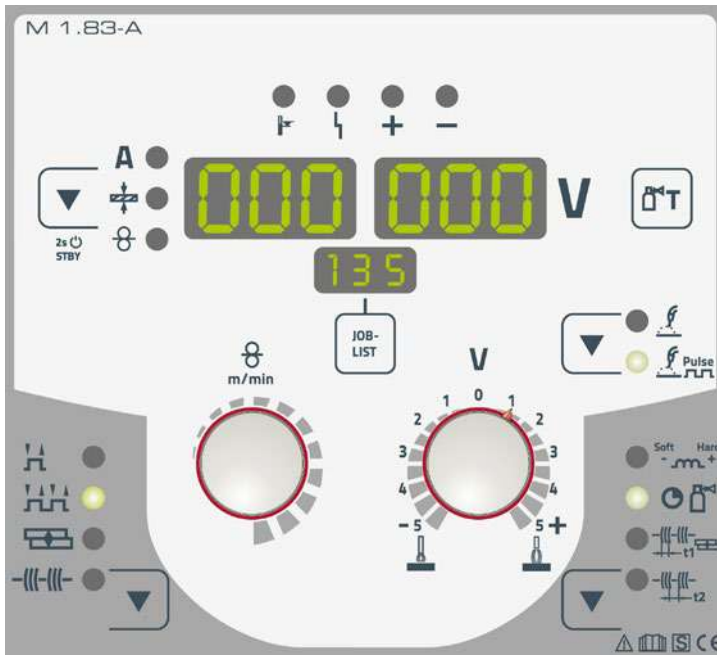
- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	ww

Overview Picomig puls / Picomig Synergic

MIG/MAG welding machines		Page		
Picomig	Overview of controls	Control description Picomig puls	222	
		Control description Picomig Synergic	223	
	Gas-cooled	Picomig 180 puls	224	
		Picomig 180 Synergic	226	
		Picomig 185 puls	228	
		Picomig 185 Synergic	230	
		Modular design	Picomig 355 puls	232
			Picomig 355 Synergic	234

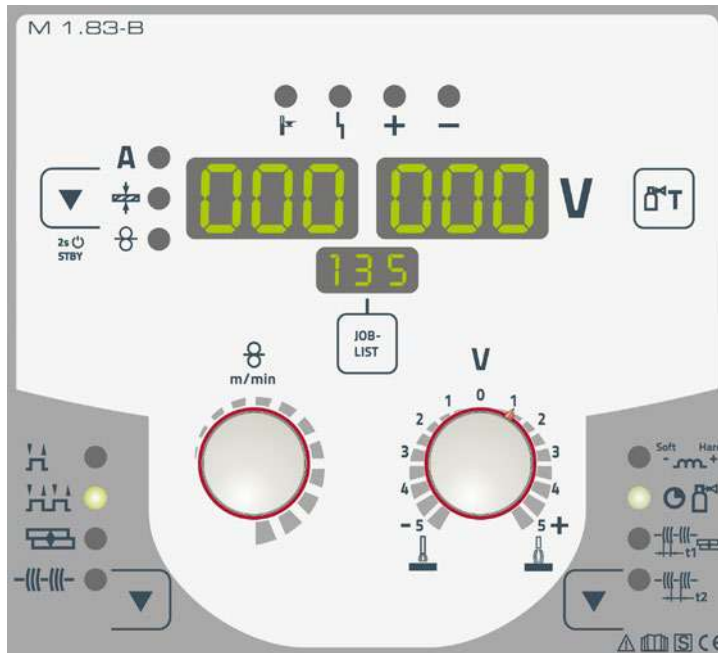
Control description Picomig puls



Oration mode	Synergic oration
Welding process	MIG/MAG
	MIG/MAG pulse
	TIG
	MMA
	forceArc®
	forceArc puls®
	rootArc®
	rootArc puls®
Parameters in display	Welding current
	Wire feed sed
	Plate thickness
	JOB number
	Error code
	Polarity display
Number of JOBS	122
MMA functions	Hotstart
	Arcforce
	Antistick

- Setting of all welding parameters and functions – easy setting of orating point, pre-programmed JOBS (welding tasks) can be selected from JOB list
- Please note:
- Number of JOBS in Picomig 355: 122. Number of JOBS in Picomig 180/185: 50
- The innovative rootArc and forceArc processes are only available in the Picomig 355 variant

Control description Picomig Synergic



- Setting of all welding parameters and functions – easy setting of orating point, pre-programmed JOBS (welding tasks) can be selected from JOB list
- Please note:
- Number of JOBS in Picomig 355: 73. Number of JOBS in Picomig 180/185: 35
- The innovative rootArc and forceArc processes are only available in the Picomig 355 variant

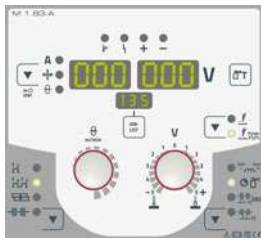
Oration mode	Synergic oration
Welding process	MIG/MAG
	TIG
	MMA
	forceArc®
	rootArc®
Orating modes	Non-latched
Parameters in display	Welding current
	Wire feed sed
	Plate thickness
	JOB number
	Error code
	Polarity display
Number of JOBS	73
MMA functions	Hotstart
	Arcforce
	Antistick

Picomig 180 puls

/Pulse



Picomig Puls



Control	Page	222
Wire feed rolls	Page	267
Welding torches	Page	279

- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob oration and integrated wire feeder
- **Welding procedures and functions**
- GMAW pulsed welding and GMAW standard welding
- Synergic characteristics for steel, CrNi and aluminium
- MMA welding and TIG lift arc welding
- rfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- Synergic or manual welding oration
- Non-latched/latched oration
- Interval welding
- Adjustable gas pre- and post-flow time
- **Your benefits**
- Portable, compact
- Saves power through highly efficient rformance
- Robust casing suitable for construction site use
- 4-Rollen-Swissfeed-Antrieb. Ausgerüstet für 0,8 mm + 1,0 mm Stahldrähte
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Wire spool diameter up to 200 mm/D200
- 3.5 m mains supply lead with 16 A shock-proof plug
- 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
- **Overtoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**



Version	Picomig 180 puls
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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 machine, LxWxH in mm	559 x 276 x 340
Weight, machine	16 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire sed m/min	1 m/min - 15 m/min
Wire sed ipm	39.37 ipm - 590.55 ipm

Ty	Designation	PU	Item no.
Picomig 180 puls TKG	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	1	090-005545-00502
PM 221 G M7 3 m		1	094-700000-00000
PM 221 G M7 4 m	MIG/MAG welding torch, gas-cooled	1	094-700000-00004
PM 221 G M7 5 m		1	094-700000-00005
WK25mm² 230A/60% 4m/K	Workpiece lead with clamp	1	092-000016-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Picomig 180 puls TKG Set	Set, Picomig 180 puls (single machine): MIG 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	1	091-005545-00502
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

6x Picomig 180 puls Packing unit: 6 x Picomig 180 puls 092-015321-00502

ON 15KG Picomig

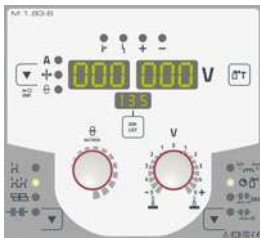


Ty	Designation	PU	Item no.
ON Trolley Picomig	Trolley Picomig 180 with holder for 300 mm wire spool	1	092-000312-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Picomig 180 Synergic



Picomig Synergic



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- Multiprocess inverter welding machine with easy Synergic one-knob oration and integrated wire feed mechanism



- **Welding procedures and functions**

- GMAW standard welding
- Synergic characteristics for steel, CrNi and aluminium
- MMA welding and TIG lift arc welding
- rfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- Non-latched/latched oration
- Interval welding
- Adjustable gas pre- and post-flow time

- **Your benefits**

- Portable, compact
- Saves power through highly efficient rformance
- Robust casing suitable for construction site use
- 4-Rollen-Swissfeed-Antrieb. Ausgerüstet für 0,8 mm + 1,0 mm Stahldrähte
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Wire spool diameter up to 200 mm/D200
- 3.5 m mains supply lead with 16 A shock-proof plug
- 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
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Version	Picomig 180 Synergic
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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 machine, LxWxH in mm	559 x 276 x 340
Weight, machine	16 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire sed m/min	1 m/min - 15 m/min
Wire sed ipm	39.37 ipm - 590.55 ipm

Ty	Designation	PU	Item no.
Picomig 180 Synergic TKG	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	1	090-005546-00502
PM 221 G M7 3 m		1	094-700000-00000
PM 221 G M7 4 m	MIG/MAG welding torch, gas-cooled	1	094-700000-00004
PM 221 G M7 5 m		1	094-700000-00005
WK25mm² 230A/60% 4m/K	Workpiece lead with clamp	1	092-000016-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
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	1	091-005546-00502
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit		
6x Picomig 180 Synergic	Packing unit: 6 x Picomig 180 Synergic	092-015323-00502

ON 15KG Picomig



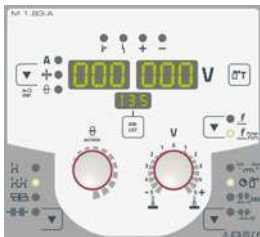
Ty	Designation	PU	Item no.
ON Trolley Picomig	Trolley Picomig 180 with holder for 300 mm wire spool	1	092-000312-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Picomig 185 puls

/Pulse



Picomig Puls



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- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob oration and integrated wire feeder
- **Welding procedures and functions**
 - GMAW pulsed welding and GMAW standard welding
 - Synergic characteristics for steel, CrNi and aluminium
 - MMA welding and TIG lift arc welding
 - rfect for welding self-shielding flux cored wires
 - Infinitely adjustable arc dynamics (choke effect)
 - Synergic or manual welding oration
 - Non-latched/latched oration
 - Interval welding
 - Adjustable gas pre- and post-flow time
- **Your benefits**
 - Portable, compact
 - Saves power through highly efficient rformance
 - 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
 - Equiped with 0.8/0.9/1.0 mm UNI rolls for low to high-alloy steel
 - Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
 - Easy, tool-free change of welding polarity
 - Earth fault monitoring (protection)
 - IP23 spray water protected
 - 3.5 m mains supply lead with 16 A shock-proof plug
 - 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
 - **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**



Version	Picomig 185 puls
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	23.8 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire sed m/min	0.5 m/min - 25 mm/min
Wire sed ipm	19.68 ipm - 944.88 ipm

Ty	Designation	PU	Item no.
Picomig 185 puls TKG	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	1	090-005547-00502
PM 221 G M7 3 m		1	094-700000-00000
PM 221 G M7 4 m	MIG/MAG welding torch, gas-cooled	1	094-700000-00004
PM 221 G M7 5 m		1	094-700000-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

6x Picomig 185 puls

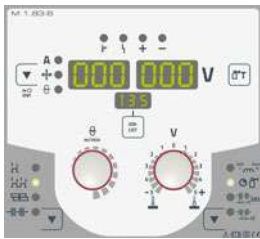
Packing unit: 6 x Picomig 185 puls

092-015324-00502

Picomig 185 Synergic



Picomig Synergic



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- Multiprocess inverter welding machine with easy Synergic one-knob oration and integrated wire feed mechanism






● **Welding procedures and functions**

- GMAW standard welding
- Synergic characteristics for steel, CrNi and aluminium
- MMA welding and TIG lift arc welding
- rfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- Non-latched/latched oration
- Interval welding
- Adjustable gas pre- and post-flow time

● **Your benefits**

- Portable, compact
- Saves power through highly efficient rformance
- 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
- Equipd with 0.8/0.9/1.0 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- 3.5 m mains supply lead with 16 A shock-proof plug
- 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
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Version	Picomig 185 Synergic
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	23.8 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	  
Wire sed m/min	0.5 m/min - 25 mm/min
Wire sed ipm	19.68 ipm - 944.88 ipm

Ty	Designation	PU	Item no.
Picomig 185 Synergic TKG	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	1	090-005548-00502
PM 221 G M7 3 m		1	094-700000-00000
PM 221 G M7 4 m	MIG/MAG welding torch, gas-cooled	1	094-700000-00004
PM 221 G M7 5 m		1	094-700000-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

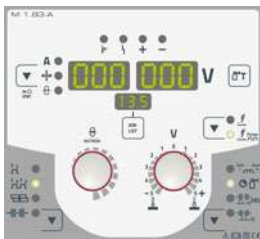
6x Picomig 185 Synergic Packing unit: 6 x Picomig 185 Synergic 092-015325-00502

Picomig 355 puls

/rootArc®/rootArc® puls
 /forceArc®/forceArc® puls
 /Impuls



Picomig Puls



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Welding torches	Page	279

- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob operation and integrated wire feeder
- **Welding procedures and functions**
- GMAW pulsed welding and GMAW standard welding
- EWM forceArc/forceArc puls characteristics for unalloyed steel
- EWM rootArc/rootArc puls characteristics for unalloyed steel
- Synergic characteristics for steel, CrNi and aluminium
- MMA welding and TIG lift arc welding
- Effect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- Synergic or manual welding operation
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre- and post-flow time
- **Your benefits**
- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- Saves power through highly efficient performance
- 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 with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control, function torch and cooling unit
- 5 m mains supply lead
- 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



Version	Picomig 355 puls
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	34.4 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire speed m/min	0.5 mm/min - 25 mm/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Ty	Designation	PU	Item no.
Picomig 355 puls TKM	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	1	090-005542-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Ty	Designation	PU	Item no.
Picomig 355 puls TKM	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	1	090-005542-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

6x Picomig 355 puls TKM

Packing unit: 6 x Picomig 355 puls

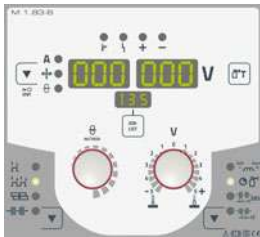
092-015327-00502

Picomig 355 Synergic

/rootArc[®]
/forceArc[®]



Picomig Synergic



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Wire feed rolls	Page	264
Welding torches	Page	279

- Multiprocess inverter welding machine with easy Synergic one-knob oration and integrated wire feed mechanism




● **Welding procedures and functions**

- GMAW standard welding
- EWM forceArc characteristics for unalloyed steel
- EWM rootArc characteristics for unalloyed steel
- Synergic characteristics for steel, CrNi and aluminium
- MMA welding and TIG lift arc welding
- rfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- Non-latched/latched oration
- Interval welding
- Adjustable gas pre- and post-flow time

● **Your benefits**

- Gas cooled or optionally water cooled with cool 50 U40 cooling unit
- Depiction in combination with Trolley 55-5 and Cool50 U40 – other components can be found in the corresponding chapters on accessories
- Saves power through highly efficient rformance
- 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
- Equipd with 1.0–1.2 mm UNI rolls for low to high-alloy steel
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (protection)
- IP23 spray water protected
- Connection capability for remote control, function torch and cooling unit
- 5 m mains supply lead
- 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

Version	Picomig 355 Synergic
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	636 x 298 x 482
Weight, machine	34.4 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire sed m/min	0.5 m/min - 25 m/min
Wire sed ipm	19.68 ipm - 944.88 ipm
Dimensions cooling unit in mm	695 x 298 x 329
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Ty	Designation	PU	Item no.
Picomig 355 Synergic TKM	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	1	090-005512-00502
PM 301 G M9 3 m		1	094-700001-00000
PM 301 G M9 4 m	MIG/MAG welding torch, gas-cooled	1	094-700001-00004
PM 301 G M9 5 m		1	094-700001-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
ON Case	Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Ty	Designation	PU	Item no.
Picomig 355 Synergic TKM	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	1	090-005512-00502
cool50 U40	Cooling unit with centrifugal pump	1	090-008598-00502
PM 301 W M7 3 m		1	094-700003-00000
PM 301 W M7 4 m	MIG/MAG welding torch, water-cooled	1	094-700003-00004
PM 301 W M7 5 m		1	094-700003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
Trolley 55-6	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1	090-008825-00000
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

6x Picomig 355 Synergic TKM

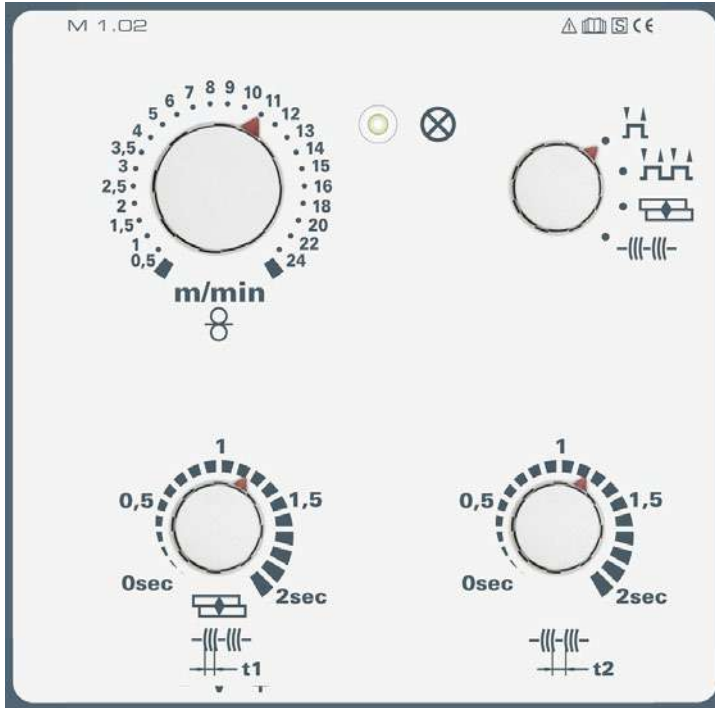
Packing unit: 6 x Picomig 355 Synergic

092-015326-00502

Overview Mira, Saturn, Wega

MIG/MAG welding machines		Page	
Step switch controlled welding machines	Overview of controls Mira, Saturn, Wega	M1.02	238
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		Mira 301 M2.20 - M2.40 FKG	242
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System components step switch controlled welding machines	Wire feed units	Saturn drive 41	258
		Wega drive 41	258
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	Options drive 41L – drive 41	259	
	Intermediate hose packages	Gas-cooled	260
Water-cooled		261	

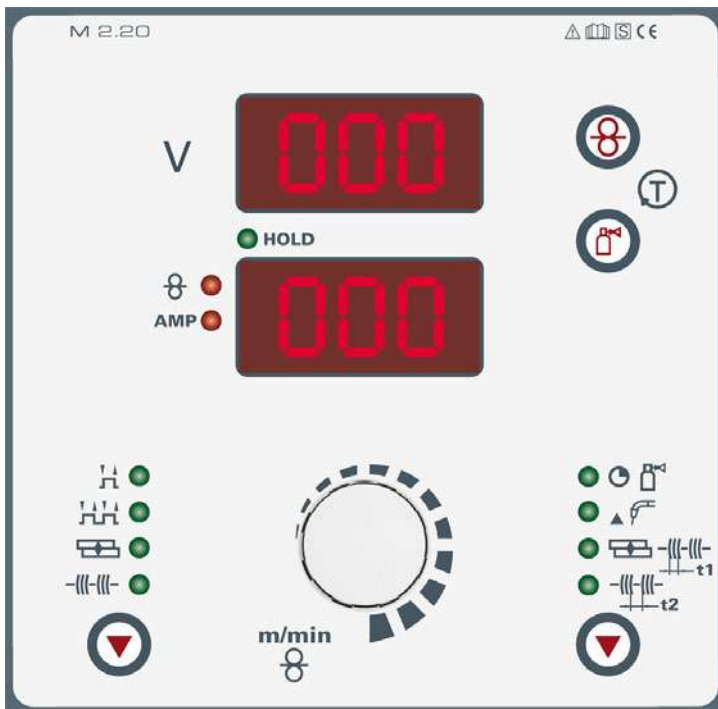
M1.02



Oration mode	Twin-knob oration
Welding process	MIG/MAG

- Twin-knob oration: configuration of orating point using wire feed sed and welding voltage
- Adjustable spot, interval and pause times

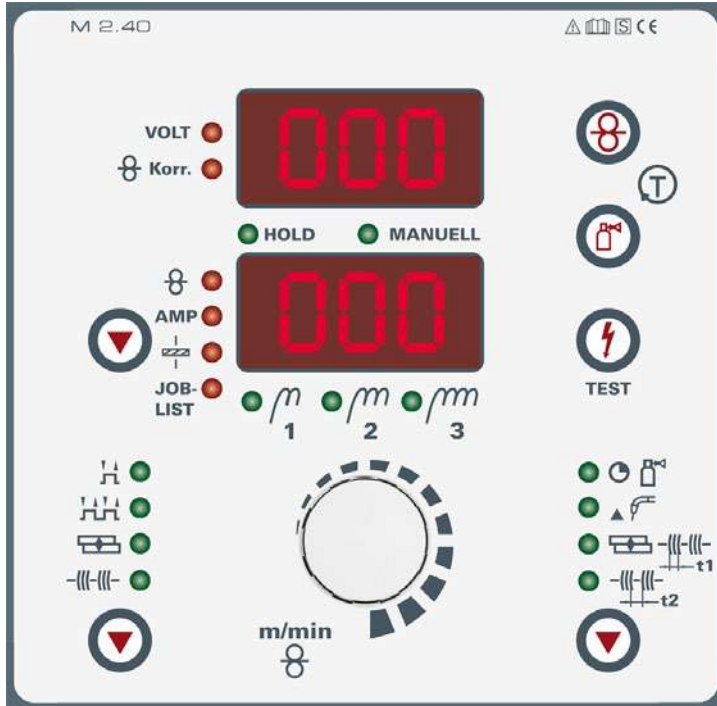
M2.20



Oration mode	Twin-knob oration
Welding process	MIG/MAG
Parameters in display	Welding current
	Welding voltage
	Wire feed sed

- Twin-knob oration: Configuration of orating point using wire feed sed and welding voltage, including parameter display
- Adjustable spot, interval, pause, gas post-flow and burn-back times

M2.40



Oration mode	Twin-knob oration
Welding process	MIG/MAG
Parameters in display	Welding current
	Welding voltage
	Wire feed sed
Number of JOBs	Plate thickness
	24

- Synergic one-knob oration: The orating point can be set with a single knob thanks to easy JOB (welding task) preselection
- Adjustable spot, interval, pause, gas post-flow and burn-back times

Mira 151 | 221 | 251 | 301 M1.02 FKG

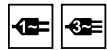


M1.02



Control	Page	238
Welding torches	Page	314
Wire feed rolls	Page	267

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Mira 151/Mira 221 MV: 2-roller wire feed. Equipd for 0.8 mm + 1.0 mm steel wires
- Mira 251/Mira 301: 4-roll drive. Equipd 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 oration – setting of the welding voltage and wire-feed sed
- 5 m mains supply lead with CEE 16 A plug
- Mira 151: 3.5 m mains supply lead with 16 A shock-proof plug



Version	Mira 151	Mira 221 MV	Mira 251	Mira 301
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)		3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	1 x 10 A	1 x 16 A	3 x 10 A	
On circuit voltage	35.5 V	14.3 V	32.4 V	38.2 V
Setting range for welding current	30 A - 150 A	30 A - 220 A	30 A - 250 A	30 A - 300 A
Duty cycle 40 °C	150 A / 15 %	220 A / 15 %	250 A / 20 %	300 A / 20 %
	55 A / 100 %	85 A / 100 %	125 A / 100 %	150 A / 100 %
cos φ	0.98		0.97	
Dimensions machine, LxWxH in mm	888 x 379 x 604			
Weight, machine	47 kg	56 kg	60 kg	72 kg
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				
Wire sed m/min	1.5 m/min - 15 m/min	1.5 m/min - 20 m/min		
Wire sed ipm	59.05 ipm - 590.55 ipm	59.05 ipm - 787.4 ipm		

Ty	Designation	PU	Item no.
Mira 151 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive	1	-
UM 15 G 3m		1	394-600000-00000
UM 15 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600000-00004
UM 15 G 5m		1	394-600000-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030

Ty	Designation	PU	Item no.
Mira 221 MV FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive	1	-
UM 25 G 3m		1	394-600002-00000
UM 25 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600002-00004
UM 25 G 5m		1	394-600002-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030

Ty	Designation	PU stk	Item no.
Mira 251 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	-
UM 25 G 3m		1	394-600002-00000
UM 25 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600002-00004
UM 25 G 5m		1	394-600002-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030

Ty	Designation	PU stk	Item no.
Mira 301 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	-
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030

► * Only the items in bold are included in the total

► Only available in packs of 2!

Mira packing units

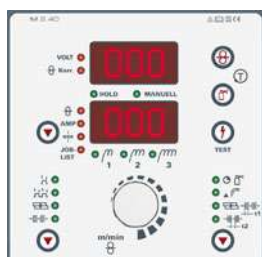
2x Mira 151 FKG	Packing unit: 2 x Mira 151 FKG	092-015238-00502
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG	092-015239-00502
2x Mira 251 FKG	Packing unit: 2 x Mira 251 FKG	092-015240-00502
2x Mira 301 M1.02 FKG	Packing unit: 2 x Mira 301 M1.02 FKG	092-015236-00502

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 oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the orating point thanks to pre-programmed JOBS (welding tasks), display of welding parameters
- 5 m mains supply lead with CEE 16 A plug

M2.40



M2.20



Version	Mira 301
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 10 A
On circuit voltage	38.2 V
Setting range for welding current	30 A - 300 A
Duty cycle 40 °C	300 A / 20 %
	150 A / 100 %
cos φ	0.97
Dimensions machine, LxWxH in mm	888 x 379 x 604
Weight, machine	72 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	

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Ty	Designation	PU	Item no.
Mira 301 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	-
Mira 301 M2.40 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	-
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030

▶ * Only the items in bold are included in the total

▶ 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
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 oration – setting of the welding voltage and wire-feed speed
- Protective earth monitoring ()
- Inert gas ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead

M1.02



Version	Saturn 301	Saturn 351
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 16 A	
On circuit voltage	15.5 V	41 V
Setting range for welding current	30 A - 300 A	30 A - 350 A
Duty cycle 40 °C	300 A / 40 %	350 A / 45 %
	190 A / 60 %	250 A / 60 %
	160 A / 100 %	220 A / 100 %
cos φ	0.97	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals	 	
Wire speed m/min	0.5 m/min - 24 m/min	
Wire speed ipm	19.68 ipm - 944.88 ipm	

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Ty	Designation	PU	Item no.
Saturn 301 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-004977-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Saturn 351 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-004983-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

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 oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the orating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Protective earth monitoring ()
- rfect ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead



M2.20



M2.40



Version	Saturn 301	Saturn 351
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 16 A	
On circuit voltage	38.2 V	41 V
Setting range for welding current	30 A - 300 A	30 A - 350 A
Duty cycle 40 °C	300 A / 40 %	350 A / 45 %
	190 A / 60 %	250 A / 60 %
	160 A / 100 %	220 A / 100 %
cos φ	0.97	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals		
Wire speed m/min	0.5 m/min - 24 m/min	
Wire speed ipm	19.68 ipm - 944.88 ipm	

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Ty	Designation	PU	Item no.
Saturn 301 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-004978-00502
Saturn 301 M2.40 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-004979-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK50mm ² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Saturn 351 M2.20 FKG	Step switch controlled MIG/MAG welding	1	090-004984-00502
Saturn 351 M2.40 FKG	machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-004985-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

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. Equiped for 0.8 mm + 1.0 mm steel wires
- M1.02: Twin-knob oration – setting of the welding voltage and wire-feed sed
- M2.20: Twin-knob oration – setting of welding voltage and wire feed sed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the orating point thanks to pre-programmed JOBS (welding tasks), display of welding parameters
- rfect ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead

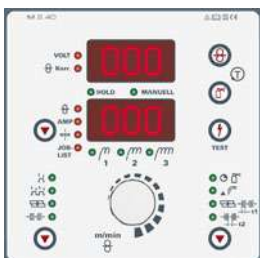
M1.02



M2.20



M2.40



Version	Saturn 351
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On circuit voltage	41 V
Setting range for welding current	30 A - 350 A
Duty cycle 40 °C	350 A / 45 %
	250 A / 60 %
	220 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	S CE EAC
Wire sed m/min	0.5 m/min - 25 m/min
Wire feeder, LxWxH in mm	690 x 300 x 410
Wire feeder weight	15.5 kg

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Ty	Designation	PU	Item no.
Saturn 351 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	1	090-004991-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
Saturn M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004995-00502
MIG G 7POL 50qmm 350A/60% 1m		1	094-000579-00000
MIG G 7POL 50qmm 350A/60% 5m	Intermediate hose package, gas-cooled, 7-pole	1	094-000579-00001
MIG G 7POL 50qmm 350A/60% 10m		1	094-000579-00002
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Ty	Designation	PU	Item no.
Saturn 351 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	1	090-004991-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
Saturn M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004996-00502
Saturn M2.40 drive 41L		1	090-004997-00502
MIG G 7POL 50qmm 350 A/60 % 1 m		1	094-000579-00000
MIG G 7POL 50qmm 350 A/60 % 5 m	Intermediate hose package, gas-cooled, 7-pole	1	094-000579-00001
MIG G 7POL 50qmm 350 A/60 % 10 m		1	094-000579-00002
WK50 mm² 350 A/60 % 4 m/K	Workpiece lead with clamp	1	092-000003-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32 A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M1.02 FKG





M1.02



Control	Page	238
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Wire feed rolls	Page	267

- 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 oration – setting of the welding voltage and wire-feed speed
- Protective earth monitoring ()
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Effect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	 
Wire speed m/min	0.5 m/min - 24 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm

Ty	Designation	PU	Item no.
Wega 401 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-005224-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M2.20 | M2.40 FKG



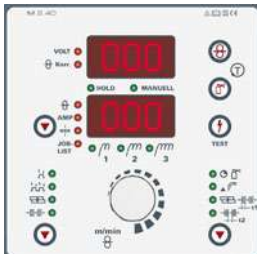
- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the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



M2.20



M2.40



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feed m/min	0.5 m/min - 24 m/min
Wire feed ipm	19.68 ipm - 944.88 ipm

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Ty	Designation	PU	Item no.
Wega 401 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	1	090-005225-00502
Wega 401 M2.40 FKG		1	090-005226-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M1.02 FKW



M1.02



Control	Page	238
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- 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 oration – setting of the welding voltage and wire-feed speed
- Protective earth monitoring ()
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Inert gas 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



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire speed m/min	0.5 m/min - 24 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm

Ty	Designation	PU	Item no.
Wega 401 M1.02 FKW	Step switch controlled MIG/MAG welding machine, compact, water-cooled, Euro torch connector, 4-roll drive	1	090-005227-00502
UM 401 W 4m		1	394-600011-00004
UM 401 W 3m	MIG/MAG welding torch, water-cooled	1	394-600011-00000
UM 401 W 5m		1	394-600011-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M2.20 | M2.40 FKW

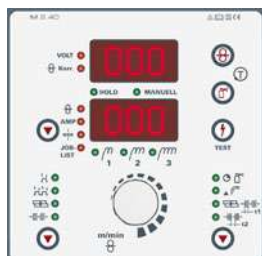


- MIG/MAG standard welding machine, step switch controlled, water-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the orating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Protective earth monitoring ()
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- rfect 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



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire speed m/min	0.5 m/min - 24 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm

Control	Page	238
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Ty	Designation	PU	Item no.
Wega 401 M2.20 FKW	Step switch controlled MIG/MAG welding machine, compact, water-cooled, Euro torch connector, 4-roll drive	1	090-005228-00502
Wega 401 M2.40 FKW	MIG/MAG welding machine, compact, water-cooled, Euro torch connector, 4-roll drive	1	090-005229-00502
UM 401 W 4m	MIG/MAG welding torch, water-cooled	1	394-600011-00004
UM 401 W 3m	MIG/MAG welding torch, water-cooled	1	394-600011-00000
UM 401 W 5m	MIG/MAG welding torch, water-cooled	1	394-600011-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 l, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M1.02 FDG






M1.02



- 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 oration – setting of the welding voltage and wire-feed speed
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires
- rfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	  
Wire feeder, LxWxH in mm	690 x 300 x 410
Wire feeder weight	18.2 kg

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Wire feed units	Page	258

Ty	Designation	PU	Item no.
Wega 401 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	1	090-004948-00502
UM 36 G 3m		1	394-600003-00000
UM 36 G 4m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5m		1	394-600003-00005
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004965-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00000
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 M2.20 | M2.40 FDG



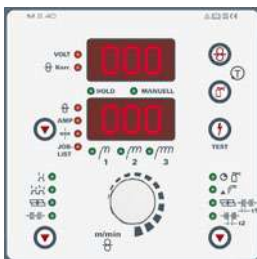
- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Decompact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: Synergic one-knob oration – easy setting of the orating 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
- rfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead



M2.20



M2.40



Version	Wega 401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 25 A
On circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 40 °C	400 A / 60 %
	300 A / 100 %
cos φ	0.97
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Wire feeder, LxWxH in mm	690 x 300 x 410
Wire feeder weight	18.2 kg

Control	Page	238
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Wire feed units	Page	258

Ty	Designation	PU	Item no.
Wega 401 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	1	090-004948-00502
UM 36 G 3 m		1	394-600003-00000
UM 36 G 4 m	MIG/MAG welding torch, gas-cooled	1	394-600003-00004
UM 36 G 5 m		1	394-600003-00005
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004966-00502
Wega M2.40 drive 41L		1	090-004967-00502
MIG G 7POL 70qmm 450 A/60 % 1 m	Intermediate hose package, gas-cooled, 7-pole	1	094-000580-00000
WK70 mm² 450 A/60 % 4 m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
OW CEE 32 A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Wega 401 | 501 | 601 M1.02 FDW



M1.02



Control	Page	238
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Wire feed rolls	Page	267
Wire feed units	Page	258

- MIG/MAG standard welding machine, step switch controlled, water-cooled
- M1.02: Twin-knob oration – setting of the welding voltage and wire-feed speed
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Inert gas 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



Version	Wega 401	Wega 501	Wega 601
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
On circuit voltage	45 V	49.5 V	57.5 V
Setting range for welding current	30 A - 400 A	50 A - 500 A	50 A - 600 A
Duty cycle 40 °C	400 A / 60 %	500 A / 60 %	600 A / 45 %
	300 A / 100 %	400 A / 100 %	450 A / 100 %
cos φ	0.97		
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals			
Wire feeder, LxWxH in mm	690 x 300 x 410		
Wire feeder weight	18.2 kg		

Ty	Designation	PU	Item no.
		stk	
Wega 401 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-004949-00502
UM 401 W 4m		1	394-600011-00004
UM 401 W 3m	MIG/MAG welding torch, water-cooled	1	394-600011-00000
UM 401 W 5m		1	394-600011-00005
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004965-00502
MIG W 7POL 70qmm 450A/60% 1m		1	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m	Intermediate hose package, water-cooled,	1	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m	7-pole	1	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		1	094-000406-00004
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Ty	Designation	PU stk	Item no.
Wega 501 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-005088-00502
UM 501 W 3m		1	394-600012-00000
UM 501 W 4m	MIG/MAG welding torch, water-cooled	1	394-600012-00004
UM 501 W 5m		1	394-600012-00005
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004965-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled,	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m	7-pole	1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Ty	Designation	PU stk	Item no.
Wega 601 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-005089-00502
UM 501 W 3m		1	394-600012-00000
UM 501 W 4m	MIG/MAG welding torch, water-cooled	1	394-600012-00004
UM 501 W 5m		1	394-600012-00005
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004965-00502
MIG W 7POL 95qmm 550A/60% 1m		1	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m	Intermediate hose package, water-cooled,	1	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m	7-pole	1	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		1	094-000407-00006
WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

► * Only the items in bold are included in the total

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 oration – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob oration (Synergic) – easy setting of the orating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires
- rfect ignition and welding by means of optimised choke with 3 tappings
- Powerful cooling system with centrifugal pump, pressure switch and 7 l tank. Temrature-controlled pump and fan
- 5 m mains supply lead



M2.20



M2.40



Version	Wega 401	Wega 501	Wega 601
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
On circuit voltage	45 V	49.5 V	57.5 V
Setting range for welding current	30 A - 400 A	50 A - 500 A	50 A - 600 A
Duty cycle 40 °C	400 A / 60 %	500 A / 60 %	600 A / 45 %
	300 A / 100 %	400 A / 100 %	450 A / 100 %
cos φ	0.97		
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	S CE EAC		
Wire feeder, LxWxH in mm	690 x 300 x 410		
Wire feeder weight	18.2 kg		

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Wire feed rolls	Page	267
Wire feed units	Page	258

Ty	Designation	PU	Item no.
Wega 401 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-004949-00502
UM 401 W 4 m		1	394-600011-00004
UM 401 W 3 m	MIG/MAG welding torch, water-cooled	1	394-600011-00000
UM 401 W 5 m		1	394-600011-00005
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004966-00502
Wega M2.40 drive 41L		1	090-004967-00502
MIG W 7POL 70qmm 450 A/60 % 1 m		1	094-000406-00000
MIG W 7POL 70qmm 450 A/60 % 5 m	Intermediate hose package, water-cooled,	1	094-000406-00001
MIG W 7POL 70qmm 450 A/60 % 10 m	7-pole	1	094-000406-00002
MIG W 7POL 70qmm 450 A/60 % 15 m		1	094-000406-00004
WK70 mm² 450 A/60 % 4 m/Z	Workpiece lead with clamp	1	092-000013-00000
DM 842 Ar/CO2 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32 A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Ty	Designation	PU stk	Item no.
Wega 501 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-005088-00502
UM 501 W 3 m		1	394-600012-00000
UM 501 W 4 m	MIG/MAG welding torch, water-cooled	1	394-600012-00004
UM 501 W 5 m		1	394-600012-00005
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004966-00502
Wega M2.40 drive 41L		1	090-004967-00502
MIG W 7POL 95qmm 550 A/60 % 1 m		1	094-000407-00000
MIG W 7POL 95qmm 550 A/60 % 5 m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550 A/60 % 10 m		1	094-000407-00002
MIG W 7POL 95qmm 550 A/60 % 15 m		1	094-000407-00006
WK95 mm² 550 A/60 % 4 m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32 A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Ty	Designation	PU stk	Item no.
Wega 601 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	1	090-005089-00502
UM 501 W 3 m		1	394-600012-00000
UM 501 W 4 m	MIG/MAG welding torch, water-cooled	1	394-600012-00004
UM 501 W 5 m		1	394-600012-00005
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	1	090-004966-00502
Wega M2.40 drive 41L		1	090-004967-00502
MIG W 7POL 95qmm 550 A/60 % 1 m		1	094-000407-00000
MIG W 7POL 95qmm 550 A/60 % 5 m	Intermediate hose package, water-cooled, 7-pole	1	094-000407-00001
MIG W 7POL 95qmm 550 A/60 % 10 m		1	094-000407-00002
MIG W 7POL 95qmm 550 A/60 % 15 m		1	094-000407-00006
WK95 mm² 550 A/60 % 4 m/Z	Workpiece lead with clamp	1	092-000171-00000
DM 842 Ar/CO₂ 230bar 30I D	Pressure regulator with manometer	1	394-002910-00030
KF 23E 5 I, -10	Coolant (-10 °C), 5 l	1	094-000530-00005
OW CEE 32 A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

- ▶ * Only the items in bold are included in the total
- ▶ Wire feed unit available with either M2.20 or M2.40 control

System components step switch controlled welding machines - Wire feed units

drive 41L series

Saturn drive 41



Designation	Control	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	Saturn M1.02	1	090-004992-00502
	Saturn M2.20	1	090-004993-00502
	Saturn M2.40	1	090-004994-00502

Wega drive 41



Designation	Control	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	Wega M1.02	1	090-004962-00502
	Wega M2.20	1	090-004963-00502
	Wega M2.40	1	090-004964-00502

Saturn drive 41L



- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Designation	Wire feeder weight kg	Control	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	13.0	Saturn M1.02	1	090-004995-00502
	15.5	Saturn M2.20	1	090-004996-00502
		Saturn M2.40	1	090-004997-00502

Wega drive 41L



- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Designation	Wire feeder weight kg	Control	PU stk	Item no.
Wire feeder, water-cooled, Euro torch connector	15.6	Wega M1.02	1	090-004965-00502
	18.2	Wega M2.20	1	090-004966-00502
		Wega M2.40	1	090-004967-00502

Options drive 41L • drive 41

ON WAKD 4L



- 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.

Designation	PU stk	Item no.
Wheel assembly kit for drive 4L/41L	1	090-008169-00000

ON WAKD D.0002



- 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)!

Designation	PU stk	Item no.
Wheel assembly kit for drive 4 IC and drive 4/41	1	090-008035-00000

ON WAKD2 4L/41L



- Wheel set – facilitates work at frequently changing welding sites

Designation	PU stk	Item no.
Wheel assembly kit for drive 4L/41L	1	090-008151-00000

System components step switch controlled welding machines - Intermediate hose packages

Gas-cooled

- Gas-cooled intermediate hose package
- 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

MIG G 7POL 50qmm 350A/60%



Connection	7-pole
Duty cycle	350 A , 60 %
Cross-section	50 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-000579-00000
	5.0	1	094-000579-00001
	10.0	1	094-000579-00002

MIG G 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-000580-00000
	5.0	1	094-000580-00001
	10.0	1	094-000580-00002
	15.0	1	094-000580-00005
	20.0	1	094-000580-00003
	30	1	094-000580-00006

MIG G 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, gas-cooled, 7-pole	1.0	1	094-007726-00000
	5.0	1	094-007726-00001
	10.0	1	094-007726-00002
	15.0	1	094-007726-00003
	20.0	1	094-007726-00004
	30	1	094-007726-00005
	40	1	094-007726-00007

Water-cooled

- Water-cooled intermediate hose package
- 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

MIG W 7POL 50qmm 350A/60%



Connection	7-pole
Duty cycle	350 A , 60 %
Cross-section	50 mm ²

Designation	Hose package length	PU	Item no.
	m	stk	
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000405-00000
	5.0	1	094-000405-00001
	10.0	1	094-000405-00002
	15.0	1	094-000405-00003

MIG W 7POL 70qmm 450A/60%



Connection	7-pole
Duty cycle	450 A , 60 %
Cross-section	70 mm ²

Designation	Hose package length	PU	Item no.
	m	stk	
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000406-00000
	5.0	1	094-000406-00001
	10.0	1	094-000406-00002
	15.0	1	094-000406-00004
	20.0	1	094-000406-00005
	30	1	094-000406-00006

MIG W 7POL 95qmm 550A/60%



Connection	7-pole
Duty cycle	550 A , 60 %
Cross-section	95 mm ²

Designation	Hose package length	PU	Item no.
	m	stk	
Intermediate hose package, water-cooled, 7-pole	1.0	1	094-000407-00000
	5.0	1	094-000407-00001
	10.0	1	094-000407-00002
	15.0	1	094-000407-00006
	20.0	1	094-000407-00007
	30	1	094-000407-00003
	40	1	094-000407-00008

Overview

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Wire feed rolls - eFeed drive rolls

Drive roll set



- Drive roll set, V-groove for steel, stainless steel and brazing
- Four roll set
- For using rolls with a diameter of more than 1.6 mm, the SET WF 2.0–3.2 mm eFeed (092-019404-00000) option is necessary!

Colour code	white/blue
Groove sha	V-groove

Designation	Colour code	Wire Ø mm	PU	Item no.
Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel, nickel and copr alloys	white/blue	0.8 - 1	1	092-002770-00009
	Blue/Red	1 - 1.2	1	092-002770-00011
	Green	1.4	1	092-002770-00014
	Black	1.6	1	092-002770-00016
	Grey	2.0	1	092-002770-00020
	Brown	2.4	1	092-002770-00024
	Light green	2.8	1	092-002770-00028
	Violet	3.2	1	092-002770-00032

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106
drive 4X HP	090-005392-00502	144	Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106
drive 4 Basic MMA	090-005401-51502	213	Picomig 185 puls TKG	090-005547-00502	229
drive 4 Basic	090-005401-00502	213	Picomig 185 Synergic TKG	090-005548-00502	231
drive 4X IC D HP	090-005507-00502	149	Picomig 355 puls TKM	090-005542-00502	233
drive 4X EX	090-005511-00502	144	Picomig 355 Synergic TKM	090-005512-00502	235
drive 4X IC D EX	090-005598-00502	149	Drive 4 Basic S	090-005597-00502	182
drive 4X EX GFE	090-005511-55502	144	Taurus 351 Basic FKG	090-005425-00502	203
drive 4X EX MMA	090-005511-51502	144	Taurus 351 Basic FKW	090-005419-00502	205
drive 4X EX MMA GFE	090-005511-60502	144	Taurus 351 Synergic S LP MM FKW	090-005422-00502	136
drive 4X HP GFE	090-005392-55502	144	Taurus 351 Synergic S HP MM FKG	090-005431-00502	134
drive 4X HP MMA GFE	090-005392-60502	144	Taurus 351 Synergic S LP MM FKG	090-005428-00502	134
drive 4X IC HP	090-005414-00502	148	Taurus 351 Synergic S HP MM FKW	090-005420-00502	136
drive 4X IC LP	090-005415-00502	148	Taurus 355 Basic TKM	090-005406-00502	196
drive 4X LP	090-005412-00502	143	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
drive 4X LP GFE	090-005412-55502	143	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
drive 4X LP MMA	090-005412-51502	143	Taurus 401 Basic FKG	090-005426-00502	204
drive 4X LP MMA GFE	090-005412-60502	143	Taurus 401 Basic FKW	090-005408-00502	206
drive 4X HP MMA	090-005392-51502	144	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136

Drive roll set



- Drive roll set, V-groove/knurled for flux cored wire
- Four roll set
- For using rolls with a diameter of more than 1.6 mm, the SET WF 2.0–3.2 mm eFeed (092-019404-00000) option is necessary!

Colour code	White/orange
Groove sha	V-groove/knurled

Designation	Colour code	Wire Ø mm	PU stk	Item no.
Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire	White/orange	0.8	1	092-002848-00008
	Blue/orange	0.9 - 1	1	092-002848-00010
	Red/orange	1.2	1	092-002848-00012
	Green/orange	1.4	1	092-002848-00014
	Black/orange	1.6	1	092-002848-00016
	Grey/orange	2.0	1	092-002848-00020
	Brown/orange	2.4	1	092-002848-00024

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106
drive 4X HP	090-005392-00502	144	Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106
drive 4 Basic MMA	090-005401-51502	213	Picomig 185 puls TKG	090-005547-00502	229
drive 4 Basic	090-005401-00502	213	Picomig 185 Synergic TKG	090-005548-00502	231
drive 4X IC D HP	090-005507-00502	149	Picomig 355 puls TKM	090-005542-00502	233
drive 4X EX	090-005511-00502	144	Picomig 355 Synergic TKM	090-005512-00502	235
drive 4X IC D EX	090-005598-00502	149	Drive 4 Basic S	090-005597-00502	182
drive 4X EX GFE	090-005511-55502	144	Taurus 351 Basic FKG	090-005425-00502	203
drive 4X EX MMA	090-005511-51502	144	Taurus 351 Basic FKW	090-005419-00502	205
drive 4X EX MMA GFE	090-005511-60502	144	Taurus 351 Synergic S LP MM FKW	090-005422-00502	136
drive 4X HP GFE	090-005392-55502	144	Taurus 351 Synergic S HP MM FKG	090-005431-00502	134
drive 4X HP MMA GFE	090-005392-60502	144	Taurus 351 Synergic S LP MM FKG	090-005428-00502	134
drive 4X IC HP	090-005414-00502	148	Taurus 351 Synergic S HP MM FKW	090-005420-00502	136
drive 4X IC LP	090-005415-00502	148	Taurus 355 Basic TKM	090-005406-00502	196
drive 4X LP	090-005412-00502	143	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
drive 4X LP GFE	090-005412-55502	143	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
drive 4X LP MMA	090-005412-51502	143	Taurus 401 Basic FKG	090-005426-00502	204
drive 4X LP MMA GFE	090-005412-60502	143	Taurus 401 Basic FKW	090-005408-00502	206
drive 4X HP MMA	090-005392-51502	144	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136

Wire feed rolls - eFeed drive rolls

Drive roll set



- Drive roll set, U-groove for aluminium
- Four roll set
- For using rolls with a diameter of more than 1.6 mm, the SET WF 2.0–3.2 mm eFeed (092-019404-00000) option is necessary!

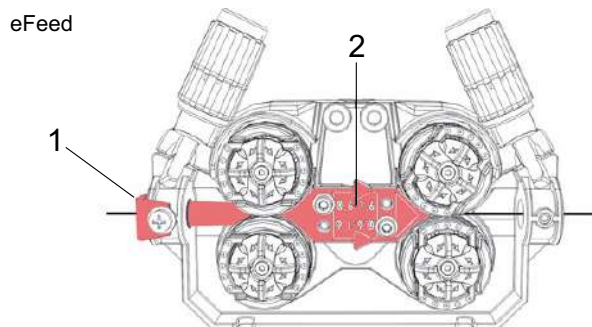
Colour code	White
Groove sha	U-groove

Designation	Colour code	Wire Ø mm	PU stk	Item no.
Drive roll set, 37 mm, 4 rollers, U-groove for aluminium	white/yellow	0.8	1	092-002771-00008
	blue/yellow	0.9 - 1	1	092-002771-00010
	red/yellow	1.2	1	092-002771-00012
	black/yellow	1.6	1	092-002771-00016
	Grey/yellow	2.0	1	092-002771-00020
	Brown/yellow	2.4	1	092-002771-00024

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106
drive 4X HP	090-005392-00502	144	Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106
drive 4 Basic MMA	090-005401-51502	213	Picomig 185 puls TKG	090-005547-00502	229
drive 4 Basic	090-005401-00502	213	Picomig 185 Synergic TKG	090-005548-00502	231
drive 4X IC D HP	090-005507-00502	149	Picomig 355 puls TKM	090-005542-00502	233
drive 4X EX	090-005511-00502	144	Picomig 355 Synergic TKM	090-005512-00502	235
drive 4X IC D EX	090-005598-00502	149	Drive 4 Basic S	090-005597-00502	182
drive 4X EX GFE	090-005511-55502	144	Taurus 351 Basic FKG	090-005425-00502	203
drive 4X EX MMA	090-005511-51502	144	Taurus 351 Basic FKW	090-005419-00502	205
drive 4X EX MMA GFE	090-005511-60502	144	Taurus 351 Synergic S LP MM FKW	090-005422-00502	136
drive 4X HP GFE	090-005392-55502	144	Taurus 351 Synergic S HP MM FKG	090-005431-00502	134
drive 4X HP MMA GFE	090-005392-60502	144	Taurus 351 Synergic S LP MM FKG	090-005428-00502	134
drive 4X IC HP	090-005414-00502	148	Taurus 351 Synergic S HP MM FKW	090-005420-00502	136
drive 4X IC LP	090-005415-00502	148	Taurus 355 Basic TKM	090-005406-00502	196
drive 4X LP	090-005412-00502	143	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
drive 4X LP GFE	090-005412-55502	143	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
drive 4X LP MMA	090-005412-51502	143	Taurus 401 Basic FKG	090-005426-00502	204
drive 4X LP MMA GFE	090-005412-60502	143	Taurus 401 Basic FKW	090-005408-00502	206
drive 4X HP MMA	090-005392-51502	144	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136

Wire guide set



Designation	PU stk	Item no.
1) Inlet guide set	1	092-002780-00000
2) Wire feed set for rolls up to 1.6 mm in diameter	1	092-002774-00000
2) Wire feed set for rolls with diameters greater than 1.6 mm	1	092-019404-00000

Conversion kits

Pressure roll set for steel wire



- Conversion to steel standard from optional alu or flux cored wire, without drive rolls
- Includes 2 pressure rollers and 2 spacer rings

Roller diameter	37 mm
------------------------	-------

Designation	PU	Item no.
Pressure roll set for steel wire	1	092-000845-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 4L	090-002121-00502	427	Saturn M2.40 drive 41	090-004994-00502	258
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M1.02 FKG	090-005224-00502	248
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M1.02 FKW	090-005227-00502	250
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M1.02 drive 41L	090-004965-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.20 drive 41L	090-004966-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258	Wega M2.40 drive 41L	090-004967-00502	258
Saturn M1.02 drive 41	090-004992-00502	258	Wega M1.02 drive 41	090-004962-00502	258
Saturn M2.20 drive 41	090-004993-00502	258	Wega M2.20 drive 41	090-004963-00502	258
			Wega M2.40 drive 41	090-004964-00502	258

Conversion kit for aluminium



- Sets for conversion from steel standard to optional alu
- Includes 4 drive rolls and 2 gears

Designation	Wire Ø mm	Roller diameter mm	PU	Item no.
Conversion kit for aluminium	0.8 - 1	37	1	092-000867-00000
	1 - 1.2		1	092-000846-00000
	1.2 - 1.6		1	092-000847-00000
	2.4 - 3.2		1	092-000868-00000
	1.0		1	092-001115-00000
	1.2		1	092-001117-00000
	1.6		1	092-001119-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M1.02 FKG	090-005224-00502	248
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M1.02 FKW	090-005227-00502	250
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M1.02 drive 41L	090-004965-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.20 drive 41L	090-004966-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258	Wega M2.40 drive 41L	090-004967-00502	258
Saturn M1.02 drive 41	090-004992-00502	258	Wega M1.02 drive 41	090-004962-00502	258
Saturn M2.20 drive 41	090-004993-00502	258	Wega M2.20 drive 41	090-004963-00502	258
Saturn M2.40 drive 41	090-004994-00502	258	Wega M2.40 drive 41	090-004964-00502	258

Conversion kits

Conversion kit for flux cored wire

- Sets for conversion from steel standard to optional flux cored wire
- Includes two drive rolls, two pressure rolls and two gears



Designation	Wire Ø mm	Wire Ø 2 mm	Roller diameter mm	PU ve	Item no.
Conversion kit for flux cored wire	0.8 - 0.9	0.8 - 0.9	37	1	092-000830-00000
	1 - 1.2	1.4 - 1.6		1	092-000831-00000
	1.4 - 1.6	2 - 2.4		1	092-000832-00000
	2.8	3.2		1	092-000833-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 4L	090-002121-00502	427	Saturn M2.40 drive 41	090-004994-00502	258
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M1.02 FKG	090-005224-00502	248
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M1.02 FKW	090-005227-00502	250
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M1.02 drive 41L	090-004965-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.20 drive 41L	090-004966-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258	Wega M2.40 drive 41L	090-004967-00502	258
Saturn M1.02 drive 41	090-004992-00502	258	Wega M1.02 drive 41	090-004962-00502	258
Saturn M2.20 drive 41	090-004993-00502	258	Wega M2.20 drive 41	090-004963-00502	258
			Wega M2.40 drive 41	090-004964-00502	258

Conversion kit for aluminium

- Sets for conversion from steel standard to optional alu
- Includes 4 twin rollers, 2 gears and 2 spacer rings



Designation	Wire Ø mm	Wire Ø 2 mm	Roller diameter mm	PU ve	Item no.
Conversion kit for aluminium	0.8	1.0	37	1	092-002268-00000
	1.0	1.2		1	092-002266-00000
	1.2	1.6		1	092-002269-00000
	2.4	3.2		1	092-002270-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	tigSed continuous drive 45 coldwire	090-000237-00502	372
Picomig 180 puls TKG Set	091-005545-00502	225	tigSed continuous drive 45 hotwire	090-000236-00502	373
Picomig 180 puls TKG	090-005545-00502	224	tigSed oscillation drive 45 coldwire	090-000181-00502	372
Picomig 180 Synergic Set	091-005546-00502	227	tigSed oscillation drive 45 hotwire	090-000180-00502	373
Picomig 180 Synergic TKG	090-005546-00502	226			
Drive 4 Basic S D200	090-005596-00502	182			

Conversion kit for flux cored wire



- Sets for conversion from steel standard to optional flux cored wire
- Includes 2 twin rolls, 2 gears, 2 pressure rolls and 2 spacer rings

Designation	Wire Ø mm	Wire Ø 2 mm	Roller diameter mm	PU ve	Item no.
Conversion kit for flux cored wire	0.8 - 0.9	0.8 - 0.9	37	1	092-000410-00000
	1 - 1.2	1.4 - 1.6		1	092-000411-00000
	1.4 - 1.6	2 - 2.4		1	092-000412-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	tigSed continuous drive 45 coldwire	090-000237-00502	372
Picomig 180 puls TKG Set	091-005545-00502	225	tigSed continuous drive 45 hotwire	090-000236-00502	373
Picomig 180 puls TKG	090-005545-00502	224	tigSed oscillation drive 45 coldwire	090-000181-00502	372
Picomig 180 Synergic Set	091-005546-00502	227	tigSed oscillation drive 45 hotwire	090-000180-00502	373
Picomig 180 Synergic TKG	090-005546-00502	226			
Drive 4 Basic S D200	090-005596-00502	182			

URUE AL 2R miniDrive



- Kit to convert from steel to aluminium

Wire Ø	1.2 mm
Wire Ø 2	1.6 mm

Designation	Length mm	PU stk	Item no.
Conversion kit for aluminium, consisting of two 37mm rolls, liner and mounting material	10.0	1	092-007906-00010
	15.0	1	092-007906-00015

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
miniDrive GS 10m 70qmm	090-005262-00110	81	miniDrive WS 20m 70qmm	090-005262-01120	81
miniDrive GS 15m 70qmm	090-005262-00115	81	miniDrive WS 25m 70qmm	090-005262-01125	81
miniDrive GS 20m 70qmm	090-005262-00120	81	miniDrive WS 10m 70qmm V+A	090-005396-01110	81
miniDrive GS 25m 70qmm	090-005262-00125	81	miniDrive WS 15m 70qmm V+A	090-005396-01115	81
miniDrive WS 10m 70qmm	090-005262-01110	81	miniDrive WS 20m 70qmm V+A	090-005396-01120	81
miniDrive WS 15m 70qmm	090-005262-01115	81	miniDrive WS 25m 70qmm V+A	090-005396-01125	81

Drive/spare rolls

Drive roll set for steel



- Spare rolls for steel wire (standard steel model)
- Includes two drive rolls

Designation	Wire Ø mm	Roller diameter mm	PU	Item no.
Replacement roll set for steel wire	0.6 - 0.8	37	1	092-000839-00000
	0.8 - 1		1	092-000840-00000
	0.9 - 1.2		1	092-000841-00000
	1 - 1.2		1	092-000842-00000
	1.2 - 1.6		1	092-000843-00000
	0.9		1	092-001107-00000
	1.0		1	092-001109-00000
	1.2		1	092-001111-00000
	1.4		1	094-015328-00000
	1.6		1	092-001113-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Mira 151 FKG	090-005084-00502	236	Saturn M2.20 drive 41	090-004993-00502	258
Mira 221 MV FKG	090-005085-00502	236	Saturn M2.40 drive 41	090-004994-00502	258
Mira 251 FKG	090-005086-00502	237	Drive 4 Basic S D200	090-005596-00502	182
Mira 301 M1.02 FKG	090-005181-00502	237	tigSed continuous drive 45 coldwire	090-000237-00502	372
Mira 301 M2.20 FKG	090-005207-00502	238	tigSed continuous drive 45 hotwire	090-000236-00502	373
Mira 301 M2.40 FKG	090-005182-00502	238	tigSed oscillation drive 45 coldwire	090-000181-00502	372
Pico drive 200C	090-002124-00502	427	tigSed oscillation drive 45 hotwire	090-000180-00502	373
Pico drive 4L	090-002121-00502	427	2x Mira 221 MV FKG	092-015239-00502	241
Picomig 180 puls TKG Set	091-005545-00502	225	Wega 401 M1.02 FKG	090-005224-00502	248
Picomig 180 puls TKG	090-005545-00502	224	Wega 401 M1.02 FKW	090-005227-00502	250
Picomig 180 Synergic Set	091-005546-00502	227	Wega 401 M2.20 FKG	090-005225-00502	249
Picomig 180 Synergic TKG	090-005546-00502	226	Wega 401 M2.20 FKW	090-005228-00502	251
Picomig 355 Synergic TKM	090-005512-00502	235	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega M1.02 drive 41L	090-004965-00502	258
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega M2.20 drive 41L	090-004966-00502	258
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega M2.40 drive 41L	090-004967-00502	258
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega M1.02 drive 41	090-004962-00502	258
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega M2.20 drive 41	090-004963-00502	258
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M2.40 drive 41	090-004964-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258			
Saturn M2.40 drive 41L	090-004997-00502	258			
Saturn M1.02 drive 41	090-004992-00502	258			

Pressure rolls, steel wire

- Spare pressure rolls, steel, standard



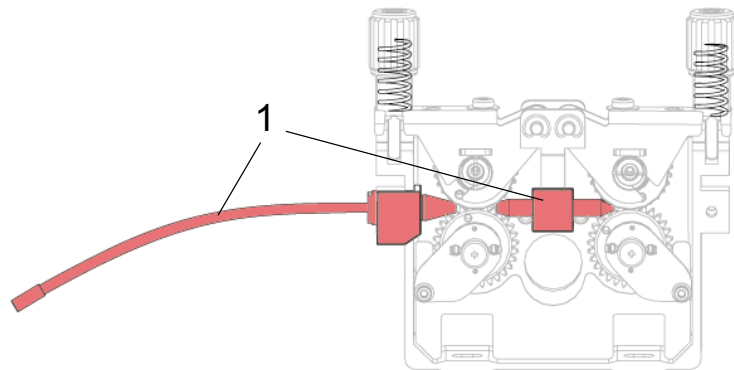
Roller diameter	37 mm
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Designation	PU	Item no.
2 pressure rolls, smooth, 37 mm	1	092-000844-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	Saturn M1.02 drive 41	090-004992-00502	258
Pico drive 4L	090-002121-00502	427	Saturn M2.20 drive 41	090-004993-00502	258
Picomig 180 puls TKG Set	091-005545-00502	225	Saturn M2.40 drive 41	090-004994-00502	258
Picomig 180 puls TKG	090-005545-00502	224	Wega 401 M1.02 FKG	090-005224-00502	248
Picomig 180 Synergic Set	091-005546-00502	227	Wega 401 M1.02 FKW	090-005227-00502	250
Picomig 180 Synergic TKG	090-005546-00502	226	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega M1.02 drive 41L	090-004965-00502	258
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega M2.20 drive 41L	090-004966-00502	258
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega M2.40 drive 41L	090-004967-00502	258
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M1.02 drive 41	090-004962-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.20 drive 41	090-004963-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258	Wega M2.40 drive 41	090-004964-00502	258

Retrofitting set for aluminium wires



Designation	PU	Item no.
Retrofit set: Inlet guide and centre guide for aluminium wire	1 stk	092-002625-00000

Drive/spare rolls

FE GR2R



Designation	PU stk	Item no.
Pressure roll set, smooth, 37 mm	1	092-007908-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
miniDrive GS 10m 70qmm	090-005262-00110	81	miniDrive WS 20m 70qmm	090-005262-01120	81
miniDrive GS 15m 70qmm	090-005262-00115	81	miniDrive WS 25m 70qmm	090-005262-01125	81
miniDrive GS 20m 70qmm	090-005262-00120	81	miniDrive WS 10m 70qmm V+A	090-005396-01110	81
miniDrive GS 25m 70qmm	090-005262-00125	81	miniDrive WS 15m 70qmm V+A	090-005396-01115	81
miniDrive WS 10m 70qmm	090-005262-01110	81	miniDrive WS 20m 70qmm V+A	090-005396-01120	81
miniDrive WS 15m 70qmm	090-005262-01115	81	miniDrive WS 25m 70qmm V+A	090-005396-01125	81

Drive roll set for aluminium

- Replacement rolls for aluminium wire
- Includes four drive rolls



Designation	Wire Ø mm	Roller diameter mm	PU ve	Item no.
Drive roll set for aluminium	0.8 - 1	37	1	092-000869-00000
	1 - 1.2		1	092-000848-00000
	1.2 - 1.6		1	092-000849-00000
	2.4 - 3.2		1	092-000870-00000
Twin wire feed roll, 37 mm, for aluminium	1.0		1	092-001114-00000
	1.2		1	092-001116-00000
	1.6		1	092-001118-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	Saturn M2.40 drive 41	090-004994-00502	258
Pico drive 4L	090-002121-00502	427	Drive 4 Basic S D200	090-005596-00502	182
Picomig 180 puls TKG Set	091-005545-00502	225	Wega 401 M1.02 FKG	090-005224-00502	248
Picomig 180 puls TKG	090-005545-00502	224	Wega 401 M1.02 FKW	090-005227-00502	250
Picomig 180 Synergic Set	091-005546-00502	227	Wega 401 M2.20 FKG	090-005225-00502	249
Picomig 180 Synergic TKG	090-005546-00502	226	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega M1.02 drive 41L	090-004965-00502	258
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega M2.20 drive 41L	090-004966-00502	258
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega M2.40 drive 41L	090-004967-00502	258
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega M1.02 drive 41	090-004962-00502	258
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M2.20 drive 41	090-004963-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.40 drive 41	090-004964-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258			
Saturn M1.02 drive 41	090-004992-00502	258			
Saturn M2.20 drive 41	090-004993-00502	258			

Drive roll set for flux cored wire



- Spare rollers flux cored wire
- Includes two drive rolls

Designation	Wire Ø mm	Wire Ø 2 mm	Roller diameter mm	PU ve	Item no.
Drive roll set for flux cored wire	0.8 - 0.9	0.8 - 0.9	37	1	092-000834-00000
	1 - 1.2	1.4 - 1.6		1	092-000835-00000
	1.4 - 1.6	2 - 2.4		1	092-000836-00000
	2.8	3.2		1	092-000837-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	Saturn M2.40 drive 41	090-004994-00502	258
Pico drive 4L	090-002121-00502	427	Drive 4 Basic S D200	090-005596-00502	182
Picomig 180 puls TKG Set	091-005545-00502	225	Wega 401 M1.02 FKG	090-005224-00502	248
Picomig 180 puls TKG	090-005545-00502	224	Wega 401 M1.02 FKW	090-005227-00502	250
Picomig 180 Synergic Set	091-005546-00502	227	Wega 401 M2.20 FKG	090-005225-00502	249
Picomig 180 Synergic TKG	090-005546-00502	226	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega M1.02 drive 41L	090-004965-00502	258
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega M2.20 drive 41L	090-004966-00502	258
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega M2.40 drive 41L	090-004967-00502	258
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega M1.02 drive 41	090-004962-00502	258
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M2.20 drive 41	090-004963-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.40 drive 41	090-004964-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258			
Saturn M1.02 drive 41	090-004992-00502	258			
Saturn M2.20 drive 41	090-004993-00502	258			

Drive/spare rolls

Pressure rolls for flux cored wire



- Replacement pressure rolls, flux cored wire

Roller diameter

37 mm

Designation	PU	Item no.
Pressure rolls for flux cored wire	1	092-000838-0000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico drive 200C	090-002124-00502	427	Saturn M2.40 drive 41	090-004994-00502	258
Pico drive 4L	090-002121-00502	427	Drive 4 Basic S D200	090-005596-00502	182
Picomig 180 puls TKG Set	091-005545-00502	225	Wega 401 M1.02 FKG	090-005224-00502	248
Picomig 180 puls TKG	090-005545-00502	224	Wega 401 M1.02 FKW	090-005227-00502	250
Picomig 180 Synergic Set	091-005546-00502	227	Wega 401 M2.20 FKG	090-005225-00502	249
Picomig 180 Synergic TKG	090-005546-00502	226	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega M1.02 drive 41L	090-004965-00502	258
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega M2.20 drive 41L	090-004966-00502	258
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega M2.40 drive 41L	090-004967-00502	258
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega M1.02 drive 41	090-004962-00502	258
Saturn M1.02 drive 41L	090-004995-00502	258	Wega M2.20 drive 41	090-004963-00502	258
Saturn M2.20 drive 41L	090-004996-00502	258	Wega M2.40 drive 41	090-004964-00502	258
Saturn M2.40 drive 41L	090-004997-00502	258			
Saturn M1.02 drive 41	090-004992-00502	258			
Saturn M2.20 drive 41	090-004993-00502	258			

Overview of capillary/guide tubes for machines/wire feeders without eFeed

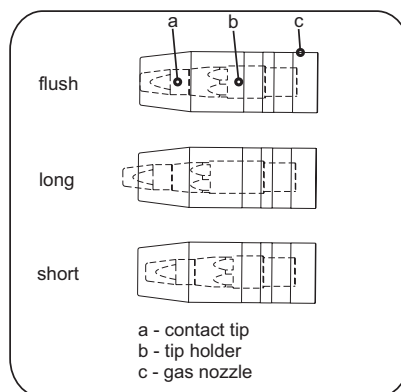
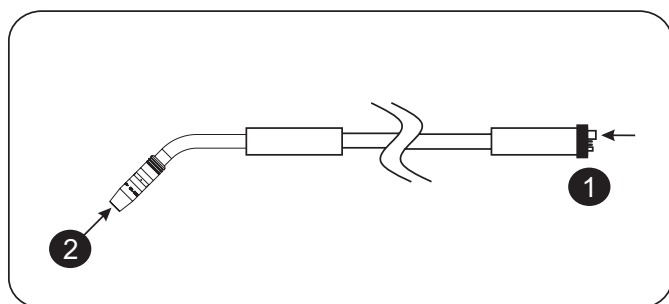
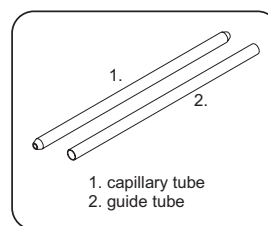
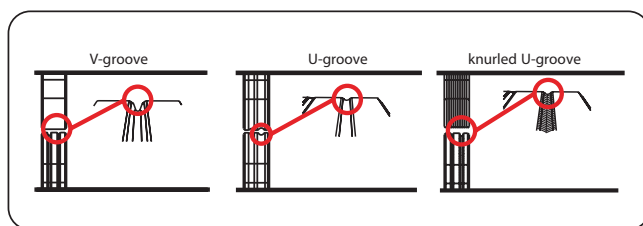
Use and assignment of different capillary tubes and guide tubes

Euro torch connectors on our machines are fitted with a capillary tube for welding torches with a steel liner ex works. The Euro torch connector needs to be modified accordingly if a welding torch with a liner is used!

Operate welding torches with liners with a guide tube in the Euro torch connector!

Operate welding torches with steel liners with a capillary tube in the Euro torch connector!

	Capillary tubes		Guide tube	
	094-006634-00000 (≤ 1.6 mm \varnothing) 094-021470-00000 (≤ 2.4 mm \varnothing)	094-014186-00000 (≤ 1.6 mm \varnothing)	094-006051-00000	
Compact machines (machines with integrated wire feed mechanism)				
Mira		●		094-019350-00000
Saturn	●		●	
Wega	●		●	
Picomig 180	094-014667-00000 (< 2.0 mm \varnothing)			094-018316-00000
	Capillary tubes		Guide tube	
	094-006634-00000 (≤ 1.6 mm \varnothing) 094-021470-00000 (≤ 2.4 mm \varnothing)	094-002559-00000 (≤ 1.6 mm \varnothing) 094-007515-00000 (≤ 2.0 mm \varnothing)	094-006051-00000	094-001064-00000
Wire feeders				
drive 41L		●		●
drive 41	●		●	
Drive 4X Steel D200 Drive 4 Basic S D200	094-014667-00000 (≤ 2.0 mm \varnothing)			094-018316-00000



Capillary/guide tube for eFeed wire feed mechanism

The use of capillary or guide tubes ensures optimum wire guiding from spool to weld pool.



Recommendation:

- Use a steel liner to weld hard, unalloyed wire electrodes (steel).
- Use a plastic liner to weld or braze soft or alloy wire electrodes.

The Euro torch connectors on our wire feeders and welding machines are equipped with a capillary tube for welding torches with steel liners (for wires ≤ 1.6 mm) ex-works. The Euro torch connector needs to be modified accordingly on the machine if a welding torch with a plastic liner is used!

Use in wire feeders:	Capillary tube	Guide tube
<p>Machine series</p>	<p>Wires ≤ 1.6 mm: 094-006634-00000</p> <p>Wires ≤ 2.4 mm: 094-021470-00000</p> <p>Wires ≥ 2.4 mm: On request</p>	<p>Wires ≤ 1.6 mm: 094-020064-00000</p> <p>Wires ≤ 2.4 mm: On request</p> <p>Wires ≥ 2.4 mm: On request</p>
<p>Drive XQ drive 4X Drive 4X Steel Drive 4 Basic S drive 4 Basic</p> 	●	●
<p>drive 4X IC drive 4X IC D drive 4 IC</p> 	●	●

Use on compact welding machines	Capillary tube	Guide tube
Machine series	Wires ≤ 1.6 mm: 094-006634-00000 Wires ≤ 2.4 mm: 094-021470-00000 Wires ≥ 2.4 mm: On request	Wires ≤ 1.6 mm: 094-020064-00000 Wires ≤ 2.4 mm: On request Wires ≥ 2.4 mm: On request
Picomig 185/305	●	●
Phoenix/Taurus 355 compact	●	●
Phoenix/Taurus 351/401/501 compact	●	●
Titan XQ 350/400 C	●	●

If welding torches and the Euro torch connector are not equipped in line with the wire electrode used, there will be problems with wire feeding:

- Bird nest
- Jolting, irregular wire feed; the whole wire feed system may get jammed

This is why either a liner or steel liner with a compatible inner diameter must be used in the welding torch and a capillary or guide tube in the welding machine Euro torch connector, depending on the wire electrode diameter and wire electrode type.

Wire feed rolls - Overview capillary tubes / intermediate wire guides

● **Recommendation**

- Use a steel liner with capillary tube to weld hard, unalloyed wire electrodes (steel)
- Use a liner with guide tube to weld or braze soft or alloy wire electrodes

Capillary tube

- Capillary tube for use on a steel liner when welding steel wire



Designation	Length mm	Version	PU ve	Item no.
Capillary tube	107	Wire diameter ≤ 1.6 mm	5	094-006634-00000
	105	Wire diameter ≤ 2.4 mm	5	094-021470-00000
	118	Wire diameter ≤ 1.6 mm	5	094-002559-00000
		Wire diameter ≤ 2.0 mm	5	094-007515-00000
	48	Wire diameter ≤ 1.6 mm	5	094-014186-00000
	69	Wire diameter ≤ 2.0 mm	5	094-014667-00000

Guide tube

- Guide tube for use on a liner when welding or brazing soft or alloyed wire



Designation	Length mm	PU	Item no.
Guide tube	45	1	094-019350-00000
	66	1	094-018316-00000
	105	10	094-006051-00000
	115	10	094-001064-00000

MIG/MAG welding torches - PM welding torch gas cooled

- Secure hold thanks to rubber inserts in the grip
- The flexible ball joint makes it comfortable to work, even for positional welding
- The torch trigger protection prevents the arc being ignited unintentionally



Connection	Euro torch connector
Bend angle torch neck	45 °
Approvals	CE

PM 221 G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch,	3.0	1	094-700000-00000
gas-cooled	4.0	1	094-700000-00004
	5.0	1	094-700000-00005

PM 221 G LED X



- Gas-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines

Duty cycle	250 A / 60 %
	220 A / 60 %
	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with	3.0	1	094-700000-00900
LED lighting,	4.0	1	094-700000-00904
gas-cooled	5.0	1	094-700000-00905

MIG/MAG welding torches - PM welding torch gas cooled

PM 221 G 2U/D



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-700000-00800
function torch,	4.0	1	094-700000-00804
gas-cooled	5.0	1	094-700000-00805

PM 221 G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled, with X technology	3.0	1	094-700000-00300
	4.0	1	094-700000-00304
	5.0	1	094-700000-00305

PM 221 G RD2 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700000-00700
	4.0	1	094-700000-00704
	5.0	1	094-700000-00705

PM 221 G RD3 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Orating weight	1.09 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700000-00600
	4.0	1	094-700000-00604
	5.0	1	094-700000-00605

MIG/MAG welding torches - PM welding torch gas cooled

PM 301 G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	094-700001-00000
	4.0	1	094-700001-00004
	5.0	1	094-700001-00005

PM 301 G LED X



- Gas-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines

Duty cycle	330 A / 60 %
	300 A / 60 %
	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with LED lighting, gas-cooled	3.0	1	094-700001-00900
	4.0	1	094-700001-00904
	5.0	1	094-700001-00905

PM 301 G 2U/D



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled	3.0	1	094-700001-00800
	4.0	1	094-700001-00804
	5.0	1	094-700001-00805

PM 301 G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.6 mm
Orating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled, with X technology	3.0	1	094-700001-00300
	4.0	1	094-700001-00304
	5.0	1	094-700001-00305

PM 301 G RD2 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.6 mm
Orating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700001-00700
	4.0	1	094-700001-00704
	5.0	1	094-700001-00705

MIG/MAG welding torches - PM welding torch gas cooled

PM 301 G RD3 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.6 mm
Operating weight	1.16 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700001-00600
	4.0	1	094-700001-00604
	5.0	1	094-700001-00605

PM 401 G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Operating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	094-700002-00000
	4.0	1	094-700002-00004
	5.0	1	094-700002-00005

PM 401 G LED X



- Gas-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines

Duty cycle	450 A / 35 %
	400 A / 35 %
	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with LED lighting, gas-cooled	3.0	1	094-700002-00900
	4.0	1	094-700002-00904
	5.0	1	094-700002-00905

PM 401 G 2U/D



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled	3.0	1	094-700002-00800
	5.0	1	094-700002-00805
	4.0	1	094-700002-00804

PM 401 G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 2 mm
Orating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled, with X technology	3.0	1	094-700002-00300
	4.0	1	094-700002-00304
	5.0	1	094-700002-00305

MIG/MAG welding torches - PM welding torch gas cooled

PM 401 G RD2 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 2 mm
Operating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700002-00700
	4.0	1	094-700002-00704
	5.0	1	094-700002-00705

PM 401 G RD3 X



- Gas-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 2 mm
Operating weight	1.3 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, gas-cooled, with X technology	3.0	1	094-700002-00600
	4.0	1	094-700002-00604
	5.0	1	094-700002-00605

MIG/MAG welding torches - PM welding torch water cooled

- Secure hold thanks to rubber inserts in the grip
- The flexible ball joint makes it comfortable to work, even for positional welding
- The torch trigger protection prevents the arc being ignited unintentionally



Connection	Euro torch connector
Bend angle torch neck	45 °
Approvals	CE

PM 301 W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Orating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	094-700003-00000
	4.0	1	094-700003-00004
	5.0	1	094-700003-00005

PM 301 W LED X



- Water-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines

Duty cycle	330 A / 100 %
	290 A / 100 %
	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Orating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with LED lighting, water-cooled	3.0	1	094-700003-00900
	4.0	1	094-700003-00904
	5.0	1	094-700003-00905

MIG/MAG welding torches - PM welding torch water cooled

PM 301 W 2U/D



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Operating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-700003-00800
function torch,	4.0	1	094-700003-00804
water-cooled	5.0	1	094-700003-00805

PM 301 W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Operating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-700003-00300
function	4.0	1	094-700003-00304
torch, water-cooled, with X technology	5.0	1	094-700003-00305

PM 301 W RD2 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Orating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700003-00700
	4.0	1	094-700003-00704
	5.0	1	094-700003-00705

PM 301 W RD3 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.2 mm
Orating weight	1.03 kg
Thread, current nozzle	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700003-00600
	4.0	1	094-700003-00604
	5.0	1	094-700003-00605

MIG/MAG welding torches - PM welding torch water cooled

PM 451 W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	094-700004-00000
	4.0	1	094-700004-00004
	5.0	1	094-700004-00005
	6.5	1	094-700004-00065

PM 451 W LED X



- Water-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle	500 A / 100 %
	450 A / 100 %
	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with LED lighting, water-cooled	3.0	1	094-700004-00900
	4.0	1	094-700004-00904
	5.0	1	094-700004-00905
	6.5	1	094-700004-00965

PM 451 W 2U/D



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-700004-00800
function torch, water-cooled	4.0	1	094-700004-00804
	5.0	1	094-700004-00805

PM 451 W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-700004-00300
function	4.0	1	094-700004-00304
torch, water-cooled, with X technology	5.0	1	094-700004-00305

MIG/MAG welding torches - PM welding torch water cooled

PM 451 W RD2 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700004-00700
	4.0	1	094-700004-00704
	5.0	1	094-700004-00705

PM 451 W RD3 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Orating weight	1.09 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700004-00600
	4.0	1	094-700004-00604
	5.0	1	094-700004-00605
	6.5	1	094-700004-00665

PM 551 W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	094-700005-00000
	4.0	1	094-700005-00004
	5.0	1	094-700005-00005
	6.5	1	094-700005-00065

PM 551 W LED X



- Water-cooled MIG/MAG welding torch
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle	650 A / 100 %
	550 A / 100 %
	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch with LED lighting, water-cooled	3.0	1	094-700005-00900
	4.0	1	094-700005-00904
	5.0	1	094-700005-00905
	6.5	1	094-700005-00965

PM 551 W 2U/D



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Additional control cable for connection to EWM welding machines without X technology

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, water-cooled	3.0	1	094-700005-00800
	4.0	1	094-700005-00804
	5.0	1	094-700005-00805

MIG/MAG welding torches - PM welding torch water cooled

PM 551 W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 2 mm
Operating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, water-cooled, with X technology	3.0	1	094-700005-00300
	4.0	1	094-700005-00304
	5.0	1	094-700005-00305

PM 551 W RD2 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 Ø	0.8 mm - 2 mm
Operating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700005-00700
	4.0	1	094-700005-00704
	5.0	1	094-700005-00705

PM 551 W RD3 X



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- **Recommended use for 6.5 m hose packages:** For steel and CrNi with a wire diameter of 1.2 to 1.6 mm only

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Orating weight	1.1 kg
Thread, current nozzle	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	3.0	1	094-700005-00600
	4.0	1	094-700005-00604
	5.0	1	094-700005-00605
	6.5	1	094-700005-00665

PM 551 W RD3 X Alu



- Water-cooled MIG/MAG function torch with high-quality OLED graphic display
- Ex works, equipd for welding aluminium wires
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
 - Welding process switching
 - Faults and error messages
 - **Xnet support:**
 - Selection of welding tasks according to welding sequence plan
 - Component management
- Automatic LED lighting when the welding torch is moved
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- 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 %
Orating weight	1.1 kg

Designation	Ø	Hose package length m	PU	Item no.
MIG/MAG function torch with OLED graphic display, water-cooled, X technology	1.0	3.0	1	094-700005-40600
		4.0	1	094-700005-40604
		3.0	1	094-700005-50600
	1.2	4.0	1	094-700005-50604

MIG/MAG welding torches - Options PM welding torches

ON TV PM



- Torch trigger extension for PM welding torches

Designation	PU	Item no.
Torch trigger extension for PM welding torches with LED	1	094-023891-00000
Torch trigger extension for PM standard welding torches	1	094-022327-00000

Conversion kit, upr torch trigger



- Conversion kit for "torch trigger at top" including tool for installation

Designation	PU	Item no.
Conversion kit, torch trigger on top for PM standard welding torches	1	092-007938-00000
Torch trigger, at the top with LED for PM welding torch	1	092-007939-00000

ON LED PM Standard



- Retrofit set "LED lighting" including tool for installation

PU	1 #einheitVE#
Designation	PU Item no.
LED lighting retrofit kit for PM standard torches	1 092-007940-00000

ON HSS Ø18-19 mm



Designation	PU	Item no.
Heat protection shield for PM/MT welding torches	1	094-025359-00000

MIG/MAG welding torches - MT welding torch gas cooled

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work



Connection	Euro torch connector
Bend angle torch neck	45 °
Approvals	CE

MT221G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	094-500050-00000
	4.0	1	094-500050-00004
	5.0	1	094-500050-00005

MT221G U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, up/down, gas cooled, with X Technology	3.0	1	094-500116-00200
	4.0	1	094-500116-00204
	5.0	1	094-500116-00205

MT221G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled, with X technology	3.0	1	094-500116-00300
	4.0	1	094-500116-00304
	5.0	1	094-500116-00305

MT221G PC1 X



- Gas-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with X Technology	3.0	1	094-500116-00400
	4.0	1	094-500116-00404
	5.0	1	094-500116-00405

MIG/MAG welding torches - MT welding torch gas cooled

MT221G PC2 X



- Gas-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 2, gas cooled, with X Technology	3.0	1	094-500116-00700
	4.0	1	094-500116-00704
	5.0	1	094-500116-00705

MT301G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	094-500055-00000
	4.0	1	094-500055-00004
	5.0	1	094-500055-00005

MT301G U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-500117-00200
welding torch,	4.0	1	094-500117-00204
up/down, gas	5.0	1	094-500117-00205
cooled, with X			
Technology			

MT301G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG func-	3.0	1	094-500117-00300
tion torch, gas-	4.0	1	094-500117-00304
cooled, with X	5.0	1	094-500117-00305
technology			

MIG/MAG welding torches - MT welding torch gas cooled

MT301G PC1 X



- Gas-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with X Technology	3.0	1	094-500117-00400
	4.0	1	094-500117-00404
	5.0	1	094-500117-00405

MT301G PC2 X



- Gas-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 2, gas cooled, with X Technology	3.0	1	094-500117-00700
	4.0	1	094-500117-00704
	5.0	1	094-500117-00705

MT401G



- Gas-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch,	3.0	1	094-500057-00000
gas-cooled	4.0	1	094-500057-00004
	5.0	1	094-500057-00005

MT401G U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch,	3.0	1	094-500118-00200
up/down, gas cooled, with X	4.0	1	094-500118-00204
Technology	5.0	1	094-500118-00205

MIG/MAG welding torches - MT welding torch gas cooled

MT401G 2U/D X



- Gas-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, gas-cooled, with X technology	3.0	1	094-500118-00300
	4.0	1	094-500118-00304
	5.0	1	094-500118-00305

MT401G PC1 X



- Gas-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed sed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with XTechnology	3.0	1	094-500118-00400
	4.0	1	094-500118-00404
	5.0	1	094-500118-00405

MT401G PC2 X



- Gas-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-500118-00700
welding torch,	4.0	1	094-500118-00704
Powercontrol 2, gas cooled, with X Technology	5.0	1	094-500118-00705

MIG/MAG welding torches - MT welding torch water cooled

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work



Connection	Euro torch connector
Bend angle torch neck	45 °
Approvals	CE

MT301W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	094-500058-00000
	4.0	1	094-500058-00004
	5.0	1	094-500058-00005

MT301W U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, up/down, water cooled, with X Technology	3.0	1	094-500119-00200
	4.0	1	094-500119-00204
	5.0	1	094-500119-00205

MT301W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, water-cooled, with X technology	3.0	1	094-500119-00300
	4.0	1	094-500119-00304
	5.0	1	094-500119-00305

MT301W PC1 X



- Water-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3.0	1	094-500119-00400
	4.0	1	094-500119-00404
	5.0	1	094-500119-00405

MIG/MAG welding torches - MT welding torch water cooled

MT301W PC2 X



- Water-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire Ø	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 2, water cooled, with X technology, replaceable neck	3.0	1	094-500119-00700
	4.0	1	094-500119-00704
	5.0	1	094-500119-00705

MT451W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	094-500059-00000
	4.0	1	094-500059-00004
	5.0	1	094-500059-00005

MT451W U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, up/down, water cooled, with X Technology	3.0	1	094-500120-00200
	4.0	1	094-500120-00204
	5.0	1	094-500120-00205

MT451W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, water-cooled, with X technology	3.0	1	094-500120-00300
	4.0	1	094-500120-00304
	5.0	1	094-500120-00305

MIG/MAG welding torches - MT welding torch water cooled

MT451W PC1 X



- Water-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed sed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3.0	1	094-500120-00400
	4.0	1	094-500120-00404
	5.0	1	094-500120-00405

MT451W PC2 X



- Water-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed sed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 2, water cooled, with X technology, replaceable neck	3.0	1	094-500120-00700
	4.0	1	094-500120-00704
	5.0	1	094-500120-00705

MT551W



- Water-cooled MIG/MAG welding torch
- Fits all welding machines with a Euro torch connector

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch,	3.0	1	094-500060-00000
water-cooled	4.0	1	094-500060-00004
	5.0	1	094-500060-00005

MT551W U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch,	3.0	1	094-500121-00200
up/down, water cooled, with X	4.0	1	094-500121-00204
Technology	5.0	1	094-500121-00205

MIG/MAG welding torches - MT welding torch water cooled

MT551W 2U/D X



- Water-cooled MIG/MAG function torch
 - **Setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG function torch, water-cooled, with X technology	3.0	1	094-500121-00300
	4.0	1	094-500121-00304
	5.0	1	094-500121-00305

MT551W PC1 X



- Water-cooled MIG/MAG function torch
 - Displaying and setting of welding current and wire feed speed
 - Program selection also available as an option
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3.0	1	094-500121-00400
	4.0	1	094-500121-00404
	5.0	1	094-500121-00405

MT551W PC2 X



- Water-cooled MIG/MAG function torch
 - **Display and setting of:**
 - Welding current and wire feed speed
 - Voltage correction
 - Program and JOB selection
- Only suitable for Titan XQ puls and EWM Multimatrix welding machines
- Safe and rugged; without control cable and additional connector plug
- All MT function torches are also available with additional control cable for connecting to EWM welding machines without X technology – ask us!

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire Ø	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	094-500121-00700
welding torch,	4.0	1	094-500121-00704
Powercontrol 2, water cooled, with X technology, replaceable neck	5.0	1	094-500121-00705

MIG/MAG welding torches - UM welding torch

- Ty-related standard consumables



Torch connection

Euro torch connector

Approvals



UM 15 G



- Practical and light MIG/MAG welding torch for use on construction sites and in workshops
- Ergonomic grip
- Anti-kink spring on the connection
- **Equipment as supplied (steel wire):**
- Gas nozzle, conical, Ø 12 mm; 53 mm
- Contact tip M6 x 25 mm; Ø 0.8 mm
- Contact tip holder M6

Duty cycle CO2	180 A / 60 %
Duty cycle M21	150 A / 60 %
Wire Ø	0.6 mm - 1 mm

Designation	Hose package length	PU	Item no.
	m		
MIG/MAG welding torch, gas-cooled	3.0	1	394-600000-00000
	4.0	1	394-600000-00004
	5.0	1	394-600000-00005

UM 24 G



- Gas-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.0):**
- Gas nozzle, conical, Ø 12.5 mm; 63.5 mm
- Gas diffuser, 20 mm
- Contact tip M6 x 28 mm; Ø 1.0 mm
- Contact tip holder M6 x 26 mm

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Wire Ø	0.6 mm - 1.2 mm

Designation	Hose package length	PU	Item no.
	m		
MIG/MAG welding torch, gas-cooled	3.0	1	394-600001-00000
	4.0	1	394-600001-00004
	5.0	1	394-600001-00005

UM 25 G

- Gas-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.0):**
- Gas nozzle, conical, Ø 15 mm; 57 mm
- Contact tip M6 x 28 mm; Ø 1.0 mm
- Contact tip holder M6 x 35 mm

Duty cycle CO2	230 A / 60 %
Duty cycle M21	200 A / 60 %
Wire Ø	0.6 mm - 1.2 mm

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	394-600002-00000
	4.0	1	394-600002-00004
	5.0	1	394-600002-00005

UM 36 G

- Gas-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.2):**
- Gas nozzle, conical, Ø 16 mm; 84 mm
- Gas diffuser, 32.5 mm
- Contact tip M8 x 30 mm; Ø 1.2 mm
- Contact tip holder M8 x 35 mm

Duty cycle CO2	300 A / 60 %
Duty cycle M21	270 A / 60 %
Wire Ø	0.8 mm - 1.4 mm

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, gas-cooled	3.0	1	394-600003-00000
	4.0	1	394-600003-00004
	5.0	1	394-600003-00005

MIG/MAG welding torches - UM welding torch

UM 240 W



- Water-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.0):**
- Gas nozzle, conical, Ø 12.5 mm; 63.5 mm
- Gas diffuser, 20 mm
- Contact tip M6 x 28 mm; Ø 1.0 mm
- Contact tip holder M6 x 26 mm

Duty cycle CO2	300 A / 100 %
Duty cycle M21	270 A / 100 %
Wire Ø	0.6 mm - 1.2 mm

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	394-600010-00000
	4.0	1	394-600010-00004
	5.0	1	394-600010-00005

UM 401 W



- Water-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.2):**
- Gas nozzle, conical, Ø 16 mm; 76 mm
- Gas diffuser, "Longlife", 28 mm
- Contact tip M8 x 30 mm; Ø 1.2 mm
- Contact tip holder M8 x 25 mm

Duty cycle CO2	400 A / 100 %
Duty cycle M21	350 A / 100 %
Wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
MIG/MAG welding torch, water-cooled	3.0	1	394-600011-00000
	4.0	1	394-600011-00004
	5.0	1	394-600011-00005

UM 501 W



- Water-cooled standard MIG/MAG welding torch
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- **Equipment as supplied (steel wire Ø 1.2):**
- Gas nozzle, conical, Ø 16 mm; 76 mm
- Gas diffuser, "Longlife", 28 mm
- Contact tip M8 x 30 mm; Ø 1.2 mm
- Contact tip holder M8 x 25 mm

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
MIG/MAG	3.0	1	394-600012-00000
welding torch,	4.0	1	394-600012-00004
water-cooled	5.0	1	394-600012-00005

MIG/MAG welding torches - TIG welding torch with Euro torch connector

- Single-push button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Excellent HF safety



Torch connection	Euro torch connector
Control cable connection	Tuchel, 5-pole
Approvals	CE

TIG 150 GRIP GD EZA



- Gas-cooled TIG welding torch
- Euro torch connector for the oration on gas-cooled MIG/MAG welding machines

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, Euro	4.0	1	394-512291-04000
torch connector	8.0	1	394-512291-04008

TIG 200 GRIP GD EZA



- Gas-cooled TIG welding torch
- Euro torch connector for the oration on gas-cooled MIG/MAG welding machines

Duty cycle DC-	200 A / 35 %
Duty cycle AC	140 A / 35 %
Electrode Ø	3.2 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, Euro	4.0	1	394-510981-04000
torch connector	8.0	1	394-510981-04008

TIG 450 GRIP WD EZA



- Water-cooled TIG welding torch
- Euro torch connector for the oration on water-cooled MIG/MAG welding machines

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %

Designation	Hose package length m	PU	Item no.
TIG welding torch, Euro	4.0	1	394-510993-04000
torch connector	8.0	1	394-510993-04008

Cooling units - Cooling units for MIG/MAG welding machines

- Cooling unit for water-cooled welding torches
- 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
- Excellent torch cooling and therefore cost savings on consumables thanks to the high-performance centrifugal pump
- External coolant water filling nozzle with filling level indicator

cool50



- Water connections in the front, for compact machines (TKM).

Cooling output	1000 W (1l/min)
Tank capacity	5 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	695 x 298 x 329

Designation	Weight, cooling unit kg	Cooling output	Flow rate l/min	Coolant outlet pressure bar	PU	Item no.
Cooling unit with centrifugal pump	16.5	1000 W (1l/min)	5.0	3.5	1	090-008598-00502
Cooling unit with boosted pump	17.0	1000 W	20.0	4.5	1	090-008797-00502
Packing unit: 6 x cool50 U40	16.5	1000 W (1l/min)	5.0	3.5	1	092-015332-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Picomig 355 Synergic TKM	090-005512-00502	235
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Picomig 355 puls TKM	090-005542-00502	233	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128

cool50-2 U40



- Water connections on the front and rear, for decompact machines (TDM).
- **Use of cooling unit with reinforced pump:** up to 70 m overall hose package length for decompact machines with separate wire feeder plus additional miniDrive, up to 45 m for decompact machines without additional miniDrive

Cooling output	1000 W (1l/min)
Tank capacity	5 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	695 x 298 x 329

Designation	Weight, cooling unit kg	Flow rate l/min	Coolant outlet pressure bar	PU stk	Item no.
Cooling unit with centrifugal pump	16.5	5.0	3.5	1	090-008603-00502
Cooling unit with boosted pump	17.0	20.0	4.5	1	090-008796-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 355 Basic TDM	090-005286-00502	198
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 505 Basic S	090-005601-00502	181
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Taurus 505 Basic TDM	090-005221-00502	200
Taurus 405 Basic S	090-005591-00502	180	Taurus 505 Synergic S MM TDM	090-005338-00502	132

Cooling units - Coolant

KF 23E -10



- Coolant for water-cooled welding machines and cooling units

Designation	Freezing point °C	Contents l	PU	Item no.
Coolant (-10 °C), 5 l	-10.0	5.0	1	094-000530-00005
Coolant (-10 °C), 200 l		200	1	094-000530-00001

KF 37E -20°



- Coolant for water-cooled welding machines and cooling units

Designation	Freezing point °C	Contents l	PU	Item no.
Coolant (-20 °C), 5 l	-20.0	5.0	1	094-006256-00005
Coolant (-20 °C), 200 l		200	1	094-006256-00001

Options/accessories - Options for MIG/MAG welding machines

ON Case



- Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6
- All tools and replacement parts always to hand.
- Only available in conjunction with Trolley 55-5 without an additional cooling unit
- In conjunction with Trolley 55-6, if using a cooling unit, the option "ON Extender" must also be ordered

Designation	PU	Item no.
	stk	
Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Taurus 355 Basic TDM	090-005286-00502	198
Microplasma 25	090-007027-00502	390	Taurus 355 Basic TKM	090-005406-00502	196
Microplasma 55	090-007028-00502	390	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 505 Basic S	090-005601-00502	181
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Trolley 55-5	090-008632-00000	473
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Trolley 55-5 DM	090-008632-00001	473
Picomig 185 puls TKG	090-005547-00502	229	Trolley 55-6 DF	090-008826-00000	474
Picomig 185 Synergic TKG	090-005548-00502	231	Trolley 55-6	090-008825-00000	474
Picomig 355 puls TKM	090-005542-00502	233			
Picomig 355 Synergic TKM	090-005512-00502	235			
Taurus 405 Basic S	090-005591-00502	180			

ON HS F.0001/F.0002



- 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 Phoenix/Taurus/Tetrix 351/401/451/551 machines

Designation	PU stk	Item no.
Mount for hose packages and welding torch	1	092-002910-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S MM FDW	090-005346-00502	141	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

Options/accessories - Options for MIG/MAG welding machines

ON Shock Protect F.0001



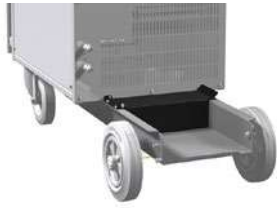
- Ram protection: protects the machine from scratches and dents. Highly recommended if the machine is transported frequently
- Not possible in combination with parking brake, wheel spacers or double cylinder cart!

Designation	PU stk	Item no.
Ram protection	1	092-002154-0000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Taurus 351 Basic FDG	090-005389-00502	208	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 401 Basic FKG	090-005426-00502	204	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 401 Basic FKW	090-005408-00502	206	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Tetrix 551 Synergic FW	090-000093-00502	360

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

Designation	PU stk	Item no.
Toolbox between gas cylinder and rear casing panel	1	092-002138-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Basic FKW	090-005408-00502	206
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 401 Basic FKG	090-005426-00502	204	Tetrix 551 Synergic FW	090-000093-00502	360

Options/accessories - Options for MIG/MAG welding machines

OW Reinforced Pump F.0001/F.0002



- 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

Designation	PU stk	Item no.
Heavy-duty coolant pump (only ex works)	1	092-002118-0001

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Basic FKW	090-005408-00502	206			
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136			

OW Reinforced Pump F.0005



- Reinforced coolant pump

Designation	PU stk	Item no.
Heavy-duty coolant pump (only ex works)	1	092-002119-00001

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 401 FDW	090-004949-00502	254	Wega 501 FDW	090-005088-00502	255
Wega 401 M1.02 FKW	090-005227-00502	250	Wega 601 FDW	090-005089-00502	255

HASE XX1



- Length of support arm adjustable
- Adjustable angle of inclination allows for different radii of oration
- Integrated torch holder
- Available for all demodular, decompact machines
- Carriage of the power source must have a tread width of at least 490 mm
- Set option for retrofitting Wega contains:
 - Support arm
 - Pivot support
 - Assembly material

Designation	Version	PU stk	Item no.
Set: Torch hose package support arm (ex works only)	For alpha Q, Phoenix, Taurus with drive 4X, drive 4L and drive 4	1	092-007921-00001
	For Wega 401 with drive 41L	1	092-007922-00000
	For Wega 401 with drive 41	1	092-007925-00000
	For Wega 501, Wega 601 with drive 41L	1	092-007923-00000
	For Wega 501, Wega 601 with drive 41	1	092-007926-00000

ON Filter T.0005



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002553-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picomig 180 puls TKG Set	091-005545-00502	225	Picomig 180 Synergic Set	091-005546-00502	227
Picomig 180 puls TKG	090-005545-00502	224	Picomig 180 Synergic TKG	090-005546-00502	226

Options/accessories - Options for MIG/MAG welding machines

ON Filter TG.0004/TG.0009/K.0002



- Dirt filter for air inlet
- Reliably protects the machine from impurities in difficult working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002698-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
cool50-2 U40	090-008603-00502	320	Taurus 405 Basic S	090-005591-00502	180
cool50-2 U42	090-008796-00502	320	Taurus 355 Basic TDM	090-005286-00502	198
Cool 50 MPW50	090-008818-00502	402	Taurus 355 Synergic S MM TDM	090-005336-00502	130
cool50 U40	090-008598-00502	320	Taurus 405 Basic TDM	090-005241-00502	199
cool50 U42	090-008797-00502	320	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Microplasma 105	090-007029-00502	390	Taurus 505 Basic S	090-005601-00502	181
Microplasma 25	090-007027-00502	390	Taurus 505 Basic TDM	090-005221-00502	200
Microplasma 55	090-007028-00502	390	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102			
Phoenix 355 Progress puls MM TDM	090-005320-00502	98			
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103			
Phoenix 405 Progress puls MM TDM	090-005321-00502	99			
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104			
Phoenix 505 Progress puls MM TDM	090-005322-00502	100			
Set Taurus 505 Basic Duo Gouging	092-008313-00000	201			

ON Filter TG.0003



- Dirt filter for air inlet
- Comprised of two filter units

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002662-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Picomig 355 puls TKM	090-005542-00502	233
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Picomig 355 Synergic TKM	090-005512-00502	235
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Basic TKM	090-005406-00502	196
Picomig 185 puls TKG	090-005547-00502	229	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Picomig 185 Synergic TKG	090-005548-00502	231	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128

ON Filter F.0004



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002090-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	243	Saturn 351 FDG	090-004991-00502	247
Saturn 301 M2.20 FKG	090-004978-00502	244	Saturn 351 M1.02 FKG	090-004983-00502	243
Saturn 301 M2.40 FKG	090-004979-00502	244	Saturn 351 M2.20 FKG	090-004984-00502	245
			Saturn 351 M2.40 FKG	090-004985-00502	245

ON Filter F.0001



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU	Item no.
Dirt filter for air inlet	1	092-002092-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Basic FDG	090-005249-00502	208
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Basic FDW	090-005250-00502	211
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Basic FKG	090-005426-00502	204
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Basic FKW	090-005408-00502	206
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S LP MM FKW	090-005428-00502	134	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360

ON Filter F.0005



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU	Item no.
Dirt filter for air inlet	1	092-002091-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 401 FDW	090-004949-00502	254	Wega 401 M1.02 FKW	090-005227-00502	250
Wega 401 FDG	090-004948-00502	252	Wega 401 M2.20 FKG	090-005225-00502	249
Wega 401 M1.02 FKG	090-005224-00502	248	Wega 401 M2.40 FKG	090-005226-00502	249

Options/accessories - Options for MIG/MAG welding machines

ON FILTER WEGA 501/601



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002730-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 501 FDW	090-005088-00502	255	Wega 601 FDW	090-005089-00502	255

OW Key Switch TG.0003



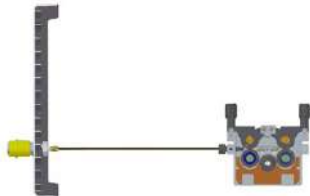
- Key switch for locking the welding machine control (ex works only)
- For modular compact machines

Designation	PU stk	Item no.
Key switch for locking the welding machine control (ex works only)	1	092-002666-00001

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
			Taurus 355 Synergic S HP MM TKM	090-005407-00502	128

ON D Barrel TG.0003



Designation	PU stk	Item no.
Wire guide Rolliner for drum feed	1	092-007929-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Picomig 355 puls TKM	090-005542-00502	233
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Picomig 355 Synergic TKM	090-005512-00502	235
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Basic TKM	090-005406-00502	196
Picomig 185 puls TKG	090-005547-00502	229	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Picomig 185 Synergic TKG	090-005548-00502	231	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128

ON CS T.0005/TG.0003/D.0002



- Crane susnsion
- For compact power sources, such as Picomig 355 TKG and Phoenix 355 puls MM TKM, the additional ON FIX CS K option for securing is required.

Designation	Version	PU stk	Item no.
Crane susnsion	Crane susnsion	1	092-002549-00000
Fastening	Fastening	1	092-002741-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Picomig 355 Synergic TKM	090-005512-00502	235
drive 4X IC HP	090-005414-00502	148	Saturn M1.02 drive 41	090-004992-00502	258
drive 4X IC LP	090-005415-00502	148	Saturn M2.20 drive 41	090-004993-00502	258
ON CS T.0005/TG.0003/D.0002	092-002549-00000	331	Saturn M2.40 drive 41	090-004994-00502	258
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Drive 4 Basic S D200	090-005596-00502	182
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Pico drive 200C	090-002124-00502	427	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Picomig 180 puls TKG Set	091-005545-00502	225	Wega M1.02 drive 41	090-004962-00502	258
Picomig 180 puls TKG	090-005545-00502	224	Wega M2.20 drive 41	090-004963-00502	258
Picomig 185 puls TKG	090-005547-00502	229	Wega M2.40 drive 41	090-004964-00502	258
Picomig 185 Synergic TKG	090-005548-00502	231			
Picomig 355 puls TKM	090-005542-00502	233			

ON CS TG.0004



Designation	PU stk	Item no.
Crane console, transport/ram protection	1	092-007895-00032

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Taurus 355 Basic TDM	090-005286-00502	198	Taurus 505 Basic TDM	090-005221-00502	200
			Taurus 505 Synergic S MM TDM	090-005338-00502	132

Options/accessories - Options for MIG/MAG welding machines

ON PS drive 4L/4X F.0001



- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine
- Für Drahtvorschubgeräte drive 4X und drive 4L

Designation	PU stk	Item no.
Pivot support (360°) for wire feeders	1	092-002112-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4X HP	090-005392-00502	144	Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114
drive 4 Basic MMA	090-005401-51502	213	Phoenix 551 Progress puls MM FDW	090-005328-00502	111
drive 4 Basic	090-005401-00502	213	Taurus 351 Basic FDG	090-005389-00502	208
drive 4X EX	090-005511-00502	144	Taurus 351 Basic FDW	090-005390-00502	211
drive 4X EX GFE	090-005511-55502	144	Taurus 351 Synergic S MM FDG	090-005341-00502	138
drive 4X EX MMA	090-005511-51502	144	Taurus 351 Synergic S MM FDW	090-005345-00502	141
drive 4X EX MMA GFE	090-005511-60502	144	Taurus 401 Basic FDG	090-005249-00502	208
drive 4X HP GFE	090-005392-55502	144	Taurus 401 Basic FDW	090-005250-00502	211
drive 4X HP MMA GFE	090-005392-60502	144	Taurus 401 Synergic S MM FDG	090-005342-00502	138
drive 4X LP	090-005412-00502	143	Taurus 401 Synergic S MM FDW	090-005346-00502	141
drive 4X LP GFE	090-005412-55502	143	Taurus 451 Basic FDG	090-005176-00502	208
drive 4X LP MMA	090-005412-51502	143	Taurus 451 Basic FDW	090-005150-00502	211
drive 4X LP MMA GFE	090-005412-60502	143	Taurus 451 Synergic S MM FDG	090-005343-00502	139
drive 4X HP MMA	090-005392-51502	144	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114			
Phoenix 451 Progress puls MM FDW	090-005327-00502	111			

ON PS drive 41L F.0005



- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine
- Only for Wega 401

Designation	PU stk	Item no.
Pivot support, horizontal for Drive 41L	1	092-002113-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 401 FDW	090-004949-00502	254	Wega M1.02 drive 41L	090-004965-00502	258
Wega 401 FDG	090-004948-00502	252	Wega M2.20 drive 41L	090-004966-00502	258
			Wega M2.40 drive 41L	090-004967-00502	258

ON DK drive 4L Wega 501/601



- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine
- For Wega 501/601

Designation	PU stk	Item no.
Pivot support, horizontal for Drive 41L	1	092-002635-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 501 FDW	090-005088-00502	255	Wega M1.02 drive 41L	090-004965-00502	258
Wega 601 FDW	090-005089-00502	255	Wega M2.20 drive 41L	090-004966-00502	258
			Wega M2.40 drive 41L	090-004967-00502	258

ON PS drive IC F.0001



- Pivot support for wire feeder without pin holder
- Wire feeder pivots 360° on the welding machine

Designation	PU stk	Item no.
Pivot support (360°) for wire feeders	1	092-002280-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Taurus 401 Basic FDG	090-005249-00502	208
drive 4X IC HP	090-005414-00502	148	Taurus 401 Basic FDW	090-005250-00502	211
drive 4X IC LP	090-005415-00502	148	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Taurus 351 Basic FDG	090-005389-00502	208	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Taurus 351 Basic FDW	090-005390-00502	211	Taurus 551 Basic FDG	090-005178-00502	209
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Taurus 551 Basic FDW	090-005151-00502	212
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Taurus 551 Synergic S MM FDG	090-005344-00502	139
			Taurus 551 Synergic S MM FDW	090-005348-00502	142

ON PS drive 41 F.0005



- Pivot support for wire feeders
- Only for Wega 401
- Cannot be used with wheel assembly kit 090-008035-00000

Designation	PU stk	Item no.
Pivot support, horizontal for Drive 41	1	092-002522-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 401 FDW	090-004949-00502	254	Wega M1.02 drive 41	090-004962-00502	258
Wega 401 FDG	090-004948-00502	252	Wega M2.20 drive 41	090-004963-00502	258
			Wega M2.40 drive 41	090-004964-00502	258

Options/accessories - Options for MIG/MAG welding machines

ON DK drive 41 Wega 501/601



- Pivot support for wire feeders
- Cannot be used with wheel assembly kit 090-008035-00000

Designation	PU stk	Item no.
Pivot support, horizontal for Drive 41	1	092-000680-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Wega 501 FDW	090-005088-00502	255	Wega M1.02 drive 41	090-004962-00502	258
Wega 601 FDW	090-005089-00502	255	Wega M2.20 drive 41	090-004963-00502	258
			Wega M2.40 drive 41	090-004964-00502	258

ON PS drive IC 4 Wheels F.0001



- Pivot support including wheel kit for wire feeder without pin holder
- Wire feeder pivots 360° on the welding machine

Designation	PU stk	Item no.
Pivot support including wheel kit	1	092-002284-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
drive 4 IC Basic	090-005416-00502	216	Taurus 401 Basic FDW	090-005250-00502	211
drive 4X IC HP	090-005414-00502	148	Taurus 401 Synergic S MM FDG	090-005342-00502	138
drive 4X IC LP	090-005415-00502	148	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Taurus 351 Basic FDG	090-005389-00502	208	Taurus 551 Basic FDG	090-005178-00502	209
Taurus 351 Basic FDW	090-005390-00502	211	Taurus 551 Basic FDW	090-005151-00502	212
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Taurus 401 Basic FDG	090-005249-00502	208			

ON Holder Gas Bottle <50L F.0001/F.0005



- 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!

Designation	PU stk	Item no.
Holding plate for gas cylinders smaller than 50 litres	1	092-002151-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 401 Basic FKG	090-005426-00502	204	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Basic FKW	090-005408-00502	206	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Wega 401 FDW	090-004949-00502	254
Taurus 401 Synergic S MM FDW	090-005346-00502	141	Wega 401 FDG	090-004948-00502	252

Options/accessories - Options for MIG/MAG welding machines

ON Shock Protect F.0001



- 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!

Designation	PU stk	Item no.
Ram protection	1	092-002154-0000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Taurus 351 Basic FDG	090-005389-00502	208	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 401 Basic FKG	090-005426-00502	204	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 401 Basic FKW	090-005408-00502	206	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Tetrix 551 Synergic FW	090-000093-00502	360

ON LB Wheels 160 x 40 mm



- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.
- Locking brake cannot be combined with ram protection!

Designation	PU stk	Item no.
Locking brake for machine wheels	1	092-002110-00000

Suitable for:

Typ	Artikel-Nr.	Seite	Typ	Artikel-Nr.	Seite
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 501 Basic FKW	090-005410-00502	185
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Basic FDG	090-005249-00502	208	Wega 401 M1.02 FKG	090-005224-00502	248
Taurus 401 Basic FDW	090-005250-00502	211	Wega 401 M1.02 FKW	090-005227-00502	250
Taurus 401 Basic FKG	090-005426-00502	204	Wega 401 M2.20 FKG	090-005225-00502	249
Taurus 401 Basic FKW	090-005408-00502	206	Wega 401 M2.40 FKG	090-005226-00502	249
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Wega 501 FDW	090-005088-00502	255
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Wega 601 FDW	090-005089-00502	255
Taurus 401 Synergic S MM FDW	090-005346-00502	141			

Options/accessories - Options for MIG/MAG welding machines

ON LB Wheels 125 x 38 mm



- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.

Designation	PU stk	Item no.
Locking brake for machine wheels	1	092-002109-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	243	Saturn 351 FDG	090-004991-00502	247
Saturn 301 M2.20 FKG	090-004978-00502	244	Saturn 351 M1.02 FKG	090-004983-00502	243
Saturn 301 M2.40 FKG	090-004979-00502	244	Saturn 351 M2.20 FKG	090-004984-00502	245
			Saturn 351 M2.40 FKG	090-004985-00502	245

ON WAK TG.0003/TG.0004/TG.0009/K.0002



- Wheel set – facilitates work at frequently changing welding sites

Designation	PU stk	Item no.
Wheel assembly kit	1	092-001356-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
cool50-2 U40	090-008603-00502	320	Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104
cool50-2 U42	090-008796-00502	320	Phoenix 505 Progress puls MM TDM	090-005322-00502	100
Cool 50 MPW50	090-008818-00502	402	Picomig 185 puls TKG	090-005547-00502	229
cool50 U40	090-008598-00502	320	Picomig 185 Synergic TKG	090-005548-00502	231
cool50 U42	090-008797-00502	320	Picomig 355 puls TKM	090-005542-00502	233
Microplasma 105	090-007029-00502	390	Picomig 355 Synergic TKM	090-005512-00502	235
Microplasma 25	090-007027-00502	390	Taurus 355 Basic TDM	090-005286-00502	198
Microplasma 55	090-007028-00502	390	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 505 Synergic S MM TDM	090-005338-00502	132

ON Drahteinschleich Poti M1.02



Designation	PU stk	Item no.
Rotary knob for setting the wire creep sed	1	092-001102-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 FDW	090-004949-00502	254
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 FDG	090-004948-00502	252
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M1.02 FKG	090-005224-00502	248
Saturn 351 FDG	090-004991-00502	247	Wega 401 M1.02 FKW	090-005227-00502	250
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 351 M2.20 FKG	090-004984-00502	245	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 351 M2.40 FKG	090-004985-00502	245	Wega 501 FDW	090-005088-00502	255
			Wega 601 FDW	090-005089-00502	255

ON AIF TG.0003



- Analogue interface for automated welding for Phoenix Progress
- In machines with Exrt 2.0 control, the interface is already fitted ex works

Designation	PU stk	Item no.
Interface for automated welding	1	092-001237-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94

ON AIF TG.0004



- Analogue interface for automated welding for Phoenix Progress
- In machines with Exrt 2.0 control, the interface is already fitted ex works

Designation	PU stk	Item no.
Analogue interface for automated welding for modular Phoenix Progress	1	092-007891-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Phoenix 505 Progress puls MM TDM	090-005322-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	99			

Options/accessories - Options for MIG/MAG welding machines

ON AIF F.0001



- Analogue interface for automated welding for Phoenix Progress
- In machines with Exrt 2.0 control, the interface is already fitted ex works

Designation	PU	Item no.
Analogue interface for automated welding for Phoenix Progress	1	092-001779-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Phoenix 451 Progress puls MM FDW	090-005327-00502	111
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Phoenix 551 Progress puls MM FDW	090-005328-00502	111

A/V EN 1090

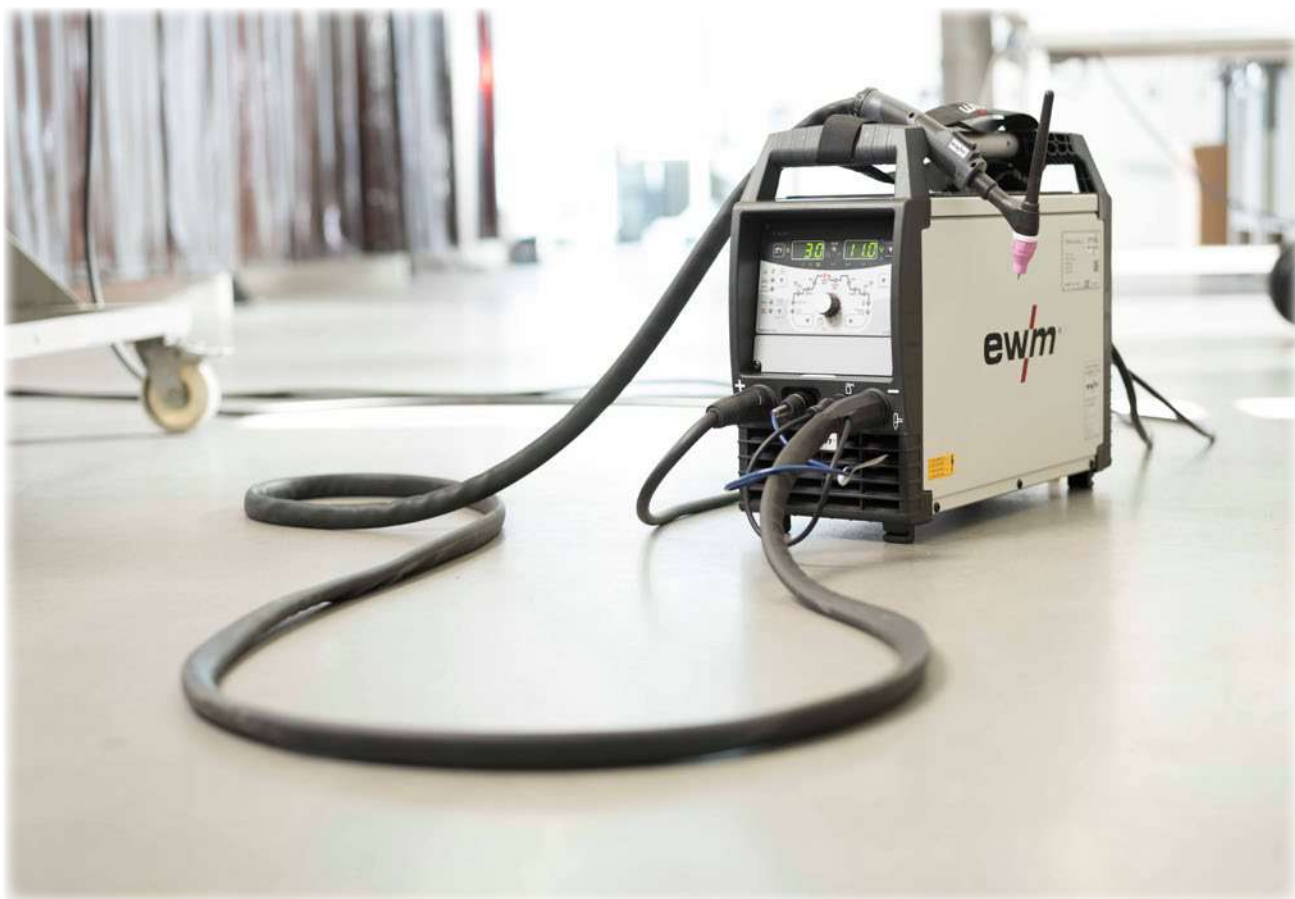
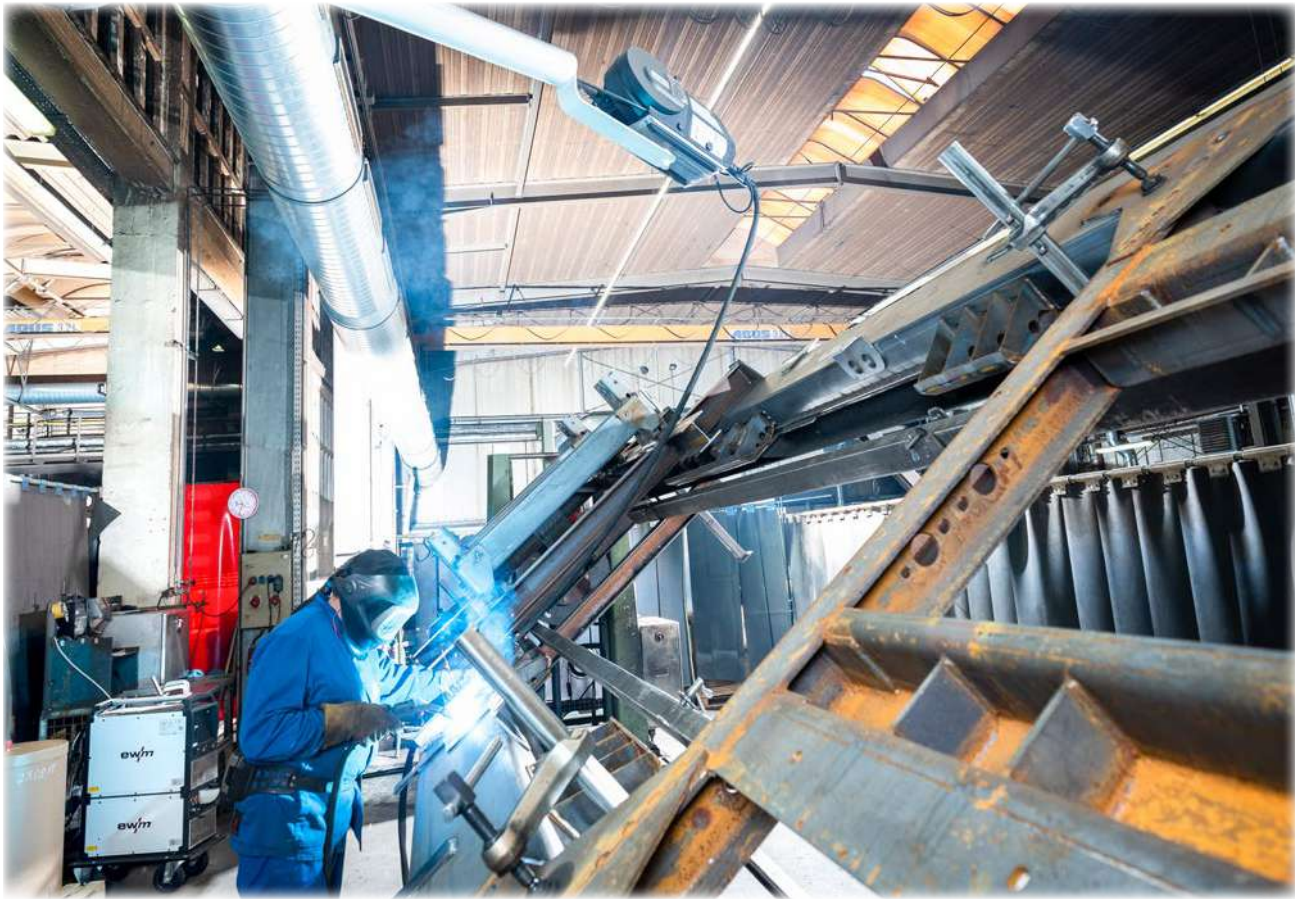


- External indication unit for welding current (A) and welding voltage (V)
- For retrofitting all welding machines without digital control
- Fastening by means of hooks at lifting eyes of the welding machine or by means of magnets

Designation	PU	Item no.
Display unit for non digital welding machines within the sco of EN 1090	1	w

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Mira 151 FKG	090-005084-00502	236	Saturn 351 M2.20 FKG	090-004984-00502	245
Mira 221 MV FKG	090-005085-00502	236	Saturn 351 M2.40 FKG	090-004985-00502	245
Mira 251 FKG	090-005086-00502	237	Wega 401 FDW	090-004949-00502	254
Mira 301 M1.02 FKG	090-005181-00502	237	Wega 401 FDG	090-004948-00502	252
Mira 301 M2.20 FKG	090-005207-00502	238	Wega 401 M1.02 FKG	090-005224-00502	248
Mira 301 M2.40 FKG	090-005182-00502	238	Wega 401 M1.02 FKW	090-005227-00502	250
Saturn 301 M1.02 FKG	090-004977-00502	243	Wega 401 M2.20 FKG	090-005225-00502	249
Saturn 301 M2.20 FKG	090-004978-00502	244	Wega 401 M2.20 FKW	090-005228-00502	251
Saturn 301 M2.40 FKG	090-004979-00502	244	Wega 401 M2.40 FKG	090-005226-00502	249
Saturn 351 FDG	090-004991-00502	247	Wega 401 M2.40 FKW	090-005229-00502	251
Saturn 351 M1.02 FKG	090-004983-00502	243	Wega 501 FDW	090-005088-00502	255
			Wega 601 FDW	090-005089-00502	255

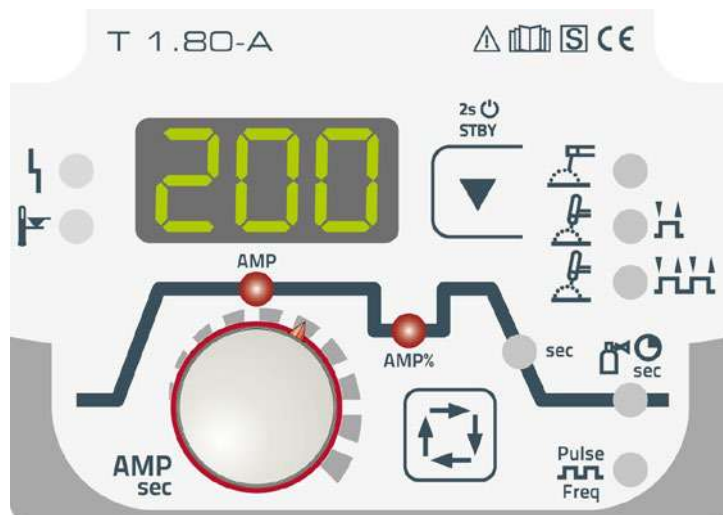


Overview TIG / Plasma welding machines

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			TIG-SR 18 GRIP WD HW U/D HFL	376
			TIG-SR 18 GRIP WD CW WO U/D HFL	377
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Control description Picotig



Welding process	TIG MMA
Orating modes	Non-latched
Ignition options	HF Liftarc
Pulse ty	Average value pulse welding
Parameters in display	Welding current Times
MMA functions	Hotstart Arcforce Antistick Average value pulse welding

- Practical reduction of the orating elements down to the most important functions

Picotig 200 puls | Picotig 200 puls Multivolt



Picotig DC



Control	Page	344
Welding torches	Page	381
Remote controls	Page	392


- Gas-cooled DC TIG inverter welding machine
- Multivolt version: Can be used worldwide thanks to automatic adjustment of mains voltage (115 V/230 V)
- **TIG welding**
 - Electronic HF start
 - TIG lift arc welding without HF
 - MMA pulse welding and pulsed TIG welding up to 2 kHz
 - Non-latched/latched operation
 - Reduced secondary current accessible using torch trigger
 - Adjustable up-slo and down-slo time
 - Adjustable gas pre- and post-flow time
- **MMA welding**
 - Adjustable hot start current and hot start time
 - Adjustable Arcforce
 - Antistick function
- **Highlights**
 - Energy-saving thanks to high efficiency and standby function
 - Portable, including shoulder strap
 - 3.5 m mains supply lead with 16 A shock-proof plug
 - 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**




Version	Picotig 200	Picotig 200 MV	
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-40 % - +15 %)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 20 A	1 x 16 A
On circuit voltage	90 V	90 V	90 V
Setting range for welding current	5 A - 200 A	5 A - 150 A	5 A - 200 A
Duty cycle 40 °C	200 A / 25 %	–	200 A / 25 %
	–	150 A / 35 %	–
	150 A / 60 %	120 A / 60 %	150 A / 60 %
	140 A / 100 %	100 A / 100 %	140 A / 100 %
cos φ		0.99	
Efficiency		86 %	
Dimensions machine, LxWxH in mm	428 x 136 x 252	428 x 181 x 294	
Weight, machine	8 kg	9.8 kg	
EMC class		A	
Insulation class		H	
Protection class		IP23	
Approvals			

Picotig 200 puls | Picotig 200 puls Multivolt


Standard version

Icon	Ty	Designation	PU	Item no.
	Picotig 200 puls TG	TIG DC welding machine, portable, gas, decentral	1	090-002058-00502
	TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	1	394-512291-00600
	TIG 150 GD GRIP 5P 8m		1	394-512291-00608
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
-	CBP Picotig	Transport case, empty	1	094-012322-00500
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Multivolt

Icon	Ty	Designation	PU	Item no.
	Picotig 200 MV puls TG	TIG multivolt inverter welding machine	1	090-002059-00502
	TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	1	394-512291-00600
	TIG 150 GD GRIP 5P 8m		1	394-512291-00608
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
-	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Sets

Icon	Ty	Designation	PU	Item no.
	Set Picotig 200 puls 5P D		1	091-002058-00502
	Set Picotig 200 puls 5P RU		1	091-002058-00508
	Set Picotig 200 puls 5P DK/FI/NL/NO/SE	Set: TIG torch, welding lead, 2 m gas hose, pressure regulator in case	1	091-002058-00540
	Set Picotig 200 puls 5P GB		1	091-002058-00537
	Set Picotig 200 puls 5P	Set: TIG torch, welding lead, 2 m gas hose in case	1	091-002058-00539

► * Only the items in bold are included in the total

Packing unit

8x Picotig 200 puls 5P Packing unit: 8x Picotig 200 puls, without accessories 092-015276-00502

Set with pressure regulator W 21,80 x 1/14" + G 1/4" and gas hose G 1/4" + G 1/4"

6x Picotig 200 puls Set D Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose, pressure regulator 092-015277-00502

Set with W 23.32 x 14/1" pressure regulator and G 3/8" + G 1/4" gas hose

6x Picotig 200 puls Set DK/FI/NL/NO/SE Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose, pressure regulator 092-015277-00540

Set with G 3/4" + G 3/8" pressure regulator and G 3/8" + G 1/4" gas hose

6x Picotig 200 puls Set RU Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose, pressure regulator 092-015277-00508

Set with G 5/8" + G 3/8" pressure regulator and G 3/8" + G 1/4" gas hose

6x Picotig 200 puls Set GB Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose, pressure regulator 092-015277-00537

Set without pressure regulator

6x Picotig 200 puls Set Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose 092-015277-00539

Control description Picotig AC



- Practical reduction of the orating elements down to the most important functions

Welding process	TIG MMA
	TIG AC
Orating modes	Non-latched
Ignition options	HF Liftarc
Pulse ty	Average value pulse welding
Parameters in display	Welding current Welding voltage Welding power
MMA functions	Hotstart Arcforce Antistick Average value pulse welding

Picotig 200 AC/DC puls TG



Picotig AC/DC





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- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- 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
- Reduced secondary current accessible using torch trigger
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- 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
- Trolley 35.2-2, Trolley 55-5 and Trolley 55-6 trolleys available
- 3.5 m mains supply lead with 16 A shock-proof plug
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Version	Picotig 200
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On circuit voltage	43 V
Setting range for welding current	3 A - 200 A
Duty cycle 40 °C	200 A / 35 %
	150 A / 60 %
	140 A / 100 %
cos φ	0.99
Efficiency	85 %
Dimensions machine, LxWxH in mm	539 x 210 x 415
Weight, machine	16.5 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Dimensions cooling unit in mm	603 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

Gas cooled

Icon	Ty	Designation	PU	Item no.
	Picotig 200 AC/DC puls 5P TG	AC/DC TIG welding machine, portable, gas, decentral, 5-pole connection socket	1	090-000188-00502
	TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	1	394-512291-00600
	TIG 150 GD GRIP 5P 8m		1	394-512291-00608
	Picotig 200 AC/DC puls 8P TG	AC/DC TIG welding machine, portable, gas, decentral, 8-pole connection socket	1	090-000188-00504
	TIG 150 GD GRIP 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-512291-00200
	TIG 150 GD GRIP 8P U/D 8m		1	394-512291-00208
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module,	1	090-008296-00000
	Trolley 55-6	10 l–50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

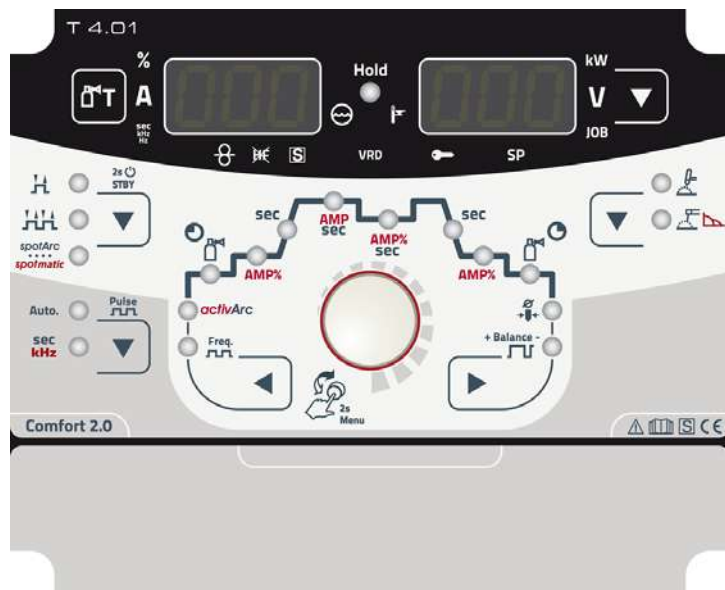
Icon	Ty	Designation	PU	Item no.
	Picotig 200 AC/DC puls 5P TG	AC/DC TIG welding machine, portable, gas, decentral, 5-pole connection socket	1	090-000188-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m		1	394-510990-00608
	Picotig 200 AC/DC puls 8P TG	AC/DC TIG welding machine, portable, gas, decentral, 8-pole connection socket	1	090-000188-00504
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m		1	394-510990-00208
	cool40 U31	Cooling unit with centrifugal pump	1	090-008593-00502
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	Trolley 35.2-2	Trolley for power source, 1 module,	1	090-008296-00000
	Trolley 55-6	10 l–50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	1	090-008632-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

6x Picotig 200 AC/DC puls 5P	Packing unit: 6x Picotig 200 AC/DC puls, 5-pole connection socket	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

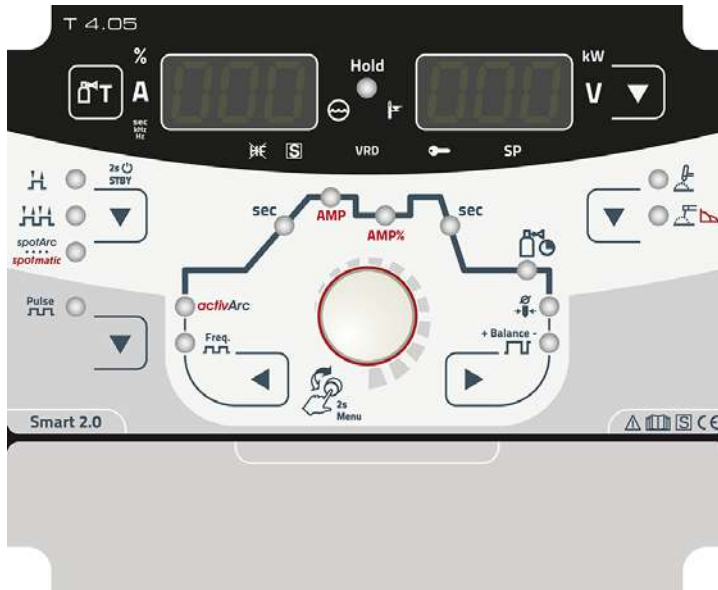
Control description Comfort 2.0 DC



- **One-knob oration**
- Welding sequence selection and parameter setting using click wheel or conventional oration with sequence buttons (back/forward)
- Exrt menu for advanced welding parameter settings
- **Welding sequence parameter setting**
- Start, welding, secondary and end current
- Up-slo/down-slo time
- Gas pre- and post-flow time
- Electrode diameter

Welding process	TIG
	EWM-activArc
	EWM-spotArc
	spotmatic
	MMA
Orating modes	Non-latched
Ignition options	HF
	Liftarc
Pulse ty	Average value pulse welding
	kHz pulsing
	Pulse frequency
Parameters in display	Welding current
	Welding voltage
	Welding parameters
	Welding power
	JOB number
Number of freely definable JOBs	100
MMA functions	Hotstart
	Arcforce
	Antistick
	Average value pulse welding
	Frequency pulse welding

Control description Smart 2.0 DC



Welding process	TIG
	EWM-activArc
	EWM-spotArc
	spotmatic
	MMA
Orating modes	Non-latched
Ignition options	HF
	Liftarc
Pulse ty	Average value pulse welding
Parameters in display	Welding current
	Welding voltage
	Welding parameters
	Welding power
MMA functions	Hotstart
	Arcforce
	Antistick
	Average value pulse welding

- **One-knob oration**
- Welding sequence selection and parameter setting using click wheel or conventional oration with sequence buttons (back/forward)
- Exrt menu for advanced welding parameter settings
- **Welding sequence parameter setting**
- Start, welding, secondary and end current
- Up-slo/down-slo time
- Gas pre- and post-flow time
- Electrode diameter

Tetric 200 DC Smart 2.0 | Comfort 2.0 puls | Comfort 2.0 puls Multivolt



Comfort 2.0 DC



Smart 2.0 DC





Control	Page	350
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- Gas-cooled DC TIG inverter welding machine
- Multivolt version: Can be used worldwide thanks to automatic adjustment of mains voltage (115 V/230 V)
- **TIG welding**
 - Features characteristics for EWM activArc and EWM spotArc at no extra charge
 - Electronic HF start
 - TIG lift arc welding without HF
 - TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
 - Adjustable pulse frequency and balance
 - Comfort 2.0 additionally with kHz pulses, thermal pulses and automated pulsing
 - Non-latched/latched oration
 - Reduced secondary current accessible using torch trigger
 - Spot welding/tack function (spotArc/spotmatic)
 - Adjustable up-slo and down-slo time
 - Adjustable gas pre- and post-flow time
- **MMA welding**
 - MMA average value pulsing
 - Adjustable hot start current and hot start time
 - Adjustable Arcforce
 - Antistick function
- **Highlights**
 - Energy-saving thanks to high efficiency and standby function
 - Connection capability for remote control and function torch
 - 3.5 m mains supply lead with 16 A shock-proof plug
 - **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**




Version	Tetric 200	Tetric 200 MV	
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 20 A	1 x 16 A
On circuit voltage	63 V	90 V	
Setting range for welding current	5 A - 200 A	5 A - 150 A	5 A - 200 A
Duty cycle 40 °C	200 A / 25 %	-	200 A / 25 %
	-	150 A / 35 %	-
	150 A / 60 %	120 A / 60 %	150 A / 60 %
	140 A / 100 %	100 A / 100 %	140 A / 100 %
cos φ	0.99		
Efficiency	86 %		
Dimensions machine, LxWxH in mm	428 x 181 x 294		
Weight, machine	10 kg	10.8 kg	
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	S CE EAC		CE EAC S

Standard version

Icon	Ty	Designation	PU	Item no.
	Tetrix 200 DC Smart 2.0 puls 5P	TIG DC welding machine, portable, gas-cooled, decentral, 5-pole connection socket	1	090-000262-00502
	Tetrix 200 DC Comfort 2.0 puls 5P	TIG DC welding machine, portable, gas-cooled, decentral, 5-pole connection socket	1	090-000261-00502
	TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	1	394-512291-00600
	TIG 150 GD GRIP 5P 8m	TIG welding torch, gas-cooled	1	394-512291-00608
	Tetrix 200 DC Smart 2.0 puls 8P	TIG DC welding machine, portable, gas-cooled, decentral, 8-pole connection socket	1	090-000262-00504
	Tetrix 200 DC Comfort 2.0 puls 8P	TIG DC welding machine, portable, gas-cooled, decentral, 8-pole connection socket	1	090-000261-00504
	TIG 150 GD GRIP 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-512291-00200
	TIG 150 GD GRIP 8P U/D 8m	TIG welding torch, up/down, gas-cooled	1	394-512291-00208
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Multivolt

Icon	Ty	Designation	PU	Item no.
	Tetrix 200 DC MV Comfort 2.0 puls 5P	TIG multivolt inverter welding machine	1	090-000260-00502
	TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	1	394-512291-00600
	TIG 150 GD GRIP 5P 8m	TIG welding torch, gas-cooled	1	394-512291-00608
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

Packing unit

8x Tetrix 200 DC Comfort 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC Comfort 2.0 puls, 5-pole connection socket	092-015333-00502
8x Tetrix 200 DC Comfort 2.0 puls 8P	Packing unit: 8 pieces Tetrix 200 DC Comfort 2.0 puls, 8-pole connection socket	092-015333-00504
8x Tetrix 200 DC Smart 2.0 puls 8P	Packing unit: 8 pieces Tetrix 200 DC Smart 2.0 puls, 8-pole connection socket	092-015334-00504
8x Tetrix 200 DC Smart 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC Smart 2.0 puls, 5-pole connection socket	092-015334-00502
8x Tetrix 200 DC Comfort MV 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC MV Comfort 2.0 puls, 5-pole connection socket	092-015335-00502

Tetric 230 DC Smart 2.0 | Comfort 2.0 puls TM



Smart 2.0 DC



Comfort 2.0 DC





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- Modular DC TIG inverter welding machine, gas- or water-cooled
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Electronic HF start
- TIG lift arc welding without HF
- TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
- Adjustable pulse frequency and balance
- Comfort 2.0 additionally with kHz pulses, thermal pulses and automated pulsing
- Non-latched/latched oration
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Antistick function
- **Highlights**
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Energy-saving thanks to high efficiency and standby function
- Excellent torch cooling, resulting in cost savings on consumables due to high-rfor- mance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Connection capability for remote control and function torch
- Trolley 35.2-2, Trolley 55-5 and Trolley 55-6 trolleys available
- 3.5 m mains lead with 16 A earthed plug
- **Overvoltage protection: No damage to machine caused if inadvertently con- nected to 400-V mains voltage**





Version	Tetric 230
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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	86 %
Dimensions machine, LxWxH in mm	539 x 210 x 415
Weight, machine	17.2 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	14 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 230 DC Smart 2.0 puls 5P TM	TIG DC welding machine, portable,	1	090-000242-00502
	Tetrix 230 Comfort 2.0 puls 5P TM	modular, decentral, 5-pole connection socket	1	090-000240-00502
	TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	1	394-510981-00600
	TIG 200 GRIP GD 5P 8m		1	394-510981-00608
	Tetrix 230 DC Smart 2.0 puls 8P TM	TIG DC welding machine, portable,	1	090-000242-00504
	Tetrix 230 Comfort 2.0 puls 8P TM	modular, decentral, 8-pole connection socket	1	090-000240-00504
	TIG 200 GRIP GD 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-510981-00200
	TIG 200 GRIP GD 8P U/D 8m		1	394-510981-00208
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module,	1	090-008296-00000
	Trolley 55-6	10 l-50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 230 DC Smart 2.0 puls 5P TM	TIG DC welding machine, portable,	1	090-000242-00502
	Tetrix 230 Comfort 2.0 puls 5P TM	modular, decentral, 5-pole connection socket	1	090-000240-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m		1	394-510990-00608
	Tetrix 230 DC Smart 2.0 puls 8P TM	TIG DC welding machine, portable,	1	090-000242-00504
	Tetrix 230 Comfort 2.0 puls 8P TM	modular, decentral, 8-pole connection socket	1	090-000240-00504
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m		1	394-510990-00208
	cool40 U31	Cooling unit with centrifugal pump	1	090-008593-00502
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module,	1	090-008296-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

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
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
6x Tetrix 230 DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 230 DC Smart 2.0 puls, 5-pole connection socket	092-015328-00502
6x Tetrix 230 DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 230 DC Smart 2.0 puls, 8-pole connection socket	092-015328-00504

Tetrax 300 DC Smart 2.0 | Comfort 2.0 puls TM



Smart 2.0 DC



Comfort 2.0 DC





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- Modular DC TIG inverter welding machine, gas- or water-cooled
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Electronic HF start
- TIG lift arc welding without HF
- TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
- Adjustable pulse frequency and balance
- Comfort 2.0 additionally with kHz pulses, thermal pulses and automated pulsing
- Non-latched/latched oration
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- **Highlights**
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Energy-saving thanks to high efficiency and standby function
- Excellent torch cooling, resulting in cost savings on consumables due to high-rfor-
mance centrifugal pump and 4-litre water tank (cool 41 U31 cooling unit)
- Connection capability for remote control and function torch
- Trolley 35.2-2, Trolley 55-5 and Trolley 55-6 trolleys available
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software





Version	Tetrax 300
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	539 x 210 x 415
Weight, machine	20.5 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	18.4 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 300 DC Smart 2.0 puls 5P TM	TIG DC welding machine, portable,	1	090-000244-00502
	Tetrix 300 Comfort 2.0 puls 5P TM	modular, decentral, 5-pole connection socket	1	090-000238-00502
	TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	1	394-510981-00600
	TIG 200 GRIP GD 5P 8m		1	394-510981-00608
	Tetrix 300 DC Smart 2.0 puls 8P TM	TIG DC welding machine, portable,	1	090-000244-00504
	Tetrix 300 Comfort 2.0 puls 8P TM	modular, decentral, 8-pole connection socket	1	090-000238-00504
	TIG 200 GRIP GD 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-510981-00200
	TIG 200 GRIP GD 8P U/D 8m		1	394-510981-00208
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module,	1	090-008296-00000
	Trolley 55-6	10 l-50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 300 DC Smart 2.0 puls 5P TM	TIG DC welding machine, portable,	1	090-000244-00502
	Tetrix 300 Comfort 2.0 puls 5P TM	modular, decentral, 5-pole connection socket	1	090-000238-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m		1	394-510990-00608
	Tetrix 300 DC Smart 2.0 puls 8P TM	TIG DC welding machine, portable,	1	090-000244-00504
	Tetrix 300 Comfort 2.0 puls 8P TM	modular, decentral, 8-pole connection socket	1	090-000238-00504
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m		1	394-510990-00208
	cool41 U31	Cooling unit with centrifugal pump	1	090-008600-00502
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

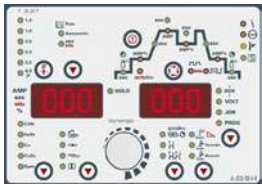
Packing unit

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
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
6x Tetrix 300 DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 300 DC Smart 2.0 puls, 5-pole connection socket	092-015329-00502
6x Tetrix 300 DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 300 DC Smart 2.0 puls, 8-pole connection socket	092-015329-00504

Tetrax 351 | 401 | 451 | 551 DC Smart 2.0 | Comfort 2.0 | Synergic



Synergic DC



Smart 2.0 DC



Comfort 2.0 DC







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
- Water-cooled DC TIG inverter welding machine
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Electronic HF start
- TIG lift arc welding without HF
- TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
- Comfort 2.0 additionally with kHz pulses, thermal pulses and automated pulsing
- Non-latched/latched oration
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- MMA welding
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- **Highlights**
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Crane-liftable casing
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- ON 7pol (092-001826-00000) "7-pole connection socket for accessory components and/or as digital interface" required for Xnet
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-rfor- mance centrifugal pump and 12-litre water tank

Version	Tetrax 351	Tetrax 401	Tetrax 451	Tetrax 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
On circuit voltage	79 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	350 A / 100 %	400 A / 100 %	450 A / 80 %	550 A / 60 %
cos φ	0.99			
Efficiency	90 %			
Dimensions machine, LxWxH in mm	1085 x 450 x 1003			
EMC class	A			
Insulation class	H			
Protection class	IP23			
Approvals				





Tetrix 351 DC

Icon	Ty	Designation	PU	Item no.
	Tetrix 351 DC Smart 2.0 puls		1	090-000253-00502
	Tetrix 351 Synergic FW	TIG DC welding machine, mobile, water-cooled, decentral	1	090-000118-00502
	Tetrix 351 DC Comfort 2.0 puls		1	090-000246-00502
	TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510993-00600
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510993-00200
	TIG 450 GRIP WD 8P U/D 8m		1	394-510993-00208
	WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000





Tetrix 401 DC

Icon	Ty	Designation	PU	Item no.
	Tetrix 401 DC Smart 2.0 puls		1	090-000254-00502
	Tetrix 401 Synergic FW	TIG DC welding machine, mobile, water-cooled, decentral	1	090-000179-00502
	Tetrix 401 DC Comfort 2.0 puls		1	090-000247-00502
	TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510993-00600
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510993-00200
	TIG 450 GRIP WD 8P U/D 8m		1	394-510993-00208
	WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Tetrix 451 DC

Icon	Ty	Designation	PU	Item no.
	Tetrix 451 DC Smart 2.0 puls		1	090-000255-00502
	Tetrix 451 Synergic FW	TIG DC welding machine, mobile, water-cooled, decentral	1	090-000103-00502
	Tetrix 451 DC Comfort 2.0 puls		1	090-000248-00502
	TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510993-00600
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510993-00200
	TIG 450 GRIP WD 8P U/D 8m		1	394-510993-00208
	WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Tetrax 551 DC

Icon	Ty	Designation	PU	Item no.
	Tetrax 551 DC Smart 2.0 puls		1	090-000256-00502
	Tetrax 551 Synergic FW	TIG DC welding machine, mobile, water-cooled, decentral	1	090-000093-00502
	Tetrax 551 DC Comfort 2.0 puls		1	090-000249-00502
	TIG 450SC GRIP 5P HFL 4m	TIG welding torch, water-cooled	1	394-511016-10600
	TIG 450SC GRIP 5P HFL 8m		1	394-511016-10608
	TIG 450SC GRIP WD 8P U/D HFL 4m	TIG welding torch, Up/Down, water-cooled	1	394-511016-10200
	TIG 450SC GRIP WD 8P U/D HFL 8m		1	394-511016-10208
	WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

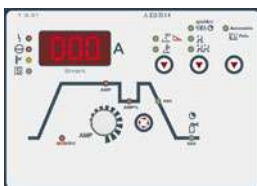
Tetrix 300 DC Smart | Comfort



Comfort DC



Smart DC







- Modular DC TIG inverter welding machine, gas- or water-cooled
- **TIG welding**
 - Features characteristics for EWM activArc and EWM spotArc at no extra charge
 - Electronic HF start
 - TIG lift arc welding without HF
 - TIG automated pulsing with automatic scification of required pulse parameters
 - Non-latched/latched oration
 - Reduced secondary current accessible using torch trigger
 - Spot welding/tack function (spotArc/spotmatic)
 - Adjustable up-slo and down-slo time
 - Adjustable gas pre- and post-flow time
- **MMA welding**
 - MMA average value pulsing
 - Adjustable hot start current and hot start time
 - Adjustable Arcforce
 - Antistick function
- **Highlights**
 - Gas-cooled or optionally water-cooled with cool 35 U31 cooling unit
 - Excellent torch cooling, resulting in cost savings on consumables due to high-rfor-
formance centrifugal pump and 4.5-litre water tank (cool 35 U31 cooling unit)
 - Energy-saving thanks to high efficiency and standby function
 - Connection capability for remote control and function torch
 - Trolley 35.2-2 trolley available for delivery







Version	Tetrix 300
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	590 x 230 x 380
Weight, machine	29 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	S CE EAC
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	33 kg

Tetrax 300 DC Smart | Comfort

Gas-cooled

Icon	Ty	Designation	PU	Item no.
	Tetrax 300 Smart TM		1	090-000125-00502
	Tetrax 300 Comfort TM	TIG DC welding machine, portable, modular, decentral	1	090-000099-00502
	TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	1	394-510981-00600
	TIG 200 GRIP GD 5P 8m		1	394-510981-00608
	TIG 200 GRIP GD 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-510981-00200
	TIG 200 GRIP GD 8P U/D 8m		1	394-510981-00208
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

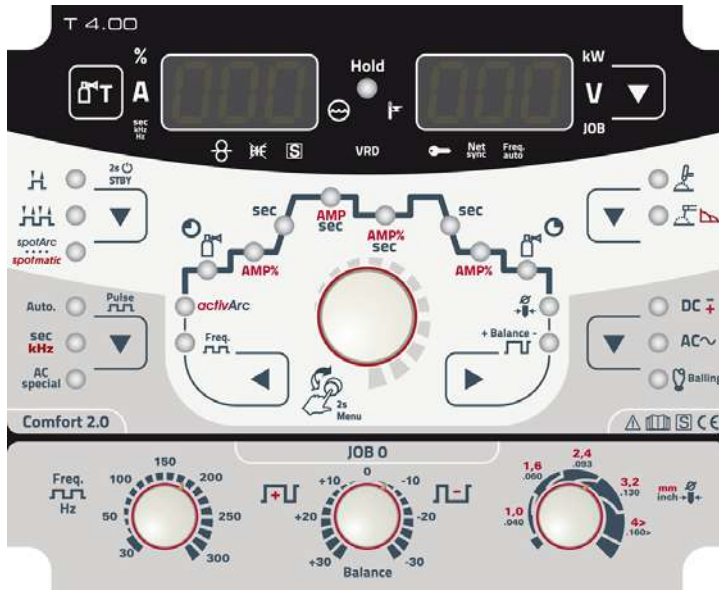
Water-cooled

Icon	Ty	Designation	PU	Item no.
	Tetrax 300 Smart TM		1	090-000125-00502
	Tetrax 300 Comfort TM	TIG DC welding machine, portable, modular, decentral	1	090-000099-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m		1	394-510990-00608
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m		1	394-510990-00208
	cool35 U31	Cooling unit with centrifugal pump	1	090-008235-00502
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total



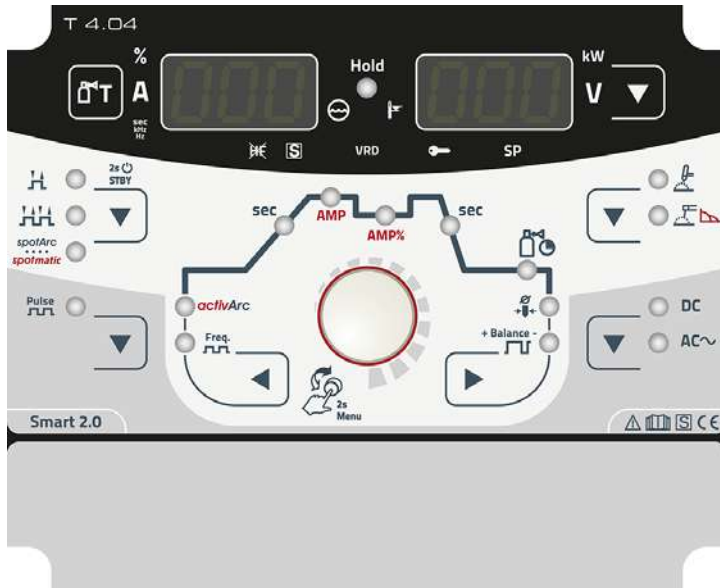
Control description Comfort 2.0 AC



- **One-knob oration**
- Welding sequence selection and parameter setting using click wheel or conventional oration with sequence buttons (back/forward)
- Exrt menu for advanced welding parameter settings
- **Welding sequence parameter setting**
- Start, welding, secondary and end current
- Up-slo/down-slo time
- Gas pre- and post-flow time
- Electrode diameter

Welding process	TIG
	EWM-activArc
	EWM-spotArc
	spotmatic
	TIG AC
	MMA
Orating modes	Non-latched
AC functions	AC scial
	AC tungsten balling
	AC sine
	AC trazoidal
	AC rectangle
	AC balance
	AC frequency: 30 Hz to 300 Hz
	Automatic AC frequency
Ignition options	HF
	Liftarc
Pulse ty	Average value pulse welding
	kHz pulsing
	Pulsing
	Seconds pulse
Parameters in display	Welding current
	Welding voltage
	Welding parameters
	Welding power
	JOB number
Number of freely definable JOBs	100
MMA functions	Hotstart
	Arcforce
	Antistick
	AC electrode welding
	Average value pulse welding
	Frequency pulse welding

Control description Smart 2.0 AC



- **One-knob oration**
- Welding sequence selection and parameter setting using click wheel or conventional oration with sequence buttons (back/forward)
- Exrt menu for advanced welding parameter settings
- **Welding sequence parameter setting**
- Start, welding, secondary and end current
- Up-slo/down-slo time
- Gas pre- and post-flow time
- Electrode diameter

Welding process	TIG
	EWM-activArc
	EWM-spotArc
	spotmatic
	TIG AC
	MMA
Orating modes	Non-latched
AC functions	AC sine
	AC trazoidal
	AC rectangle
	AC balance
Ignition options	HF
	Liftarc
Pulse ty	Average value pulse welding
	Pulse frequency
Parameters in display	Welding current
	Welding voltage
	Welding parameters
	Welding power
MMA functions	Hotstart
	Arcforce
	Antistick
	AC electrode welding
	Average value pulse welding
	Frequency pulse welding

Tetrax 230 AC/DC Smart 2.0 | Comfort 2.0 puls TM

/activArc®



Smart 2.0 AC/DC



Comfort 2.0 AC/DC





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- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- 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
- Powersinus: Uniquely high welding current – 230 A from single-phase socket
- TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
- Adjustable pulse frequency and balance
- Non-latched/latched oration
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- **Highlights**
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Trolley 35-2, Trolley 55-5 and Trolley 55-6 trolleys available
- 3.5 m mains lead with 16 A earthed plug
- **Overtoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**





Version	Tetrax 230
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
On 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 machine, LxWxH in mm	539 x 210 x 415
Weight, machine	18.8 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	14 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000241-00502
	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000239-00502
	TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	1	394-510981-00600
	TIG 200 GRIP GD 5P 8m	TIG welding torch, gas-cooled	1	394-510981-00608
	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000241-00504
	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000239-00504
	TIG 200 GRIP GD 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-510981-00200
	TIG 200 GRIP GD 8P U/D 8m	TIG welding torch, up/down, gas-cooled	1	394-510981-00208
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000241-00502
	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000239-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m	TIG welding torch, water-cooled	1	394-510990-00608
	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000241-00504
	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000239-00504
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00208
	cool40 U31	Cooling unit with centrifugal pump	1	090-008593-00502
	WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

► * Only the items in bold are included in the total

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
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
6x Tetrix 230 AC/DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 230 AC/DC Smart 2.0 puls, 5-pole connection socket	092-015330-00502
6x Tetrix 230 AC/DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 230 AC/DC Smart 2.0 puls, 8-pole connection socket	092-015330-00504

Tetric 300 AC/DC Smart 2.0 | Comfort 2.0 puls TM

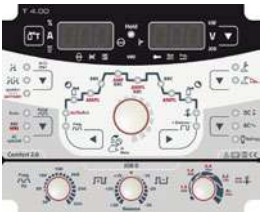
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Smart 2.0 AC/DC



Comfort 2.0 AC/DC





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- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Electronic HF start
- TIG lift arc welding without HF
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 30 Hz and 300 Hz
- Adjustable AC balance
- TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as a r welding procedure specification
- Adjustable pulse frequency and balance
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- AC electrode welding
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- **Highlights**
- Gas-cooled or optionally water-cooled with cool 41 U31 cooling unit
- Energy-saving thanks to high efficiency and standby function
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Connection capability for remote control and function torch
- Trolley 35.2-2, Trolley 55-5 and Trolley 55-6 trolleys available
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- PC interface for PC300 XQ software





Version	Tetric 300
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	539 x 210 x 415
Weight, machine	20.5 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	18.4 kg
Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Gas cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000243-00502
	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000235-00502
	TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	1	394-510981-00600
	TIG 200 GRIP GD 5P 8m	TIG welding torch, gas-cooled	1	394-510981-00608
	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000243-00504
	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000235-00504
	TIG 200 GRIP GD 8P U/D 4m	TIG welding torch, up/down, gas-cooled	1	394-510981-00200
	TIG 200 GRIP GD 8P U/D 8m	TIG welding torch, up/down, gas-cooled	1	394-510981-00208
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Water cooled

Icon	Ty	Designation	PU	Item no.
	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000243-00502
	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	1	090-000235-00502
	TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510990-00600
	TIG 260 GRIP WD 5P 8m	TIG welding torch, water-cooled	1	394-510990-00608
	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000243-00504
	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	1	090-000235-00504
	TIG 260 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00200
	TIG 260 GRIP WD 8P U/D 8m	TIG welding torch, Up/Down, water-cooled	1	394-510990-00208
	cool41 U31	Cooling unit with centrifugal pump	1	090-008600-00502
	WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 15I D	Pressure regulator with manometer	1	394-002910-00015
	Trolley 35.2-2	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
	Trolley 55-5	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000
	Trolley 55-6	Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000
	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000
	KOS25	Customised configuration with assembly for portable and compact systems	1	092-002686-00001
	KOS27	Commissioning: 1 hour	1	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
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
6x Tetrix 300 AC/DC Smart 2.0 puls 5P TM	Packing unit: 6 pieces Tetrix 300 AC/DC Smart 2.0 puls, 5-pole connection socket	092-015331-00502
6x Tetrix 300 AC/DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 300 AC/DC Smart 2.0 puls, 8-pole connection socket	092-015331-00504

Tetrax 351 | 451 | 551 AC/DC Smart 2.0 | Comfort 2.0 | Synergic

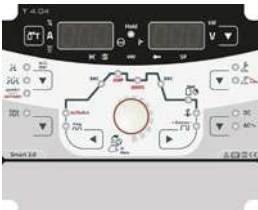
/activArc®



Synergic AC/DC



Smart 2.0 AC/DC






Comfort 2.0 AC/DC







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- Water-cooled AC/DC TIG inverter welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Electronic HF start
- TIG lift arc welding without HF
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 30 Hz and 300 Hz
- Adjustable AC balance
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- MMA welding
- MMA average value pulsing
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- **Highlights**
- Energy-saving thanks to high efficiency and standby function
- Mains connection: 3 x 400 V; other mains voltages and multivolt as an option
- Connection capability for remote control and function torch
- Crane-liftable casing
- Optional network connectivity with ewm Xnet software via LAN or WiFi gateway
- ON 7pol (092-001826-00000) "7-pole connection socket for accessory components and/or as digital interface" required for Xnet
- PC interface for PC300 XQ software
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank







Version	Tetrax 351	Tetrax 451	Tetrax 551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 20 A	3 x 32 A	
On circuit voltage	100 V	79 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 machine, LxWxH in mm	1085 x 450 x 1003	1085 x 680 x 1204	
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	  		





Tetrix 351 AC/DC

Icon	Ty	Designation	PU	Item no.
			stk	
	Tetrix 351 AC/DC Smart 2.0 puls		1	090-000257-00502
	Tetrix 351 AC/DC Synergic FW	AC/DC TIG welding machine, mobile,	1	090-000109-00502
	Tetrix 351 AC/DC Comfort 2.0 puls	water-cooled, decentral	1	090-000250-00502
	TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510993-00600
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down,	1	394-510993-00200
	TIG 450 GRIP WD 8P U/D 8m	water-cooled	1	394-510993-00208
	WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
-	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Tetrix 451 AC/DC

Icon	Ty	Designation	PU	Item no.
			stk	
	Tetrix 451 AC/DC Smart 2.0 puls		1	090-000258-00502
	Tetrix 451 AC/DC Synergic FW	AC/DC TIG welding machine, mobile,	1	090-000112-00502
	Tetrix 451 AC/DC Comfort 2.0 puls	water-cooled, decentral	1	090-000251-00502
	TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	1	394-510993-00600
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450 GRIP WD 8P U/D 4m	TIG welding torch, Up/Down,	1	394-510993-00200
	TIG 450 GRIP WD 8P U/D 8m	water-cooled	1	394-510993-00208
	WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	1	092-000013-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
-	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

Tetrix 551 AC/DC

Icon	Ty	Designation	PU	Item no.
			stk	
	Tetrix 551 AC/DC Smart 2.0 puls		1	090-000259-00502
	Tetrix 551 AC/DC Synergic FW	AC/DC TIG welding machine, mobile,	1	090-000115-00502
	Tetrix 551 AC/DC Comfort 2.0 puls	water-cooled, decentral	1	090-000252-00502
	TIG 450 GRIP WD 5P 8m		1	394-510993-00608
	TIG 450SC GRIP 5P HFL 4m	TIG welding torch, water-cooled	1	394-511016-10600
	TIG 450SC GRIP 5P HFL 8m		1	394-511016-10608
	TIG 450SC GRIP WD 8P U/D HFL 4m	TIG welding torch, Up/Down,	1	394-511016-10200
	TIG 450SC GRIP WD 8P U/D HFL 8m	water-cooled	1	394-511016-10208
	WK95mm² 550A/60% 4m/Z	Workpiece lead with clamp	1	092-000171-00000
	GH 2x1/4" 2m	Gas hose	1	094-000010-00001
	DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	1	394-002910-00030
-	KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
	OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000
	KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001

► * Only the items in bold are included in the total

tigSed wire feed systems

- High process reliability, reproducible welding results and straightforward 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

tigSed continuous drive 45 coldwire



- TIG cold wire welding
- Up to 60% faster welding speeds compared to manual TIG welding

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	636 x 324 x 482
Wire feeder weight	24.5 kg
EMC class	A
Protection class	IP23

Designation	PU	Item no.
TIG wire feeder	1	090-000237-00502

tigSed oscillation drive 45 coldwire



- TIG cold wire welding with dynamic wire feed system
- Dynamic wire feeding for a controllable weld pool even with positional welding: The wire feeding is superimposed using a forward and backward movement
- Up to 60% faster welding speeds compared to manual TIG welding

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Oscillating frequency	1 Hz - 16 Hz
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	636 x 324 x 482
Wire feeder weight	28 kg
EMC class	A
Protection class	IP23

Designation	PU	Item no.
TIG wire feeder with adjustable pulse frequency	1	090-000181-00502

tigSed continuous drive 45 hotwire



- TIG cold wire and hot wire welding
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- Heat supply to the wire for improved deposition rate and an even lower risk of weld errors
- Workpiece lead to connect the hot wire current is included in the supply package

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed sed 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 %
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	636 x 324 x 482
Wire feeder weight	30.5 kg
EMC class	A
Protection class	IP23

Designation	PU	Item no.
TIG wire feeder with wire preheating	1	090-000236-00502

tigSed oscillation drive 45 hotwire



- 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 surimposed using a forward and backward movement
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- Heat supply to the wire for improved deposition rate and an even lower risk of weld errors
- Workpiece lead to connect the hot wire current is included in the supply package

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed sed 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
Spool size	D200/D300
Roller diameter	37 mm
Wire feeder, LxWxH in mm	636 x 324 x 482
Wire feeder weight	34 kg
EMC class	A
Protection class	IP23

Designation	PU	Item no.
TIG wire feeder with adjustable pulse frequency and wire pre-heating	1	090-000180-00502

tigSed system components - Accessories/options

FR tigSed



- Remote control for tigSed system
- **Workplace setting of:**
- Start/stop welding machine
- Start/stop wire feed
- Wire feeding quantity setting during welding
- Plastic casing with retaining clip, 12-pole connection socket
- With pre-fitted 5-m connection cable

Connection	Burndy, 12-pole
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Designation	PU stk	Item no.
Remote control	1	094-019921-00000

TIG W AW 5POL



- Intermediate hose package, water-cooled, filler wire, incl. strain relief

Connection	Tuchel, 5-pole
Cross-section	95 mm ²

Designation	Hose package length m	PU stk	Item no.
Intermediate hose package, water-cooled, filler wire, incl. strain relief	2.0	1	094-019139-00000
	5.0	1	094-019139-00005
	10.0	1	094-019139-00010

ADAP tigSed



Designation	PU stk	Item no.
Adapter for tigSed intermediate hose package for connection to equipment from other manufacturers	1	094-019463-00000

Conversion kit for aluminium



- Includes 4 twin rollers, 2 gears and 2 spacer rings

Designation	Wire Ø mm	Wire Ø 2 mm	PU ve	Item no.
Conversion kit for aluminium	0.8	1.0	1	092-002268-00000
	1.0	1.2	1	092-002266-00000
	1.2	1.6	1	092-002269-00000
	2.4	3.2	1	092-002270-00000

Conversion kit for flux cored wire



- Includes 2 twin rolls, 2 gears, 2 pressure rolls and 2 spacer rings

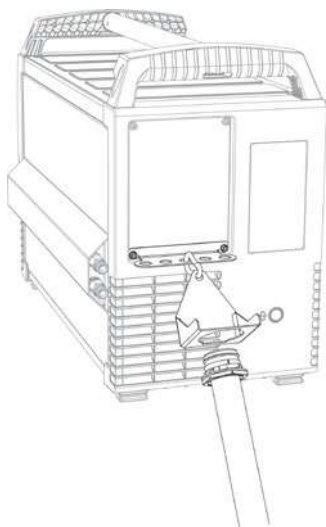
Designation	Wire Ø mm	Wire Ø 2 mm	PU ve	Item no.
Conversion kit for flux cored wire	0.8 - 0.9	0.8 - 0.9	1	092-000410-00000
	1 - 1.2	1.4 - 1.6	1	092-000411-00000
	1.4 - 1.6	2 - 2.4	1	092-000412-00000
	2.8	3.2	1	092-000413-00000

ON WAK tigSed



Designation	PU stk	Item no.
With wheel assembly kit with strain relief	1	092-007927-00000

ON AS SR tigSed



- Strain relief for tigSed
- Recommended for installation of tigSed on external machine

Designation	PU stk	Item no.
Strain relief	1	092-003685-00000

tigSed system components - Cold/hot wire welding torch

- Up to 100 % faster welding seds compared to TIG welding
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Excellent HF safety
- The consumables featured show the standard „Flex bracket, short“ design only. You will find other designs such as „Flex bracket, long“, „Mini“, fixed feed angles or models equipd with Jumbo gas nozzles in our spare parts catalogue.

Torch connection	Decentral 35 mm ² (pin Ø 13 mm ²)
Control cable connection	Burndy, 12-pole
Shielding gas supply	G 1/4" RH, crown nut
Approvals	CE

TIG-SR 18 GRIP WD CW U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Wire feeding quantity setting during welding
- Compatible with SR replacement parts
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed integrated in the grip

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, cold wire, up/down	3.0	1	094-500102-10203
	4.0	1	094-500102-10200

TIG-SR 18 GRIP WD HW U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Wire feeding quantity setting during welding
- Compatible with SR replacement parts
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed and hot wire current lead integrated in grip

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, hot wire, up/down	3.0	1	094-500106-10203
	4.0	1	094-500106-10200

TIG-SR 18 GRIP WD CW WO U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Compatible with SR replacement parts
- Ergonomic GRIP handle for a secure hold and ergonomic use

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500165-10203
torch, cold wire, up/down	4.0	1	094-500165-10200

TIG-SR 18 GRIP WD HW WO U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Compatible with SR replacement parts
- Ergonomic GRIP handle for a secure hold and ergonomic use

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500171-10203
torch, hot wire, up/down	4.0	1	094-500171-10200

TIG 260 GRIP WD CW U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Better accessibility in cramped spaces compared to common hot/cold wire torches thanks to compact construction
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed integrated in the grip
- Wire feed angle depends on the application.

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1 mm

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500167-10203
torch, cold wire, up/down	4.0	1	094-500167-10200

tigSed system components - Cold/hot wire welding torch

TIG 260 GRIP WD HW U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Better accessibility in cramped spaces compared to common hot/cold wire torches thanks to compact construction
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed integrated in the grip
- Wire feed angle depends on the application.

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, hot/cold wire, Up/Down	3.0	1	094-500169-10203
	4.0	1	094-500169-10200

TIG 260 GRIP WD CW WO U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Better accessibility in cramped spaces compared to common hot/cold wire torches thanks to compact construction
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed angle depends on the application.

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, cold wire, up/down	3.0	1	094-500168-10203
	4.0	1	094-500168-10200

TIG 260 GRIP WD HW WO U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Better accessibility in cramped spaces compared to common hot/cold wire torches thanks to compact construction
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed angle depends on the application.

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, hot/cold wire, Up/Down	3.0	1	094-500170-10203
	4.0	1	094-500170-10200

TIG 450 GRIP WD CW U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed integrated in the grip

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500094-10203
torch, cold wire, up/down	4.0	1	094-500094-10200

TIG 450 GRIP WD HW U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Wire feed and hot wire current lead integrated in grip

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500098-10203
torch, hot wire, up/down	4.0	1	094-500098-10200

TIG 450 GRIP WD CW WO U/D HFL



- Water cooled TIG welding torch with a separate cold wire feed
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding	3.0	1	094-500157-10203
torch, cold wire, up/down	4.0	1	094-500157-10200

tigSed system components - Cold/hot wire welding torch

TIG 450 GRIP WD HW WO U/D HFL



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Electrode clamping range	1.6 mm - 3.2 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, hot wire, up/down	3.0	1	094-500158-10203
	4.0	1	094-500158-10200

comfyTig 18-1 CW



- Water cooled TIG welding torch with a separate cold wire feed
- Hardly any difference in oration when switching from MIG/MAG to cold or hot wire welding
- Consumables compatible with TIG-SR 18 SC
- Wire feed integrated in the grip

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, cold wire, up/down	3.0	1	094-500145-00603
	4.0	1	094-500145-00600

comfyTig 18-1 HW



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Hardly any difference in oration when switching from MIG/MAG to cold or hot wire welding
- Consumables compatible with TIG-SR 18 SC
- Wire feed and hot wire current lead integrated in grip

Duty cycle DC-	300 A / 100 %
Duty cycle AC	210 A / 100 %
Electrode clamping range	1 mm - 4 mm
Filler wire Ø	0.8 mm - 1.6 mm

Designation	Hose package length m	PU	Item no.
TIG welding torch, hot wire, up/down	3.0	1	094-500149-00603
	4.0	1	094-500149-00600

TIG welding torches - Gas-cooled

- Gas-cooled TIG welding torch with a highly flexible hose package (high-flex leather)
- Excellent HF safety

Torch connection	Decentral 35 mm ² (pin Ø 13 mm ²)
Shielding gas supply	G 1/4" RH, crown nut
Approvals	CE

TIG 150 GRIP GD HFL



- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, gas-cooled	4.0	1	394-512291-10600
	8.0	1	394-512291-10608

TIG 150 GRIP Little GD HFL



- Especially compact GRIP grip, perfectly suitable for welding tasks that are difficult to access
- Double push-button
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used



Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, gas-cooled	4.0	1	394-512292-10600
	8.0	1	394-512292-10608

TIG 150 GRIP GD U/D HFL



- Setting of welding current, in case of Synergic control, JOB switching is also possible
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 8-pole connection socket required on machine side

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, up/down, gas-cooled	4.0	1	394-512291-10200
	8.0	1	394-512291-10208

TIG welding torches - Gas-cooled

TIG 150 GRIP Little GD HFL U/D



- Especially compact GRIP grip, rfectly suitable for welding tasks that are difficult to access
- Setting of welding current, in case of Synergic control, JOB switching is also possible
- 8-pole connection socket required on machine side

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, up/down, gas-cooled	4.0	1	394-512292-10200
	8.0	1	394-512292-10208

TIG 150 GRIP GD RETOX HFL



- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Not possible with Picotig 200 DC and machines with Smart 2.0 control
- "ON 12-pole connection socket" option required on machine side

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode clamping range	1 mm - 2.4 mm
Control cable connection	Burndy, 12-pole

Designation	Hose package length m	PU	Item no.
TIG function torch, Retox, gas-cooled	4.0	1	394-512291-10700
	8.0	1	394-512291-10708

TIG 200 GRIP GD HFL



- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	200 A / 35 %
Duty cycle AC	140 A / 35 %
Electrode clamping range	1.6 mm - 3.2 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, gas-cooled	4.0	1	394-510981-10600
	8.0	1	394-510981-10608

TIG 200 GRIP GD U/D HFL



- Setting of welding current, in case of Synergic control, JOB switching is also possible
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 8-pole connection socket required on machine side

Duty cycle DC-	200 A / 35 %
Duty cycle AC	140 A / 35 %
Electrode Ø	1.6 mm - 3.2 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding	4.0	1	394-510981-10200
torch, up/down, gas-cooled	8.0	1	394-510981-10208

TIG 200 GRIP GD RETOX HFL



- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Not possible with Picotig 200 DC and machines with Smart 2.0 control
- "ON 12-pole connection socket" option required on machine side

Duty cycle DC-	200 A / 35 %
Duty cycle AC	140 A / 35 %
Electrode clamping range	1.6 mm - 3.2 mm
Control cable connection	Burndy, 12-pole

Designation	Hose package length m	PU	Item no.
TIG function	4.0	1	394-510981-10700
torch, Retox, gas-cooled	8.0	1	394-510981-10708

TIG welding torches - Water-cooled

- Water-cooled TIG welding torch with a highly flexible hose package (high-flex leather)
- Excellent HF safety

Torch connection	Decentral 35 mm ² (pin Ø 13 mm ²)
Shielding gas supply	G 1/4" RH, crown nut
Approvals	CE

TIG 260 GRIP WD HFL



- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode Ø	3.2 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, water-cooled	4.0	1	394-510990-10600
	8.0	1	394-510990-10608

TIG 260 GRIP Little WD HFL



- Especially compact GRIP grip, rfectly suitable for welding tasks that are difficult to access
- Double push-button
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode Ø	3.2 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, water-cooled	4.0	1	394-510991-10600
	8.0	1	394-510991-10608

TIG 260 GRIP WD U/D HFL



- Setting of welding current, in case of Synergic control, JOB switching is also possible
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 8-pole connection socket required on machine side

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1 mm - 3.2 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, Up/Down, water-cooled	4.0	1	394-510990-10200
	8.0	1	394-510990-10208

TIG 260 GRIP Little WD U/D HFL



- Especially compact GRIP grip, rfectly suitable for welding tasks that are difficult to access
- Setting of welding current, in case of Synergic control, JOB switching is also possible
- 8-pole connection socket required on machine side

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode Ø	3.2 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, Up/Down, water-cooled	4.0	1	394-510991-10200
	8.0	1	394-510991-10208

TIG 260 GRIP WD RETOX HFL



- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Not possible with Picotig 200 DC and machines with Smart 2.0 control
- "ON 12-pole connection socket" option required on machine side

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode clamping range	1 mm - 3.2 mm
Control cable connection	Burndy, 12-pole

Designation	Hose package length m	PU	Item no.
TIG function torch, Retox, water-cooled	4.0	1	394-510990-10700
	8.0	1	394-510990-10708

TIG 450 GRIP WD HFL



- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Electrode clamping range	4.8 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG wel- ding torch, water-cooled	4.0	1	394-510993-10600
	8.0	1	394-510993-10608

TIG welding torches - Water-cooled

TIG 450 GRIP WD U/D HFL



- Setting of welding current, in case of Synergic control, JOB switching is also possible
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 8-pole connection socket required on machine side

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Electrode clamping range	1.6 mm - 4.8 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, Up/Down, water-cooled	4.0	1	394-510993-10200
	8.0	1	394-510993-10208

TIG 450 GRIP WD RETOX HFL



- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Not possible with Picotig 200 DC and machines with Smart 2.0 control
- "ON 12-pole connection socket" option required on machine side

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Control cable connection	Burndy, 12-pole

Designation	Hose package length m	PU	Item no.
TIG function torch, Retox, water-cooled	4.0	1	394-510993-10700
	8.0	1	394-510993-10708

TIG 450SC GRIP WD HFL



- SurCool / high-performance torch version
- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 5-pole connection socket required on machine side
- In case an 8-pole welding machine is being used, the "ADAP 8-5 POL" adapter can be alternatively used

Duty cycle DC-	450 A / 100 %
Duty cycle AC	320 A / 100 %
Electrode clamping range	1.6 mm - 4.8 mm
Control cable connection	Tuchel, 5-pole

Designation	Hose package length m	PU	Item no.
TIG welding torch, water-cooled	4.0	1	394-511016-10600
	8.0	1	394-511016-10608

TIG 450SC GRIP WD U/D HFL



- SurCool / high-performance torch version
- Setting of welding current, in case of Synergic control, JOB switching is also possible
- Ergonomic GRIP handle for a secure hold and ergonomic use
- 8-pole connection socket required on machine side

Duty cycle DC-	450 A / 100 %
Duty cycle AC	320 A / 100 %
Electrode clamping range	4.8 mm
Control cable connection	Burndy, 8-pole

Designation	Hose package length m	PU	Item no.
TIG welding	4.0	1	394-511016-10200
torch, Up/Down, water-cooled	8.0	1	394-511016-10208

TIG 450SC GRIP WD RETOX HFL



- SurCool / high-performance torch version
- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Not possible with Picotig 200 DC and machines with Smart 2.0 control
- "ON 12-pole connection socket" option required on machine side

Duty cycle DC-	450 A / 100 %
Duty cycle AC	320 A / 100 %
Control cable connection	Burndy, 12-pole

Designation	Hose package length m	PU	Item no.
TIG function	4.0	1	394-511016-10700
torch, Retox, water-cooled	8.0	1	394-511016-10708

Overview of controls, Microplasma



Welding process	Plasma DC TIG
Orating modes	Non-latched
Pulse ty	Automated pulsing Seconds pulse kHz pulsing
Number of JOBs	100

- **One-knob oration**
- Welding sequence selection and parameter setting using click wheel or conventional oration with sequence buttons (back/forward)
- Exrt menu for advanced welding parameter settings

Microplasma 25 | 55 | 105






Comfort 2.0 P



- Modular plasma/TIG welding machine with Comfort 2.0 P control
- Inverter welding machine, DC, water-cooled
- Plasma and TIG welding
- Plasma and pulsed TIG welding
- Plasma and pulsed TIG welding up to the kHz range allow a high welding speed with minimal heat input using a constricted arc
- Plasma and TIG welding current adjustable in 0.1 A increments
- Pilot arc current adjustable in 0.1 A increments between 2–15 A
- The pilot arc current can be adjusted at four operating points during the welding process (beforehand, during, and following welding, as well as during pauses in welding)
- Non-latched/latched operation
- Spot welding/tack function (spotArc/spotmatic)
- Spotmatic – reduce the time required for tacking by up to 50% (TIG only)
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- Temperature, flow and pressure monitoring for the coolant circuit
- All control elements and connections for welding torches, remote controls and workpiece leads are directly accessible on the front of the machine
- Non-interchangeable connections for all mediums
- Welding torch connection using quick connect coupling
- Connection capability for remote control
- Two system bus connections (e.g. for eWm Xnet)
- Set-up with Trolley 55-6 and Cool 50 MPW50; alternatively, a separate recooling unit can be used
- No additional mains connection required for Cool 50 MPW50, the Cool unit is supplied with mains voltage via the power source
- Optional network connectivity with eWm Xnet software via LAN or WiFi gateway
- 3.5 m mains supply lead with 16 A shock-proof plug
- Please always use an electrode setting gauge to ensure optimum welding results



Version	Microplasma 25	Microplasma 55	Microplasma 105
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)		
Mains fuses (slow-blow)	1 x 10 A	1 x 16 A	1 x 20 A
On circuit voltage	63 V		
Setting range for welding current	0.3 A - 20 A	0.3 A - 50 A	0.3 A - 100 A
Duty cycle 40 °C	–		100 A / 60 %
	20 A / 100 %	50 A / 100 %	70 A / 100 %
cos φ	0.99		
Dimensions machine, LxWxH in mm	625 x 377 x 531		
Weight, machine	33.6 kg		
EMC class	A		
Insulation class	H		
Protection class	IP23		
Approvals	  		
Dimensions cooling unit in mm	695 x 298 x 329		
Weight, cooling unit	14.3 kg		
Trolley dimensions L x W x H in mm	1114 x 678 x 1486		
Trolley weight	35 kg		

Microplasma 25 | 55 | 105

Microplasma 25

Ty	Designation	PU	Item no.
Microplasma 25	Microplasma welding machine	1	090-007027-00502
PHW 20 3 m 5P	Plasma torch	1	394-003872-00000
EAG PHW 20	Electrode setting gauge	1	394-001119-00000
Cool 50 MPW50	Cooling unit with centrifugal pump	1	090-008818-00502
WK16mm ² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005801-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
G1/4"+G3/8" 2 m		1	092-000525-00001
Maxex AR/MIX 200bar 30m ³ G1/4"	Pressure regulator	1	096-000000-00000
Maxex Hydrogen 200bar 30m ³ G3/8"L		1	096-000001-00000
Trolly 55-6 DF	Transport cart for a power source, cooling unit and two shielding gas cylinders	1	090-008826-00000
KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
ADAP3 G1/4-G1/4 LKS	Threaded adapter	1	094-001652-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Microplasma 55

Ty	Designation	PU	Item no.
Microplasma 55	Microplasma welding machine	1	090-007028-00502
PHW 100 3 m 5P	Plasma manual welding torch without setting gauge	1	394-003843-00000
EAG PHW100/150	Electrode setting gauge	1	094-008262-00000
Cool 50 MPW50	Cooling unit with centrifugal pump	1	090-008818-00502
WK16mm ² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005801-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
G1/4"+G3/8" 2 m		1	092-000525-00001
Maxex AR/MIX 200bar 30m ³ G1/4"	Pressure regulator	1	096-000000-00000
Maxex Hydrogen 200bar 30m ³ G3/8"L		1	096-000001-00000
Trolly 55-6 DF	Transport cart for a power source, cooling unit and two shielding gas cylinders	1	090-008826-00000
KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
ADAP3 G1/4-G1/4 LKS	Threaded adapter	1	094-001652-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Microplasma 105

Ty	Designation	PU	Item no.
Microplasma 105	Microplasma welding machine	1	090-007029-00502
PHW 100 3 m 5P	Plasma manual welding torch without setting gauge	1	394-003843-00000
EAG PHW100/150	Electrode setting gauge	1	094-008262-00000
Cool 50 MPW50	Cooling unit with centrifugal pump	1	090-008818-00502
WK16mm ² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005801-00000
GH 2x1/4" 2m	Gas hose	1	094-000010-00001
G1/4"+G3/8" 2 m		1	092-000525-00001
Maxex AR/MIX 200bar 30m ³ G1/4"	Pressure regulator	1	096-000000-00000
Maxex Hydrogen 200bar 30m ³ G3/8"L		1	096-000001-00000
Trolly 55-6 DF	Transport cart for a power source, cooling unit and two shielding gas cylinders	1	090-008826-00000
KF 23E-5	Coolant (-10 °C), 5 l	1	094-000530-00005
ADAP3 G1/4-G1/4 LKS	Threaded adapter	1	094-001652-00000
KOS26	Customised configuration with assembly for decompact systems	1	092-002685-00001
KOS27	Commissioning: 1 hour	1	KOS-V00027-00000

Plasma welding torches

PHW 20



- Water-cooled plasma welding torch
- Greater load capacity of the plasma nozzles thanks to optimised cooling system
- Reduced orating 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 rformance
- Please always use an electrode setting gauge to ensure optimum welding results



Duty cycle DC-	20 A / 60 %
Hose package length	3 m
Approvals	CE
Connection	Tuchel, 5-pole
Ø Nozzle	0,5 mm - 1,2 mm

Designation	PU	Item no.
Plasma torch	1	394-003872-00000

PHW 100



- Water-cooled plasma welding torch
- Greater load capacity of the plasma nozzles thanks to optimised cooling system
- Reduced orating 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 rformance
- Please always use an electrode setting gauge to ensure optimum welding results



Duty cycle DC-	100 A / 100 %
Duty cycle AC	80 A / 100 %
Duty cycle DC+	35 A / 100 %
Connection	Tuchel, 5-pole
Hose package length	3 m
Approvals	CE
Ø Nozzle	0,5 mm - 1,2 mm

Designation	PU	Item no.
Plasma manual welding torch without setting gauge	1	394-003843-00000

ON Adap Microplasma new



Designation	PU	Item no.
Adapter for connecting a welding torch with screw coupling to microplasma 25/55/105	1 stk	092-003539-00000

Remote controls - TIG/Plasma remote control

RT50



- The RT50 7POL remote control allows machines with a 7-pole connection to be equiped with a second remote control
- Robust metal casing with rubber feet, retaining clip and holding magnet, 7-pole connection socket
- Cable not supplied in delivery, please order connection cable separately

Dimensions in mm	115 x 235 x 300
Weight	3.2 kg
Connection	7-pole

Designation	PU stk	Item no.
Remote control with complete range of functions	1	090-008793-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 351 Synergic FW	090-000118-00502	359	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

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
- Orating point setting directly at the site of welding

Weight	0.7 kg
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	Cable length m	PU stk	Item no.
Remote control, current	5.0	1	090-008106-00000
	10.0	1	090-008106-00010

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Microplasma 25	090-007027-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Microplasma 55	090-007028-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Pico 300 cel	090-002043-00502	425	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 Smart TM	090-000125-00502	362
Picotig 200 puls TG	090-002058-00502	346	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 400 Basic TDG	090-005446-00502	193	Tetrix 351 Synergic FW	090-000118-00502	359
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 551 Synergic FW	090-000093-00502	360

Remote controls - TIG/Plasma remote control

RT1



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	1.2 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control, current	1	090-008097-0000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Microplasma 25	090-007027-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Microplasma 55	090-007028-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 180 puls	090-002003-00502	423	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Pico 300 cel	090-002043-00502	425	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 300 Smart TM	090-000125-00502	362
Pico 350 cel puls	090-002060-00502	426	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Pico 350 cel puls vrd (AUS)	090-002060-28503	426	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Picotig 200 puls TG	090-002058-00502	346	Tetrix 351 Synergic FW	090-000118-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 400 Basic TDG	090-005446-00502	193	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 551 Synergic FW	090-000093-00502	360

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
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	1.5 kg
Connection	19-pole
Dimensions LxWxH in mm	260 x 147 x 75

Designation	PU	Item no.
Remote control, spot/pulsed welding	1	090-008098-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Microplasma 25	090-007027-00502	390	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Microplasma 55	090-007028-00502	390	Tetrix 300 Smart TM	090-000125-00502	362
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 351 Synergic FW	090-000118-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 300 Comfort TM	090-000099-00502	362	Tetrix 551 Synergic FW	090-000093-00502	360

Remote controls - TIG/Plasma remote control

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%.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	ca.1.5 kg
Connection	19-pole
Dimensions LxWxH in mm	260 x 147 x 75

Designation	PU stk	Item no.
Remote control, spot/pulsed welding	1	090-008099-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 300 Smart TM	090-000125-00502	362
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 351 Synergic FW	090-000118-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 300 Comfort TM	090-000099-00502	362	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357	Tetrix 551 Synergic FW	090-000093-00502	360
Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357			

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%.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	1.5 kg
Connection	19-pole
Dimensions LxWxH in mm	260 x 147 x 75

Designation	PU stk	Item no.
Remote control, spotArc, spot/ pulsed welding	1	090-008211-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 Smart TM	090-000125-00502	362
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 351 Synergic FW	090-000118-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 300 Comfort TM	090-000099-00502	362	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

Remote controls - TIG/Plasma remote control

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.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Connection	19-pole
Dimensions LxWxH in mm	260 x 150 x 75

Designation	Weight kg	PU stk	Item no.
Remote control, current/ balance/frequency	1.1	1	090-008197-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371			

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.
- Orating point setting directly at the site of welding
- Cable not supplied in delivery, please order connection cable separately

Weight	0.42 kg
Connection	19-pole
Dimensions LxWxH in mm	118 x 118 x 94

Designation	PU stk	Item no.
Remote control, vertical-down weld, current pole reversal	1	090-008199-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 300 cel	090-002043-00502	425	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Pico 300 cel pws	090-002044-00502	425	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Pico 350 cel puls	090-002060-00502	426	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Pico 350 cel puls vrd (AUS)	090-002060-28503	426			

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

Cable length	5
Connection	19-pole

Designation	PU stk	Item no.
Foot-operated remote control, current, with connection cable	1	094-006680-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Microplasma 25	090-007027-00502	390	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Microplasma 55	090-007028-00502	390	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 180 puls	090-002003-00502	423	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel	090-002043-00502	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Smart TM	090-000125-00502	362
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 350 cel puls	090-002060-00502	426	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 351 Synergic FW	090-000118-00502	359
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Pico 350 cel puls vrd (AUS)	090-002060-28503	426	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Picotig 200 puls TG	090-002058-00502	346	Tetrix 401 Synergic FW	090-000179-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 551 Synergic FW	090-000093-00502	360
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355			

Remote controls - Connection cables

Connection cables



Connection		19-pole	
Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection		19-pole	
Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

Digital 7-pole cable



- Digital 7-pole cable
- Extension for 7-pole remote control with permanently installed cable
- Connection cable for remote control and gateway without permanently installed cable

Connection		7-pole	
Designation	Cable length m	PU stk	Item no.
Digital 7-pole cable	0.5	1	092-000201-00004
	1.0	1	092-000201-00002
	5.0	1	092-000201-00003
	10.0	1	092-000201-00000
	15.0	1	092-000201-00005
	20.0	1	092-000201-00001
	25	1	092-000201-00007

Cooling units - Cooling units for TIG/Plasma welding machines

- Cooling unit for water-cooled welding torches
- Modular design, tool-free assembly
- Excellent torch cooling and therefore cost savings on consumables thanks to the high-rformance centrifugal pump
- External coolant water filling nozzle with filling level indicator

cool40 U31



Cooling output	900 W (1l/min)
Flow rate	5 l/min
Tank capacity	4 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	14 kg

Designation	PU	Item no.
Cooling unit with centrifugal pump	1	090-008593-00502
Packing unit: 6 x cool40 U31	1	092-015283-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355

cool41 U31



Cooling output	900 W (1l/min)
Flow rate	5 l/min
Tank capacity	4 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	603 x 210 x 340
Weight, cooling unit	18.4 kg

Designation	PU	Item no.
Cooling unit with centrifugal pump	1	090-008600-00502
Packing unit: 6 cool41 U31	1	092-015291-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357

Cooling units - Cooling units for TIG/Plasma welding machines

cool50 MPW50



- Recommended for manual and partially-mechanised welding tasks
- When using Microplasma for automated tasks we recommend the use of a recooling unit

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	695 x 298 x 329
Weight, cooling unit	14.3 kg

Designation	PU	Item no.
Cooling unit with centrifugal pump	1	090-008818-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Microplasma 25	090-007027-00502	390
			Microplasma 55	090-007028-00502	390

cool35 U31



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

Designation	PU	Item no.
Cooling unit with centrifugal pump	1	090-008235-00502
Packing unit: 6 x cool35 U31	1	092-015295-00502

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 300 Comfort TM	090-000099-00502	362	Tetrix 300 Smart TM	090-000125-00502	362

Cooling units - Recooling units

RK



- High-rformance recooling unit with fully thermal motor compressor
- Can be used as an alternative to the Cool 50 MPW50
- Recommended for automated continuous oration or at very high ambient tempratures
- **Note:** Does not fit under Microplasma or on Trolley 55-6
- Requires its own power supply
- Rear connections
- High-rformance pump, pressure switch, temprature-controlled pump and fan
- Coolant drain valve and coolant level indicator
- A recooling unit with boosted pump is necessary when using torches with more than 150 A!
- Temprature control and LED display

Designation	Weight, cooling unit kg	Dimensions cooling unit in mm mm	Tank capacity		Cooling output		Mains voltage V	PU stk	Item no.
			l	W	l	W			
Recooling unit	42	565 x 440 x 345	6.0	900	1 x 230	2000	1	094-002283-00000	
				2700		3 x 400	1	094-002284-00000	
				2700		3 x 400	1	094-002285-00000	
Recooling unit with boosted pump 8 bar	85	750 x 450 x 500	15.0	2000	1 x 230	2700	1	094-002284-02000	
				2700		3 x 400	1	094-002285-02000	

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Microplasma 55	090-007028-00502	390
Microplasma 25	090-007027-00502	390			

Frost protection tester

Designation	PU stk	Item no.
Frost protection tester	1	094-014499-00000

Cooling units - Coolant

KF 23E -10



- Coolant for water-cooled welding machines and cooling units

Designation	Freezing point °C	Con- tents l	PU	Item no.
Coolant (-10 °C), 5 l	-10.0	5.0	1	094-000530-00005
Coolant (-10 °C), 200 l		200	1	094-000530-00001

KF 37E -20°



- Coolant for water-cooled welding machines and cooling units

Designation	Freezing point °C	Con- tents l	PU	Item no.
Coolant (-20 °C), 5 l	-20.0	5.0	1	094-006256-00005
Coolant (-20 °C), 200 l		200	1	094-006256-00001

Options/accessories - Options for TIG and plasma welding machines

ON Filter T.0003



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002546-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 220 cel puls	090-002057-00502	424	Picotig 200 puls TG	090-002058-00502	346

ON Filter T.0004



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002547-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
			Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353

ON Filter TG.0002



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002551-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357

ON Filter F.0001



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU	Item no.
Dirt filter for air inlet	1	092-002092-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Basic FDG	090-005249-00502	208
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Basic FDW	090-005250-00502	211
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Basic FKG	090-005426-00502	204
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Basic FKW	090-005408-00502	206
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S LP MM FKW	090-005428-00502	134	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360

ON Filter F.0002



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU	Item no.
Dirt filter for air inlet	1	092-004999-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 451 AC/DC Synergic FW	090-000112-00502	371	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371

Options/accessories - Options for TIG and plasma welding machines

ON Filter K.0001



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-008772-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
cool40 U31	090-008593-00502	401	cool41 U31	090-008600-00502	401
6x cool40 U31	092-015283-00502	401	6x cool41 U31	092-015291-00502	401

ON Key Switch



Designation	PU stk	Item no.
Key switch	1	092-001828-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Tetrix 351 Synergic FW	090-000118-00502	359	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 401 Synergic FW	090-000179-00502	359	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

OW Reinforced Pump F.0001/F.0002



- 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

Designation	PU stk	Item no.
Heavy-duty coolant pump (only ex works)	1	092-002118-00001

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 AC/DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Basic FKW	090-005408-00502	206			
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136			

Options/accessories - Options for TIG and plasma welding machines

ON HS F.0001/F.0002



- 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 Phoenix/Taurus/Tetrix 351/401/451/551 machines

Designation	PU stk	Item no.
Mount for hose packages and welding torch	1	092-002910-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S MM FDW	090-005346-00502	141	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

ON Holder Gas Bottle <50L F.0001/F.0005



- 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!

Designation	PU stk	Item no.
Holding plate for gas cylinders smaller than 50 litres	1	092-002151-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 351 Synergic FW	090-000118-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 401 Basic FDW	090-005250-00502	211	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 401 Basic FKG	090-005426-00502	204	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 401 Basic FKW	090-005408-00502	206	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Wega 401 FDW	090-004949-00502	254
Taurus 401 Synergic S MM FDW	090-005346-00502	141	Wega 401 FDG	090-004948-00502	252

Options/accessories - Options for TIG and plasma welding machines

ON Holder Gas Bottle <50L F.0002



- 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!

Designation	PU stk	Item no.
Holding plate for gas cylinders smaller than 50 litres	1	092-002345-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 451 AC/DC Synergic FW	090-000112-00502	371	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371

ON PC Plug



- Protective cap for plug
- Protects against force exerted from left, right or above

Designation	PU stk	Item no.
Protective cap for plug	1	092-003074-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357

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

Designation	PU	Item no.
Toolbox between gas cylinder and rear casing panel	1	092-002138-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 401 Basic FDG	090-005249-00502	208	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Basic FDW	090-005250-00502	211			
Taurus 401 Basic FKG	090-005426-00502	204			
Taurus 401 Basic FKW	090-005408-00502	206			
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136			

Options/accessories - Options for TIG and plasma welding machines

ON LB Wheels 160 x 40 mm



- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.
- Locking brake cannot be combined with ram protection!

Designation	PU stk	Item no.
Locking brake for machine wheels	1	092-002110-0000

Suitable for:

Typ	Artikel-Nr.	Seite	Typ	Artikel-Nr.	Seite
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 501 Basic FKW	090-005410-00502	185
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 501 Synergic S LP MM FKW	090-005424-00502	136
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 401 Basic FDG	090-005249-00502	208	Wega 401 M1.02 FKG	090-005224-00502	248
Taurus 401 Basic FDW	090-005250-00502	211	Wega 401 M1.02 FKW	090-005227-00502	250
Taurus 401 Basic FKG	090-005426-00502	204	Wega 401 M2.20 FKG	090-005225-00502	249
Taurus 401 Basic FKW	090-005408-00502	206	Wega 401 M2.40 FKG	090-005226-00502	249
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136	Wega 501 FDW	090-005088-00502	255
Taurus 401 Synergic S MM FDG	090-005342-00502	138	Wega 601 FDW	090-005089-00502	255
Taurus 401 Synergic S MM FDW	090-005346-00502	141			

ON WAK TG.0003/TG.0004/TG.0009/K.0002



- Wheel set – facilitates work at frequently changing welding sites

Designation	PU	Item no.
Wheel assembly kit	1	092-001356-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
cool50-2 U40	090-008603-00502	320	Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104
cool50-2 U42	090-008796-00502	320	Phoenix 505 Progress puls MM TDM	090-005322-00502	100
Cool 50 MPW50	090-008818-00502	402	Picomig 185 puls TKG	090-005547-00502	229
cool50 U40	090-008598-00502	320	Picomig 185 Synergic TKG	090-005548-00502	231
cool50 U42	090-008797-00502	320	Picomig 355 puls TKM	090-005542-00502	233
Microplasma 105	090-007029-00502	390	Picomig 355 Synergic TKM	090-005512-00502	235
Microplasma 25	090-007027-00502	390	Taurus 355 Basic TDM	090-005286-00502	198
Microplasma 55	090-007028-00502	390	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 505 Synergic S MM TDM	090-005338-00502	132

ON Safeguard T.0003



- 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

Designation	PU	Item no.
Protective sleeve for welding machines	1	092-008767-00000
Packing unit 8 pieces ON Safeguard M	1	092-002806-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 180 puls	090-002003-00502	423	Pico 220 cel puls	090-002057-00502	424
			Picotig 200 puls TG	090-002058-00502	346

Options/accessories - Options for TIG and plasma welding machines

ON 7pol



- 7-pole connection socket for accessory components and/or as digital interface

Designation	PU stk	Item no.
7-pole connection socket for accessory components and/or as digital interface	1	092-001826-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 351 Synergic FW	090-000118-00502	359	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 401 Synergic FW	090-000179-00502	359	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 451 AC/DC Synergic FW	090-000112-00502	371	Tetrix 551 Synergic FW	090-000093-00502	360
Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359			

ON 8pol



Designation	PU stk	Item no.
8-pole connection socket	1	092-002465-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
			Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357

ON 12pol Retox T.0004



Designation	PU stk	Item no.
12-pole connection socket	1	092-002466-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353

ON 12pol Retox TG.0002

Designation	PU stk	Item no.
12-pole torch connection socket	1	092-002519-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357

ON 12pol Retox TG.0008/F.0001/F.0002

- 12-pole connection socket for connecting a TIG Retox welding torch

Designation	PU stk	Item no.
12-pole connection socket	1	092-001807-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 300 Comfort TM	090-000099-00502	362	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 351 Synergic FW	090-000118-00502	359	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 401 Synergic FW	090-000179-00502	359	Tetrix 551 Synergic FW	090-000093-00502	360

ON 19pol TG.0008

Designation	PU stk	Item no.
19-pole connection socket for accessory components and/or as analog interface for automated welding	1	092-001827-00000

Suitable for:

Ty	Item no.	Page
Tetrix 300 Comfort TM	090-000099-00502	362

Options/accessories - Options for TIG and plasma welding machines

ON 19pol F.0001/F.0002



Designation	PU stk	Item no.
19-pole connection socket for accessory components and/or as analog interface for automated welding	1	092-001951-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 351 Synergic FW	090-000118-00502	359	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 401 Synergic FW	090-000179-00502	359	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 451 AC/DC Synergic FW	090-000112-00502	371	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
			Tetrix 551 Synergic FW	090-000093-00502	360

ON Netsynchron



Designation	PU stk	Item no.
Phase sequence changeover set for synchronous welding	1	090-008212-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 451 AC/DC Synergic FW	090-000112-00502	371	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371			

Overview MMA welding machines

MMA DC welding machines			Page			
Pico	Pico		418			
	Pico 160 cel puls		419			
	Pico		420			
	Pico 162 Multivolt		421			
	Pico 180 puls		422			
	Pico 220 cel puls		423			
	Pico 300 cel - Pico 300 cel pws		424			
	Pico 350 cel puls - Pico 350 cel puls pws		425			
	Pico drive 200C		426			
	Pico drive 4L		427			
	Pico drive 4L		427			
Degaussing	Pico 350 Degauss		428			
	Degauss 600		429			
Welding machine accessories	Remote controls	MMA remote controls	RTG1	430		
			RT1	431		
			RG13	432		
			RTF1	432		
			RT PWS 1	433		
			RT DGS1	433		
			Connection cables	Connection cables	400	
			Options/accessories	Options for MMA welding machines	ON Handle Pico 160	435

Pico 160



- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and TIG lift arc welding
- Arcforce, hot start, antistick
- Portable, shoulder strap
- **Your benefits**
- Very light-weight – casing made of aluminium and impact-resistant plastic
- IP23 spray water protected
- 3.5 m mains lead with 16 A earthed plug
- **Ovoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Pico 160



Remote controls	Page	430
Options/accessories	Page	435
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Version	Pico 160
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
On circuit voltage	105 V
Setting range for welding current	10 A - 150 A
Duty cycle 40 °C	150 A / 35 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	83 %
Dimensions machine, LxWxH in mm	370 x 129 x 236
Weight, machine	4.9 kg
EMC class	A
Insulation class	H
Protection class	IP23

Approvals



Ty	Designation	PU	Item no.
Pico 160	MMA inverter welding machine	1	090-002128-00502
WK16mm ² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005801-00000
EH 16 mm ² 170 A/60% 4 m	Electrode holders	1	094-005800-00000
Packing unit			
12x Pico 160	Packing unit: 12x Pico 160		092-015319-00502

Pico 160 cel puls



Pico 160 cel puls



Remote controls	Page	430
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Electrode holders	Page	485

- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- MMA and TIG lift arc welding
- Pulsed TIG welding with up to 2 kHz
- Cellulose electrodes: 100% safe for vertical-down welding
- Welding of stick electrodes up to 4 mm
- Arcforce, hot start, antistick
- Portable, shoulder strap
- **Your benefits**
- Connection capability for remote control
- Very light-weight – casing made of aluminium and impact-resistant plastic
- IP23 spray water protected
- Energy efficient due to standby mode
- 3.5 m mains lead with 16 A earthed plug
- Also available as a VRD version conforming to the Russian and Australian safety requirements
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**



Version	Pico 160 cel puls
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
On circuit voltage	94 V
Setting range for welding current	5 A - 150 A
Duty cycle 40 °C	150 A / 30 %
	120 A / 60 %
	110 A / 100 %
cos φ	0.99
Efficiency	83 %
Dimensions machine, LxWxH in mm	370 x 129 x 236
Weight, machine	4.9 kg
EMC class	A
Insulation class	H
Protection class	IP23

Approvals



Ty	Designation	PU	Item no.
		stk	
Pico 160 cel puls	MMA inverter welding machine	1	090-002129-00502
Pico 160 cel puls VRD (AUS)	MMA inverter welding machine with on circuit voltage reduction to AS 1674.2-2003	1	090-002129-28503
Pico 160 cel puls VRD (RU)	MMA welding machine with on circuit voltage reduction in accordance with IEC/DIN EN 60974-1 and GOCT 12.2	1	090-002129-28504
RG13 RS-453	Remote control, current	1	090-008113-00000
WK16mm² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005801-00000
EH 16 mm² 170 A/60% 4 m	Electrode holders	1	094-005800-00000

Packing unit		
12x Pico 160 cel puls	Packing unit: 12x Pico 160 cel puls	092-015320-00502
12x Pico 160 cel puls VRD (AUS)	Packing unit: 12x Pico 160 cel puls (AUS)	092-015320-28503
12x Pico 160 cel puls VRD (RU)	Packing unit: 12x Pico 160 cel puls (RU)	092-015320-28504

Pico 160 L-BOXX Set



Pico 160



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- No damage during transport thanks to robust L-BOXX
- All the components always at hand
- L-BOXX system compatible to transport systems of many well-known manufacturers
- Pico 160 set in robust plastic case
- Set comprising: Pico 160, Pico carrying handle, dirt filter, workpiece lead, electrode holder and documentation
- **Welding procedures and functions**
- MMA and TIG lift arc welding
- Arcforce, hot start, antistick
- Portable, shoulder strap
- **Your benefits**
- Very light-weight – casing made of aluminium and impact-resistant plastic
- IP23 spray water protected
- 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**



Version	Pico 160
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
On circuit voltage	105 V
Setting range for welding current	10 A - 150 A
Duty cycle 40 °C	150 A / 35 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	83 %
Dimensions machine, LxWxH in mm	370 x 129 x 236
Weight, machine	4.9 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	

Ty	Designation	PU stk	Item no.
Pico 160 L-BOXX Set	MMA inverter welding machine in robust L-BOXX transport box	1	091-002128-00502

► * Only the items in bold are included in the total

Packing unit

12x Pico 160 L-BOXX Set	Packing unit: 12 pieces Pico 160 L-BOXX Set	092-003411-00502
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Pico 160 cel puls L-BOXX Set



Pico 160 cel puls



Remote controls	Page	430
Options/accessories	Page	435

- Pico 160 cel puls set in robust plastic case
- Set comprising: Pico 160 cel puls, Pico carrying handle, dirt filter, workpiece lead, electrode holder and documentation
- No damage during transport thanks to robust L-BOXX
- All the components always at hand
- L-BOXX system compatible to transport systems of many well-known manufacturers
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- MMA and TIG lift arc welding
- Pulsed TIG welding with up to 2 kHz
- Cellulose electrodes: 100% safe for vertical-down welding
- Welding of stick electrodes up to 4 mm
- Arcforce, hot start, antistick
- Portable, shoulder strap
- **Your benefits**
- Connection capability for remote control
- Very light-weight – casing made of aluminium and impact-resistant plastic
- IP23 spray water protected
- 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**

Version	Pico 160 cel puls
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
On circuit voltage	94 V
Setting range for welding current	5 A - 150 A
Duty cycle 40 °C	150 A / 30 %
	120 A / 60 %
	110 A / 100 %
cos φ	0.99
Efficiency	83 %
Dimensions machine, LxWxH in mm	370 x 129 x 236
Weight, machine	4.9 kg
EMC class	A
Insulation class	H
Protection class	IP23

Approvals



Ty	Designation	PU	Item no.
Pico 160 cel puls L-BOXX Set	MMA inverter welding machine in robust L-BOXX transport box	1	091-002129-00502
Ty	Designation	PU	Item no.
RG13 RS-453	Remote control, current	1	090-008113-00000

► * Only the items in bold are included in the total

Packing unit

12x Pico 160 cel puls L-BOXX Set	Packing unit: 12 pieces Pico 160 cel puls L-BOXX Set	092-003412-00502
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Pico 162 Multivolt



Remote controls	Page	430
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Electrode holders	Page	485

- Inverter welding machine, DC, automatic mains voltage adaptation
- **Welding procedures and functions**
- MMA and TIG lift arc welding
- Arcforce, hot start, antistick
- Portable, shoulder strap
- **Your benefits**
- One-knob oration
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**



Version	Input voltage: 230 V	Input voltage: 115 V
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
On circuit voltage	105 V	
Setting range for welding current	10 A - 150 A	
Duty cycle 40 °C	150 A / 35 %	110 A / 35 %
	120 A / 60 %	90 A / 60 %
	100 A / 100 %	80 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions machine, LxWxH in mm	360 x 116 x 224	
Weight, machine	5.4 kg	
EMC class	A	
Insulation class	H	
Protection class	IP23	
Approvals		

Ty	Designation	PU	Item no.
Pico 162 MV	Multivolt MMA inverter welding machine	1	090-002042-00502
WK16mm² 170A/60% 4m/K	Workpiece lead with clamp	1	094-005314-00000
EH 16 mm² 170 A/60% 4 m	Electrode holder with cable	1	094-005313-00000

► * Only the items in bold are included in the total

Packing unit		
12x Pico162 MV	Packing unit: 12 x Pico 162 MV	092-002058-00502

Pico 180 puls



- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- MMA and TIG lift arc welding
- Arcforce and hot start can be set
- Portable, shoulder strap
- Antistick
- **Your benefits**
- Connection capability for remote control
- Also available as a VRD version conforming to the Russian and Australian safety requirements
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Pico 180 puls



Remote controls	Page	430
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Version	Pico 180 puls
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
On 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 machine, LxWxH in mm	428 x 136 x 252
Weight, machine	8.3 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	

Ty	Designation	PU stk	Item no.
Pico 180 puls	MMA inverter welding machine	1	090-002003-00502
Pico 180 puls VRD (AUS)	MMA inverter welding machine with on circuit voltage reduction to AS 1674.2-2003	1	090-002051-00502
Pico 180 puls VRD (RU)	MMA inverter welding machine with on circuit voltage reduction as r IEC/EN 60974-1 and ГOCT 12.2	1	090-002051-00503
WK35mm ² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
EH 35mm ² 290A/60% 4m	Electrode holder with cable	1	092-000052-00000
Packing unit			
8x Pico180	Packing unit: 8 x Pico 180 puls		092-015235-00502
8x Pico 180 puls VRD (AUS)	Packing unit: 8 x Pico 180 puls VRD (AUS)		092-015248-00502
8x Pico 180 puls VRD (RU)	Packing unit: 8 x Pico 180 puls VRD (RU)		092-015248-00503

Pico 220 cel puls



Pico 220 cel puls



Remote controls	Page	430
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Electrode holders	Page	485

- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- MMA and TIG lift arc welding
- Cellulose electrodes: 100% safe for vertical-down welding
- Arcforce and hot start can be set
- Portable, shoulder strap
- Antistick
- **Your benefits**
- Connection capability for remote control
- 5 m mains supply lead
- Also available as a VRD version conforming to the Russian and Australian safety requirements

Version	Pico 220 cel puls
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 10 A
On 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 machine, LxWxH in mm	428 x 136 x 252
Weight, machine	10.5 kg
EMC class	A
Insulation class	H
Protection class	IP23
Approvals	S CE EAC

Ty	Designation	PU	Item no.
		stk	
Pico 220 cel puls	MMA inverter welding machine	1	090-002057-00502
Pico 220 cel puls vrd (RU)	MMA inverter welding machine with on circuit voltage reduction to IEC/EN 60974-1 and ГОСТ 12.2.007.8	1	090-002057-28504
Pico 220 cel puls vrd (AUS)	MMA inverter welding machine with on circuit voltage reduction to AS 1674.2-2003	1	090-002057-28503
WK35mm² 290A/60% 4m/K	Workpiece lead with clamp	1	092-000008-00000
EH 35mm² 290A/60% 4m	Electrode holder with cable	1	092-000052-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000

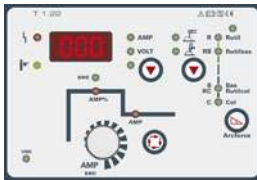
Packing unit

8x Pico 220 cel puls	Packing unit: 8x Pico 220 cel puls	092-015280-00502
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Pico 300 cel | Pico 300 cel pws



Pico 300 cel



Remote controls	Page	430
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- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and TIG lift arc welding
- Cellulose electrodes: 100% safe for vertical-down welding
- Arcforce and hot start can be set
- Portable, shoulder strap
- Antistick
- **Your benefits**
- PRS: Pole reversal on the machine or via remote control saves time-consuming reconnecting of welding current connections
- 5 m mains supply lead
- Also available as a VRD version conforming to the Russian and Australian safety requirements

Version	Pico 300 cel	Pico 300 cel pws
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 10 A	
On 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 machine, LxWxH in mm	515 x 185 x 350	515 x 185 x 445
Weight, machine	16.5 kg	23.5 kg
EMC class	A	
Insulation class	H	
Protection class	IP23	

Approvals



Standard version

Ty	Designation	PU stk	Item no.
Pico 300 cel	MMA inverter welding machine	1	090-002043-00502
Pico 300 cel vrd 12V	MMA inverter welding machine with on circuit voltage reduction to AS 1674.2-2003	1	090-002043-00503
Pico 300 cel svrd 12V	MMA inverter welding machine with on circuit voltage reduction as r IEC/EN 60974-1 and ГOCT 12.2	1	090-002043-00504
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
EH 50m² 350A/60% 4m	Electrode holder with cable	1	092-000004-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000

Version with pole reversing switch

Ty	Designation	PU stk	Item no.
Pico 300 cel pws	MMA inverter welding machine, pole reversing switch	1	090-002044-00502
Pico 300 cel pws vrd 12V	MMA inverter welding machine with pole reversing switch and on circuit voltage reduction to AS 1674.2-2003	1	090-002044-00503
Pico 300 cel pws svrd 12V	MMA inverter welding machine with pole reversing switch and on circuit voltage reduction to IEC/EN 60974-1 and ГOCT 12.2 007.8	1	090-002044-00504
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
EH 50m² 350A/60% 4m	Electrode holder with cable	1	092-000004-00000
OW CEE 16A/400V	Mains plug, assembled	1	092-008214-00000

Packing unit

6x Pico 300 CEL	Packing unit: 6x Pico 300 cel	092-002298-00502
6x Pico 300 cel svrd 12V	Packing unit: 6x Pico 300 cel SVRD	092-002298-00504
6x Pico 300 cel vrd 12V	Packing unit: 6x Pico 300 cel VRD	092-002298-00503

Pico 350 cel puls | Pico 350 cel puls pws



Pico 350 cel puls



Remote controls	Page	430
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Electrode holders	Page	485

- Inverter welding machine, DC
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- rfect MMA vertical-up welding through PF pulse function
- MMA and TIG lift arc welding
- GMAW welding with Pico drive 4L or Pico drive 200C wire feeder
- CC/CV characteristic
- Suitable for flux cored wire welding
- Cellulose electrodes: 100% safe for vertical-down welding
- Arcforce and hot start can be set
- Portable, shoulder strap
- **Your benefits**
- PRS: Pole reversal on the machine or via remote control saves time-consuming reconnecting of welding current connections
- Robust design suitable for construction site use
- Impact-resistant casing
- Inscted protection against splash water (IP-34s)
- Energy-saving thanks to high efficiency and standby function
- 5 m mains supply lead
- Also available as a VRD version conforming to the Russian and Australian safety requirements



Version	Pico 350 cel puls	Pico 350 cel puls pws
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 16 A	
On 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 machine, LxWxH in mm	539 x 210 x 415	
Weight, machine	23.5 kg	25 kg
EMC class	A	
Insulation class	H	
Protection class	IP34s	
Approvals		

Standard version

Ty	Designation	PU stk	Item no.
Pico 350 cel puls	MMA inverter welding machine	1	090-002060-00502
Pico 350 cel puls vrd (AUS)	MMA inverter welding machine with on circuit voltage reduction to AS 1674.2-2003	1	090-002060-28503
Pico 350 cel puls vrd (RU)	MMA inverter welding machine with on circuit voltage reduction as r IEC/EN 60974-1 and GOCT 12.2	1	090-002060-28504
WK50mm² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
EH 50m² 350A/60% 4m	Electrode holder with cable	1	092-000004-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000

Version with pole reversing switch

Ty	Designation	PU stk	Item no.
Pico 350 cel puls pws	MMA inverter welding machine, pole reversing switch	1	090-002061-00502
Pico 350 cel puls pws vrd (AUS)	MMA inverter welding machine with pole reversing switch and on circuit voltage reduction to AS 1674.2-2003	1	090-002061-28503
Pico 350 cel puls pws vrd (RU)	MMA inverter welding machine with pole reversal and on circuit voltage reduction as r IEC/DIN EN	1	090-002061-28504
WK50mm ² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
EH 50m ² 350A/60% 4m	Electrode holder with cable	1	092-000004-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000

Packing unit

6x Pico 350 cel puls	Packing unit: 6 x Pico 350 cel puls	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
6x Pico 350 cel puls pws	Packing unit: 6 x Pico 350 cel puls pole reversing switch	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

Pico drive 200C



- MIG/MAG wire feeder for Pico 350 cel puls
- MMA and TIG lift arc welding
- Spool diameter up to 200 mm
- Arcforce, hot start, antistick
- Portable, shoulder strap
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires

Ty	Designation	PU stk	Item no.
Pico drive 200C	Wire feeder	1	090-002124-00502

Pico drive 4L



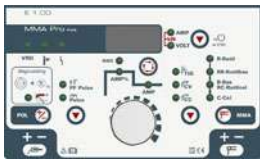
- MIG/MAG wire feeder for Pico 350 cel puls
- Aluminium housing
- Suitable for 200 mm or 300 mm wire spools
- 4-roll drive. Equipd for 1.0 mm + 1.2 mm steel wires

Ty	Designation	PU stk	Item no.
Pico drive 4L	Wire feeder	1	090-002121-00502

Pico 350 cel puls pws dgs






Pico 350 cel puls degauss



Remote controls	Page	430
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- MMA inverter welding machine with degaussing function, pole reversing switch
- **Welding procedures and functions**
- MMA and pulsed TIG welding
- rfect MMA vertical-up welding through PF pulse function
- Degaussing of pis and metal sheets through automatic process before the welding (max. 350 A)
- Degaussing function ensures a stable welding process without magnetic deflection
- GMAW welding with Pico drive 4L or Pico drive 200C wire feeder
- CC/CV characteristic
- Suitable for flux cored wire welding
- Cellulose electrodes: 100% safe for vertical-down welding
- Welding polarity can be reversed by pressing a button (polarity reversing switch)
- Arcforce and hot start can be set
- Portable, shoulder strap
- Antistick
- **Your benefits**
- PRS: Pole reversal on the machine or via remote control saves time-consuming reconnecting of welding current connections
- Robust design suitable for construction site use
- Impact-resistant casing
- Inscted protection against splash water (IP-34s)
- Energy-saving thanks to high efficiency and standby function
- 5 m mains supply lead
- **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



Version	Pico 350 cel puls pws dgs
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
On 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 machine, LxWxH in mm	539 x 210 x 415
Weight, machine	25 kg
EMC class	A
Insulation class	H
Protection class	IP34s
Approvals	  

Ty	Designation	PU stk	Item no.
Pico 350 cel puls pws dgs	MMA inverter welding machine, polarity reversing switch, degaussing	1	090-002127-00502
Set LC 35 mm ²	Set: Two 5-metre load cables (35 mm ²) and one 20-metre load cable (35 mm ²) for degaussing	1	092-002921-00000
WK50mm ² 350A/60% 4m/K	Workpiece lead with clamp	1	092-000003-00000
EH 50mm ² 350A/60% 4m	Electrode holder with cable	1	092-000004-00000
OW CEE 32A	Mains plug, assembled (CEE 32 A)	1	092-008215-00000

Degauss 600



Remote controls	Page	430
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- Degaussing machine for degaussing of pipes and metal sheets
- **Automatic degaussing process before welding:**
- Durable degaussing for better welding results through stable welding process without magnetic deflection, minimisation of finishing work
- **activgauss (10–250 A) – degaussing during welding:**
- Avoids moving up of magnetic field during the welding process in case of very long and strongly magnetised components
- Portable and robust
- Instant connection to the pipe by means of three load cables
- Used at -25 °C to +40 °C
- 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
- **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



Version	Degauss 600
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3
Degaussing current	10 A - 600 A
cos φ	0.99
Efficiency	90 %
Dimensions machine, LxWxH in mm	539 x 210 x 415
Weight, machine	25 kg
EMC class	A
Insulation class	H
Protection class	IP34s
Approvals	

Ty	Designation	PU	Item no.
		stk	
Set Degauss 600	Set: Degauss 600 degaussing machine, two 5-metre, 35 mm ² load cables, one 20-metre, 35 mm ² load cable, RT DGS1 remote control and 5-m connection cable	1	091-002065-00502

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)

Ty	Designation	PU	Item no.
		stk	
FIM1-4 Set	Set: magnetic field meter, including Hall effect sensor	1	092-002937-00000

Remote controls - MMA remote controls

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
- Orating point setting directly at the site of welding

Weight	0.7 kg
Connection	19-pole
Dimensions LxWxH in mm	225 x 70 x 60

Designation	Cable length	PU	Item no.
	m	stk	
Remote control, current	5.0	1	090-008106-00000
	10.0	1	090-008106-00010

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Microplasma 25	090-007027-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Microplasma 55	090-007028-00502	390	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Pico 300 cel	090-002043-00502	425	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 Smart TM	090-000125-00502	362
Picotig 200 puls TG	090-002058-00502	346	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Taurus 400 Basic TDG	090-005446-00502	193	Tetrix 351 Synergic FW	090-000118-00502	359
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 401 Synergic FW	090-000179-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 551 Synergic FW	090-000093-00502	360

RT1



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Orating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- Cable not supplied in delivery, please order connection cable separately

Weight	1.2 kg
Connection	19-pole
Dimensions LxWxH in mm	180 x 100 x 70

Designation	PU stk	Item no.
Remote control, current	1	090-008097-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Microplasma 25	090-007027-00502	390	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Microplasma 55	090-007028-00502	390	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 180 puls	090-002003-00502	423	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel	090-002043-00502	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Smart TM	090-000125-00502	362
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 350 cel puls	090-002060-00502	426	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 351 Synergic FW	090-000118-00502	359
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Pico 350 cel puls vrd (AUS)	090-002060-28503	426	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Picotig 200 puls TG	090-002058-00502	346	Tetrix 401 Synergic FW	090-000179-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 400 Basic TDG	090-005446-00502	193	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 Synergic FW	090-000093-00502	360
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355			
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355			
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355			
Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355			
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369			
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369			

Remote controls - MMA remote controls

RG13



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- With pre-fitted 5-m connection cable
- Orating point setting directly at the site of welding

Cable length	5
---------------------	---

Designation	PU stk	Item no.
Remote control, current	1	090-008113-00000

Suitable for:

Ty	Item no.	Page
Pico 160 cel puls	090-002129-00502	419

RTF1



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Start/stop welding oration
- Orating point setting directly at the site of welding

Cable length	5
Connection	19-pole

Designation	PU stk	Item no.
Foot-orated remote control, current, with connection cable	1	094-006680-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Microplasma 25	090-007027-00502	390	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Microplasma 55	090-007028-00502	390	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 180 puls	090-002003-00502	423	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 220 cel puls	090-002057-00502	424	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 300 cel	090-002043-00502	425	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 Smart TM	090-000125-00502	362
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 350 cel puls	090-002060-00502	426	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 351 Synergic FW	090-000118-00502	359
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Pico 350 cel puls vrd (AUS)	090-002060-28503	426	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Picotig 200 puls TG	090-002058-00502	346	Tetrix 401 Synergic FW	090-000179-00502	359
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353	Tetrix 451 Synergic FW	090-000103-00502	359
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 551 Synergic FW	090-000093-00502	360
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355			

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.
- Orating point setting directly at the site of welding
- Cable not supplied in delivery, please order connection cable separately

Weight	0.42 kg
Connection	19-pole
Dimensions LxWxH in mm	118 x 118 x 94

Designation	PU stk	Item no.
Remote control, vertical-down weld, current pole reversal	1	090-008199-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 300 cel	090-002043-00502	425	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Pico 300 cel pws	090-002044-00502	425	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Pico 350 cel puls	090-002060-00502	426	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	427			
Pico 350 cel puls vrd (AUS)	090-002060-28503	426			
Tetrix 351 AC/DC Synergic FW	090-000109-00502	371			

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
- Cable not supplied in delivery, please order connection cable separately

Weight	0.42 kg
Dimensions LxWxH in mm	118 x 118 x 94

Designation	PU stk	Item no.
Degauss remote control	1	090-008806-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Set Degauss 600	091-002065-00502	429	Pico 350 cel puls pws dgs	090-002127-00502	428

Remote controls - Connection cables

Connection cables



Connection		19-pole	
Designation	Cable length m	PU stk	Item no.
Connection cables	5.0	1	092-001470-00005
	10.0	1	092-001470-00010
	20.0	1	092-001470-00020

Extension cable



Connection		19-pole	
Designation	Cable length m	PU stk	Item no.
Extension cable	5.0	1	092-000857-00000
	10.0	1	092-000857-00010
	15.0	1	092-000857-00015
	20.0	1	092-000857-00020

Digital 7-pole cable



- Digital 7-pole cable
- Extension for 7-pole remote control with rmanently installed cable
- Connection cable for remote control and gateway without rmanently installed cable

Connection		7-pole	
Designation	Cable length m	PU stk	Item no.
Digital 7-pole cable	0.5	1	092-000201-00004
	1.0	1	092-000201-00002
	5.0	1	092-000201-00003
	10.0	1	092-000201-00000
	15.0	1	092-000201-00005
	20.0	1	092-000201-00001
	25	1	092-000201-00007

Options/accessories - Options for MMA welding machines

ON Handle Pico 160



Designation	PU stk	Item no.
Handle	1	092-003205-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 160	090-002128-00502	418	Pico 160 cel puls	090-002129-00502	419

ON Filter Pico 160



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-003206-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 160	090-002128-00502	418	Pico 160 cel puls	090-002129-00502	419

ON Filter T.0002



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002072-00000

Suitable for:

Ty	Item no.	Page
Pico 162 MV	090-002042-00502	422

ON Filter T.0003



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002546-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 220 cel puls	090-002057-00502	424	Picotig 200 puls TG	090-002058-00502	346

Options/accessories - Options for MMA welding machines

ON Safeguard T.0003



- 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

Designation	PU	Item no.
Protective sleeve for welding machines	1	092-008767-00000
Packing unit 8 pieces ON Safeguard M	1	092-002806-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 180 puls	090-002003-00502	423	Pico 220 cel puls	090-002057-00502	424
			Picotig 200 puls TG	090-002058-00502	346

ON Filter TG.0005



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-001856-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 300 cel	090-002043-00502	425	Pico 300 cel pws vrd 12V	090-002044-00503	425
Pico 300 cel pws	090-002044-00502	425	Pico 300 cel svrd 12V	090-002043-00504	425
Pico 300 cel pws svrd 12V	090-002044-00504	425	Pico 300 cel vrd 12V	090-002043-00503	425

ON Filter TG.0001



- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Designation	PU stk	Item no.
Dirt filter for air inlet	1	092-002756-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 350 cel puls	090-002060-00502	426	Pico 350 cel puls pws dgs	090-002127-00502	428
Pico 350 cel puls pws	090-002061-00502	427	Taurus 400 Basic TDG	090-005446-00502	193




Overview Multivolt machines and packing units

Multivolt machines			Page
		Mira 221 MV	441
		Picotig 200 MV 5P TGD	442
Multivolt machines	Multivolt machines	Tetrix 200 Comfort 2.0 puls MV	443
		Pico 162 MV	444
		voltConverter 230/400	445
Packing units			450



Multivolt machines - MV

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 machine			
		 230 V 400 V 480 V	 440 V 460 V 480 V
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	•	•

Name	Item no.	PG
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 M1
OW 440/460/480 Volt Equipment of machines 355/405/505 as well as 351/401/451/501/551 for 3x 440/460/480 V mains connection (only ex works)	 440 V 460 V 480 V	092-002647-00001 M1

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 Synergic FW	090-000179-00502	•	•
Tetrix 451 Synergic FW	090-000103-00502	•	•
Tetrix 551 Synergic FW	090-000093-00502	•	•
Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	•	•
Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	•	•
Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	•	•
Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	•	•
Tetrix 351 DC Smart 2.0 puls	090-000253-00502	•	•
Tetrix 401 DC Smart 2.0 puls	090-000254-00502	•	•
Tetrix 451 DC Smart 2.0 puls	090-000255-00502	•	•
Tetrix 551 DC Smart 2.0 puls	090-000256-00502	•	•
AC/DC TIG welding machines			
			
Tetrix 351 AC/DC Synergic FW	090-000109-00502	•	
Tetrix 451 AC/DC Synergic FW	090-000112-00502	•	•
Tetrix 551 AC/DC Synergic FW	090-000115-00502	•	•
Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	•	
Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	•	•
Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	•	•
Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	•	
Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	•	•
Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	•	•

Name	Item no.	PG
OW Multivolt 351/401/451/551 Multi-voltage (230 V/400 V/480 V) – factory fitting (no retrofitting)	092-002542-00001	M1
 230 V 400 V 480 V		
OW 440/460/480 Volt Equipment of machines 355/405/505 as well as 351/401/451/501/551 for 3x 440/460/480 V mains connection (only ex works)	092-002647-00001	M1
 440 V 460 V 480 V		

Multivolt machines - MV

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			
			 440 V 460 V 480 V
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			
			 440 V 460 V 480 V
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	•	•

Name	Item no.	PG
voltConverter 230/400 voltage converter ► May only be used with gas-cooled machines.		090-008800-00502 M1
OW 440/460/480 Volt Equipment of machines 355/405/505 as well as 351/401/451/501/551 for 3x 440/460/480 V mains connection (only ex works)	 440 V 460 V 480 V	092-002647-00001 M1

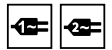
Mira 221 MV



M1.02



- 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 oration – setting of the welding voltage and wire-feed sed
- 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



Version	Mira 221 MV	Mira 221 MV 2 x 400 V
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	2 x 400 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	2 x 16 A
On circuit voltage	14.3 V	38.5 V
Setting range for welding current	30 A - 220 A	
Duty cycle 40 °C	220 A / 15 %	
	85 A / 100 %	
cos φ	0.98	
Dimensions machine, LxWxH in mm	888 x 379 x 604	
Weight, machine	56 kg	
Insulation class	H	
Approvals		
Wire sed m/min	1.5 m/min - 20 m/min	
Wire sed ipm	59.05 ipm - 787.4 ipm	

Ty	Designation	PU	Item no.			
		ve				
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG	1	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



Picotig DC



- Gas-cooled DC TIG inverter welding machine
- Multivolt (MV): Can be used worldwide thanks to automatic adjustment of mains voltage (115 V/230 V)
- Electronic HF start
- TIG lift arc welding without HF
- MMA pulse welding and pulsed TIG welding up to 2 kHz
- Non-latched/latched oration
- Reduced secondary current accessible using torch trigger
- Adjustable up-slo and down-slo time
- Adjustable gas pre- and post-flow time
- **MMA welding**
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Practical reduction of the orating elements down to the most important functions
- 3.5 m mains supply lead with 16 A shock-proof plug
- **Overtoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Version	Picotig 200 MV	
Mains voltage (tolerances)	1 x 115 V (-40 % - +15 %)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A	1 x 16 A
On 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 %	140 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions machine, LxWxH in mm	428 x 181 x 294	
Weight, machine	9.8 kg	
Insulation class	H	
Approvals	CE EAC S	

Ty	Designation	PU	Item no.			
		stk				
Picotig 200 MV puls TG	TIG multivolt inverter welding machine	1	090-002059-00502			

► Appropriate accessories see chapter DC TIG welding machines in the machine price list.

Tetrix 200 Comfort 2.0 puls MV



Comfort 2.0 DC



- Gas-cooled DC TIG inverter welding machine
- Multivolt (MV): Can be used worldwide thanks to automatic adjustment of mains voltage (115 V/230 V)
- **TIG welding**
 - Features characteristics for EWM activArc and EWM spotArc at no extra charge
 - Electronic HF start
 - TIG lift arc welding without HF
 - TIG average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as r welding procedure scification
 - Adjustable pulse frequency and balance
 - Non-latched/latched oration
 - Reduced secondary current accessible using torch trigger
 - Spot welding/tack function (spotArc/spotmatic)
 - Adjustable up-slo and down-slo time
 - Adjustable gas pre- and post-flow time
- **MMA welding**
 - MMA average value pulsing
 - Adjustable hot start current and hot start time
 - Adjustable Arcforce
 - Antistick function
- **Highlights**
 - Energy-saving thanks to high efficiency and standby function
 - Connection capability for remote control and function torch
 - 3.5 m mains supply lead with 16 A shock-proof plug
 - **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**



Version	Tetrix 200 MV	
Mains voltage (tolerances)	1 x 115 V (-15 % - +15 %)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A	1 x 16 A
On 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 %	140 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions machine, LxWxH in mm	428 x 181 x 294	
Weight, machine	10.8 kg	
Insulation class	H	
Approvals	CE EAC S	




Ty	Designation	PU	Item no.			
		stk				
Tetrix 200 DC MV Comfort 2.0 puls 5P	TIG multivolt inverter welding machine	1	090-000260-00502			

► Appropriate accessories see chapter DC TIG welding machines in the machine price list.

Pico 162 MV



- Inverter welding machine, DC, automatic mains voltage adaptation
- Multivolt (MV): Can be used worldwide thanks to automatic adjustment of mains voltage (115 V/230 V)
- **Welding procedures and functions**
 - MMA and TIG lift arc welding
 - Arcforce, hot start, antistick
 - Portable, shoulder strap
- **Your benefits**
 - Contents set: power source, aluminium- framed hard case, electrode holder, welding lead, welding shield, chipping hammer, steel brush
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Version	Input voltage: 230 V	Input voltage: 115 V
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
On circuit voltage	105 V	
Setting range for welding current	10 A - 150 A	
Duty cycle 40 °C	150 A / 35 %	110 A / 35 %
	120 A / 60 %	90 A / 60 %
	100 A / 100 %	80 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions machine, LxWxH in mm	360 x 116 x 224	
Weight, machine	5.4 kg	
Insulation class	H	
Approvals	  	

Ty	Designation	PU stk	Item no.			
Pico 162 MV	Multivolt MMA inverter welding machine	1	090-002042-00502			

► 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)	(-25 % - +20 %)
cos φ	0.99
Efficiency	90 %

Ty	Designation	PU	Item no.			
		stk				
voltConverter 230/400	Voltage converter	1	090-008800-00502			

► May only be used with gas-cooled machines.

Packing units

Picomig

Ty	Designation	PU ve	Item no.
6x Picomig 180 puls	Packing unit: 6 x Picomig 180 puls	1	092-015321-00502
6x Picomig 180 Synergic	Packing unit: 6 x Picomig 180 Synergic	1	092-015323-00502
Ty	Designation	PU ve	Item no.
6x Picomig 185 puls	Packing unit: 6 x Picomig 185 puls	1	092-015324-00502
6x Picomig 185 Synergic	Packing unit: 6 x Picomig 185 Synergic	1	092-015325-00502
Ty	Designation	PU ve	Item no.
6x Picomig 355 puls TKM	Packing unit: 6 x Picomig 355 puls	1	092-015327-00502
6x Picomig 355 Synergic TKM	Packing unit: 6 x Picomig 355 Synergic	1	092-015326-00502

Mira

Ty	Designation	PU ve	Item no.
2x Mira 151 FKG	Packing unit: 2 x Mira 151 FKG	1	092-015238-00502
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG	1	092-015239-00502
2x Mira 251 FKG	Packing unit: 2 x Mira 251 FKG	1	092-015240-00502
2x Mira 301 M1.02 FKG	Packing unit: 2 x Mira 301 M1.02 FKG	1	092-015236-00502
2x Mira 301 M2.20 FKG	Packing unit: 2 x Mira 301 M2.20 FKG	1	092-015263-00502
2x Mira 301 M2.40 FKG	Packing unit: 2 x Mira 301 M2.40 FKG	1	092-015237-00502
Ty	Designation	PU ve	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	1	092-015242-00502
2x Mira 151 FKG Set DK/FI/NL/NO/SE		1	092-015242-00540
2x Mira 151 FKG Set GB		1	092-015242-00537
2x Mira 151 FKG Set RU		1	092-015242-00508
Ty	Designation	PU ve	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	1	092-015243-00502
2x Mira 221 MV FKG Set DK/FI/NL/NO/SE		1	092-015243-00540
2x Mira 221 MV FKG Set GB		1	092-015243-00537
2x Mira 221 MV FKG Set RU		1	092-015243-00508
Ty	Designation	PU ve	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	1	092-015244-00502
2x Mira 251 FKG Set DK/FI/NL/NO/SE		1	092-015244-00540
2x Mira 251 FKG Set GB		1	092-015244-00537
2x Mira 251 FKG Set RU		1	092-015244-00508
Ty	Designation	PU ve	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	1	092-015245-00502
2x Mira 301 M1.02 FKG Set DK/FI/NL/NO/SE		1	092-015245-00540
2x Mira 301 M1.02 FKG Set GB		1	092-015245-00537
2x Mira 301 M1.02 FKG Set RU		1	092-015245-00508
2x Mira 301 M2.20 FKG Set D		1	092-015269-00502
2x Mira 301 M2.20 FKG Set DK/FI/NL/NO/SE		1	092-015269-00540
2x Mira 301 M2.20 FKG Set GB		1	092-015269-00537
2x Mira 301 M2.20 FKG Set RU		1	092-015269-00508
2x Mira 301 M2.40 FKG Set D		1	092-015246-00502
2x Mira 301 M2.40 FKG Set DK/FI/NL/NO/SE		1	092-015246-00540
2x Mira 301 M2.40 FKG Set GB	1	092-015246-00537	
2x Mira 301 M2.40 FKG Set RU	1	092-015246-00508	

Packing units

Picotig/Tetrix DC

Ty	Designation	PU ve	Item no.
8x Picotig 200 puls 5P	Packing unit: 8x Picotig 200 puls, without accessories	1	092-015276-00502
Ty	Designation	PU ve	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	1	092-015277-00502
6x Picotig 200 puls Set DK/FI/NL/NO/SE		1	092-015277-00540
6x Picotig 200 puls Set RU		1	092-015277-00508
6x Picotig 200 puls Set GB		1	092-015277-00537
6x Picotig 200 puls Set		1	092-015277-00539
Ty	Designation	PU stk	Item no.
8x Tetrix 200 DC Comfort MV 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC MV Comfort 2.0 puls, 5-pole connection socket	1	092-015335-00502
8x Tetrix 200 DC Comfort 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC Comfort 2.0 puls, 5-pole connection socket	1	092-015333-00502
8x Tetrix 200 DC Comfort 2.0 puls 8P	Packing unit: 8 pieces Tetrix 200 DC Comfort 2.0 puls, 8-pole connection socket	1	092-015333-00504
Ty	Designation	PU stk	Item no.
8x Tetrix 200 DC Smart 2.0 puls 5P	Packing unit: 8 pieces Tetrix 200 DC Smart 2.0 puls, 5-pole connection socket	1	092-015334-00502
8x Tetrix 200 DC Smart 2.0 puls 8P	Packing unit: 8 pieces Tetrix 200 DC Smart 2.0 puls, 8-pole connection socket	1	092-015334-00504
Ty	Designation	PU ve	Item no.
6x Tetrix 230 DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 230 DC Smart 2.0 puls, 5-pole connection socket	1	092-015328-00502 ve
6x Tetrix 230 DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 230 DC Smart 2.0 puls, 8-pole connection socket	1	092-015328-00504 ve
Ty	Designation	PU ve	Item no.
6x Tetrix 230 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 5-pole connection socket	1	092-015317-00502 ve
6x Tetrix 230 Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 8-pole connection socket	1	092-015317-00504 ve
Ty	Designation	PU ve	Item no.
6x Tetrix 300 DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 300 DC Smart 2.0 puls, 5-pole connection socket	1	092-015329-00502
6x Tetrix 300 DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 300 DC Smart 2.0 puls, 8-pole connection socket	1	092-015329-00504
Ty	Designation	PU ve	Item no.
6x Tetrix 300 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 300 Comfort 2.0 puls, 5-pole connection socket	1	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	1	092-015315-00504

Picotig/Tetrix AC/DC

Ty	Designation	PU ve	Item no.
6x Picotig 200 AC/DC puls 5P	Packing unit: 6x Picotig 200 AC/DC puls, 5-pole connection socket	1	092-002719-00502
6x Picotig 200 AC/DC puls 8P	Packing unit: 6x Picotig 200 AC/DC puls, 8-pole connection socket	1	092-002719-00504
Ty	Designation	PU ve	Item no.
6x Tetrix 230 AC/DC Smart 2.0 puls 5P TM	Packing unit: 6 Tetrix 230 AC/DC Smart 2.0 puls, 5-pole connection socket	1	092-015330-00502
6x Tetrix 230 AC/DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 230 AC/DC Smart 2.0 puls, 8-pole connection socket	1	092-015330-00504
Ty	Designation	PU ve	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	1	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	1	092-015318-00504
Ty	Designation	PU ve	Item no.
6x Tetrix 300 AC/DC Smart 2.0 puls 5P TM	Packing unit: 6 pieces Tetrix 300 AC/DC Smart 2.0 puls, 5-pole connection socket	1	092-015331-00502
6x Tetrix 300 AC/DC Smart 2.0 puls 8P TM	Packing unit: 6 Tetrix 300 AC/DC Smart 2.0 puls, 8-pole connection socket	1	092-015331-00504
Ty	Designation	PU ve	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	1	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	1	092-015316-00504

Packing units

Pico

Ty	Designation	PU	Item no.	
12x Pico 160	Packing unit: 12x Pico 160	1	092-015319-00502	ve
12x Pico 160 L-BOXX Set	Packing unit: 12 pieces Pico 160 L-BOXX Set	1	092-003411-00502	ve
Ty	Designation	PU	Item no.	
12x Pico 160 cel puls	Packing unit: 12x Pico 160 cel puls	1	092-015320-00502	ve
12x Pico 160 cel puls L-BOXX Set	Packing unit: 12 pieces Pico 160 cel puls L-BOXX Set	1	092-003412-00502	ve
12x Pico 160 cel puls VRD (AUS)	Packing unit: 12x Pico 160 cel puls VRD (AUS)	1	092-015320-28503	ve
12x Pico 160 cel puls VRD (RU)	Packing unit: 12x Pico 160 cel puls VRD (RU)	1	092-015320-28504	ve
Ty	Designation	PU	Item no.	
12x Pico162 MV	Packing unit: 12 x Pico 162 MV	1	092-002058-00502	ve
Ty	Designation	PU	Item no.	
8x Pico180	Packing unit: 8 x Pico 180 puls	1	092-015235-00502	ve
8x Pico 180 puls VRD (AUS)	Packing unit: 8 x Pico 180 puls VRD (AUS)	1	092-015248-00502	ve
8x Pico 180 puls VRD (RU)	Packing unit: 8 x Pico 180 puls VRD (RU)	1	092-015248-00503	ve
Ty	Designation	PU	Item no.	
8x Pico 220 cel puls	Packing unit: 8x Pico 220 cel puls	1	092-015280-00502	
Ty	Designation	PU	Item no.	
6x Pico 300 CEL	Packing unit: 6x Pico 300 cel	1	092-002298-00502	
6x Pico 300 cel svrd 12V	Packing unit: 6x Pico 300 cel SVRD	1	092-002298-00504	
6x Pico 300 cel vrd 12V	Packing unit: 6x Pico 300 cel VRD	1	092-002298-00503	
Ty	Designation	PU	Item no.	
6x Pico 350 cel puls	Packing unit: 6 x Pico 350 cel puls	1	092-015284-00502	
6x Pico 350 cel puls vrd (RU)	Packing unit: 6 x Pico 350 cel puls VRD (RU)	1	092-015284-28504	
6x Pico 350 cel puls vrd (AUS)	Packing unit: 6 x Pico 350 cel puls VRD (AUS)	1	092-015284-28503	
Ty	Designation	PU	Item no.	
6x Pico 350 cel puls pws	Packing unit: 6 x Pico 350 cel puls pole reversing switch	1	092-015285-00502	
6x Pico 350 cel puls pws vrd (RU)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (RU)	1	092-015285-28504	
6x Pico 350 cel puls pws vrd (AUS)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (AUS)	1	092-015285-28503	

Cooling units

Ty	Designation	PU	Item no.			
		ve				
6x cool35 U31	Packing unit: 6 x cool35 U31	1	092-015295-00502	ve		
Ty	Designation	PU	Item no.			
		ve				
6x cool40 U31	Packing unit: 6 x cool40 U31	1	092-015283-00502	ve		
Ty	Designation	PU	Item no.			
		ve				
6x cool41 U31	Packing unit: 6 cool41 U31	1	092-015291-00502	ve		
Ty	Designation	PU	Item no.			
		ve				
6x cool50 U40	Packing unit: 6 x cool50 U40	1	092-015332-00502	ve		

Transport cart

Ty	Designation	PU	Item no.			
		ve				
6x Trolley 35.2-2	Packing unit: 6 Trolley 35.2-2	1	092-015282-00000	ve		

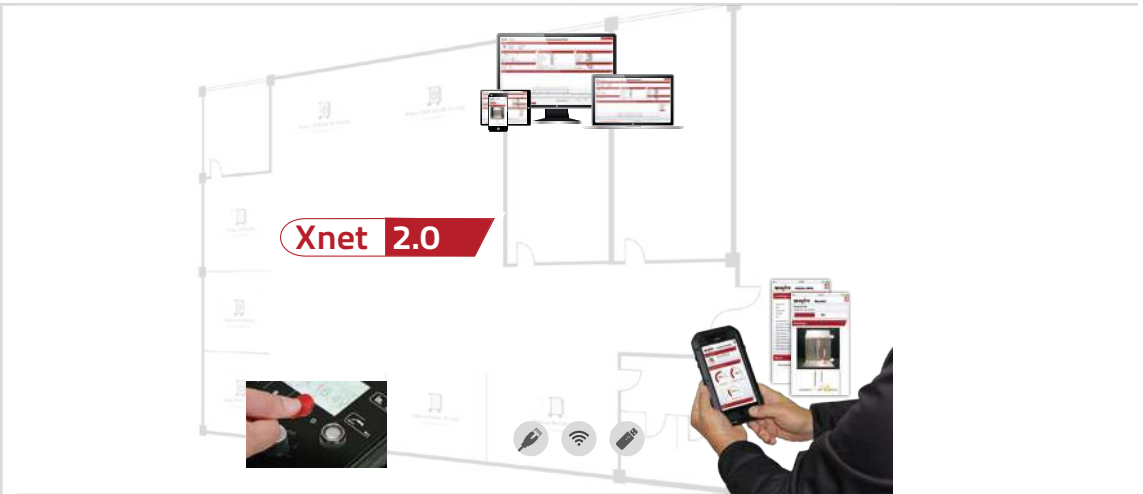
Overview Xnet 2.0 system and software

Accessories		Page	
Xnet 2.0 system and software		Xnet software 2.0	458
	Step 1 – Xnet software configuration	WPQ-X Manager (Urade 1)	458
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Structure of an Xnet system

Step 1 Configuring the software according to customer requirements

From Page 462



Step 2 Configuring the hardware according to customer requirements

A) – Xnet configuration for Titan XQ puls welding machines from Page 464:



B) – Xnet retrofitting for all EWM welding machines with 7-pole digital interface from Page 465



Step 3 Defining the number of machine usage licences

From Page 466



Not required, machine licences are included in the Xnet-retrofitting sets

Step 4 Commissioning and training by EWM

From Page 466

Step 1: Xnet configuration

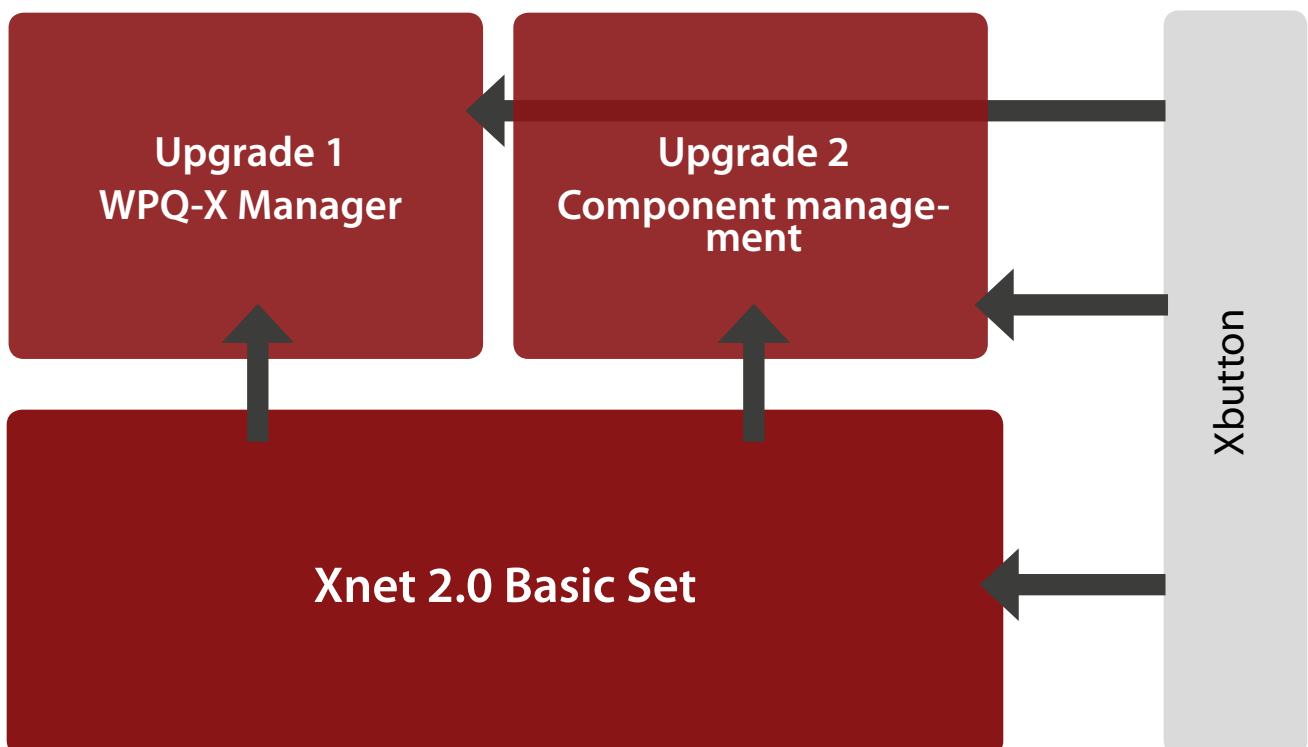
Build your own digital quality assurance

The Welding 4.0 quality management system ewm Xnet was specifically developed for welding production and effectively supports all the employees involved in the welding process (welding coordinator, welder, production manager, manager, etc.).





Thanks to the modular structure, the Xnet welding management system can be used in small, medium and large companies.



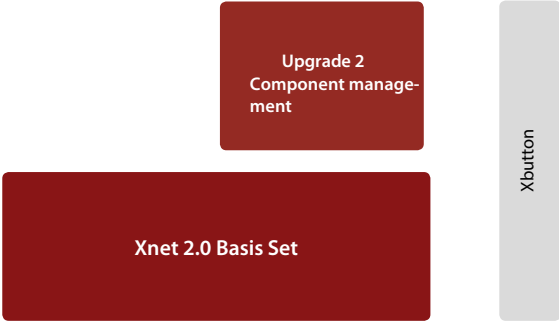
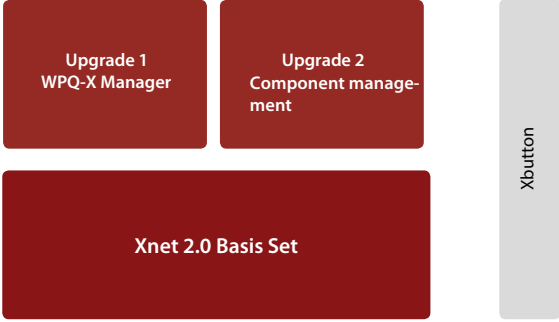
The spectrum of performance of ewm Xnet provides you with a variety of options for optimising your production:

- Monitoring and the documentation of all welding parameters from any number of networked welding machines.
- Digital generation and management of the welding documentation (WPQR, WPS, welding certificates)
- Numerous evaluation options
- Management of components including all the information associated with it, such as component identification via bar code, material consumption, welding parameters, etc.
- Identification and permission management on the welding machine with Xbutton



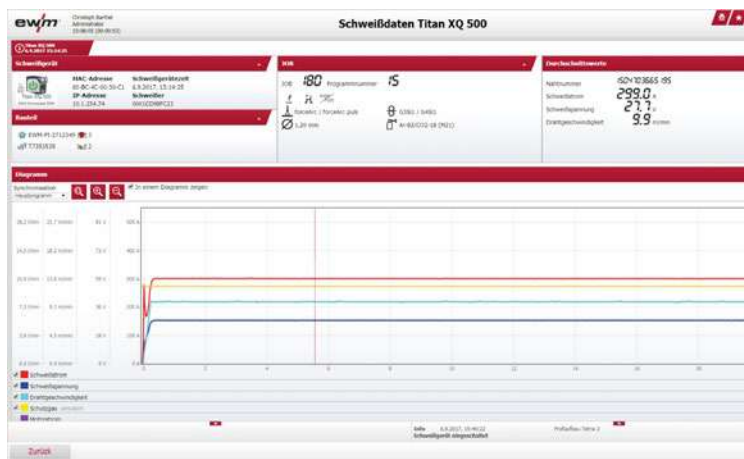
Xnet software – combination options

 <p>Xnet 2.0 Basis Set</p>	<ul style="list-style-type: none"> ● Machines/machine status visible via the network ● Monitoring of welding parameters in real time ● Recording of welding data ● Welding machine maintenance ● Scanning of bar codes ● Costs and consumption per bar code ● Analysis of welding efficiency ● Calculation of consumption ● Display of the most important information on the dashboard
 <p>Upgrade 1 WPQ-X Manager</p> <p>Xnet 2.0 Basis Set</p>	<p>In addition to the Basic Set functions:</p> <ul style="list-style-type: none"> ● Easy, quick creation and management of WPQR and pWPS/WPS ● Transmission of recorded data directly in a pWPS/WPS ● Management of welders and welder qualifications ● Reminder in case confirmation/extension of welder qualification is due
 <p>Upgrade 2 Component manage- ment</p> <p>Xnet 2.0 Basis Set</p>	<p>In addition to the Basic Set functions:</p> <ul style="list-style-type: none"> ● Creation of components with image, drawing or welding sequence etc. ● Identification of the components via bar code ● Allocation of recorded welding data, consumption, costs for each scanned component
 <p>Upgrade 1 WPQ-X Manager</p> <p>Upgrade 2 Component manage- ment</p> <p>Xnet 2.0 Basis Set</p>	<p>In addition to the Basic Set functions:</p> <ul style="list-style-type: none"> ● Easy, quick creation and management of WPQR and pWPS/WPS ● Transmission of recorded data directly in a pWPS/WPS ● Management of welders and welder qualifications ● Reminder in case confirmation/extension of welder qualification is due ● Creation of components with image, drawing or welding sequence etc. ● Identification of components via bar code ● Allocation of recorded welding data, consumption, costs for each scanned component ● Transferring the welding parameters into the welding machine (in component mode and in conjunction with WPQ-X Manager) (only with Titan XQ) ● Evaluation of the efficiency, consumption and costs per component or working time interval

<ul style="list-style-type: none"> ● Identification of the person on the welding machine ● Access authorisation to the welding machine via programmed Xbuttons (with Expert 2.0 control variants) 	<p>Additional uses with Xbutton</p>  <p>The diagram shows a dark red rectangular box labeled "Xnet 2.0 Basis Set" positioned to the left of a vertical grey bar labeled "Xbutton".</p>
<ul style="list-style-type: none"> ● Identification of the person on the welding machine ● Access authorisation to the welding machine via programmed Xbuttons (with Expert 2.0 control variants) 	<p>Additional uses with Xbutton</p>  <p>The diagram shows two dark red rectangular boxes. The top one is labeled "Upgrade 1 WPQ-X Manager" and is positioned above a larger dark red rectangular box labeled "Xnet 2.0 Basis Set". To the right of these boxes is a vertical grey bar labeled "Xbutton".</p>
<ul style="list-style-type: none"> ● Identification of the person on the welding machine ● Access authorisation to the welding machine via programmed Xbuttons (with Expert 2.0 control variants) ● Allocation of the components welded by the welder 	<p>Additional uses with Xbutton</p>  <p>The diagram shows two dark red rectangular boxes. The top one is labeled "Upgrade 2 Component management" and is positioned above a larger dark red rectangular box labeled "Xnet 2.0 Basis Set". To the right of these boxes is a vertical grey bar labeled "Xbutton".</p>
<ul style="list-style-type: none"> ● Identification of the person on the welding machine ● Access authorisation to the welding machine via programmed Xbuttons (with Expert 2.0 control variants) ● Allocation of the components welded by the welder ● Evaluation of the efficiency, consumption and costs per component, welder or working time interval 	<p>Additional uses with Xbutton</p>  <p>The diagram shows three dark red rectangular boxes. Two are positioned side-by-side at the top: "Upgrade 1 WPQ-X Manager" on the left and "Upgrade 2 Component management" on the right. Below them is a larger dark red rectangular box labeled "Xnet 2.0 Basis Set". To the right of these boxes is a vertical grey bar labeled "Xbutton".</p>

Step 1 • Xnet software configuration

Xnet software 2.0



Software product for quality assurance in welding production

- Xnet 2.0 basic set consisting of USB dongle with serial number, installation file and software usage licence
- **Range of functions:**
 - Machines/machine status visible via the network
 - Monitoring of the welding parameters in real time
 - Recording of the welding data
 - Welding machine maintenance
 - Scanning of barcodes
 - Costs and consumption r barcode
 - Analysis of the welding efficiency
 - Calculation of the consumption for one or more machines
 - Display of the most important information on the dashboard
- **The following must be observed:**
 - Availability of network infrastructure and necessary network communication must be checked
 - System requirements as r Xnet data sheet
 - Number of machine usage licences according to customer requirement

Designation	PU	Item no.			
	stk				
Xnet 2.0 basic set consisting of USB dongle with serial number, installation file and software usage licence	1	091-008836-00000			
Software urade from Xnet 1.x to Xnet 2.0	1	090-008838-00000			

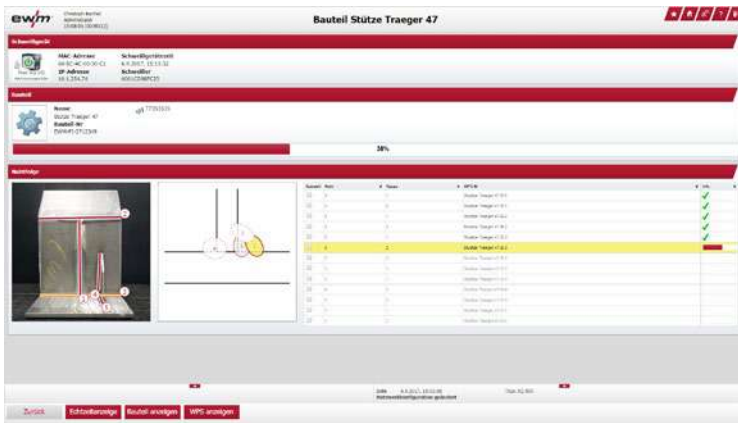
WPQ-X Manager (Urade 1)

Easy, quick creation and management of a database by WPQR and pWPS/WPS in the network

- Direct creation of a pWPS/WPS in the network of the welding data recorded with Xnet
- Creation and management of a database for welder and welder qualification in the network
- Reminder in case of due confirmation/extension of welder qualification
- Xnet 2.0 basic set is the prerequisite for using the WPQ-X Manager

Designation	PU	Item no.			
	stk				
Xnet software module for WPS creation and management	1	090-008814-00000			

Component management (urade 2)



Creation of components e.g. with image, drawing or welding sequence

- Allocation of WPS, monitoring profile, length for each weld seam in the welding sequence
- Identification of the components before the welding using barcode (in conjunction with a barcode scanner connected to the machine)
- Transferring of the welding parameters in the welding machine (in component mode and in conjunction with WPQ-X Manager)
- Allocation of recorded welding data, consumption, costs for each scanned component

Designation	PU	Item no.			
	stk				
Component management (urade 2)	1	090-008816-00000			

Xbutton



EWM Xbutton set consisting of:

- USB dongle
- Software usage licence
- Programming box incl. USB cable
- 10 pcs. of authentication keys (Xbuttons) + 1 programming key
- **Range of functions without integration in an Xnet system:**
 - Identification of the welder at welding machine
 - Managing rmissions for the welder at welding machine
 - Qualification of the welder on the key
- **Additional range of functions with integration in an Xnet system:**
 - Allocating the welder to a component or a weld seam
 - Checking the validity of the welder's qualification while logging in at the machine

Designation	Colour	PU	Item no.		
		stk			
Authentication set: Programming box incl. cable, software key, dongle, 10 Xbuttons, 1 programming button	Miscellaneous	1	092-002911-00000		
Authentication key		1	092-002912-00000		
Authentication key 5+1 (6 for the price of 5)	Black	1	092-002912-00005		
Authentication key 10+3 (13 for the price of 10)		1	092-002912-00010		
Authentication key		1	092-002913-00000		
Authentication key 5+1 (6 for the price of 5)	Red	1	092-002913-00005		
Authentication key 10+3 (13 for the price of 10)		1	092-002913-00010		
Authentication key		1	092-002914-00000		
Authentication key 5+1 (6 for the price of 5)	Green	1	092-002914-00005		
Authentication key 10+3 (13 for the price of 10)		1	092-002914-00010		
Authentication key		1	092-002915-00000		
Authentication key 5+1 (6 for the price of 5)	Yellow	1	092-002915-00005		
Authentication key 10+3 (13 for the price of 10)		1	092-002915-00010		
Authentication key		1	092-002916-00000		
Authentication key 5+1 (6 for the price of 5)	Blue	1	092-002916-00005		
Authentication key 10+3 (13 for the price of 10)		1	092-002916-00010		

Step 2 A) • Xnet hardware configuration
For Titan XQ puls welding machines



Exrt XQ 2.0 control with LAN gateway for connecting to ewm Xnet

- Intuitive user guidance on LCD panel and through plain text display of all welding parameters and functions
- Data transfer via network cable
- USB interface for data recording and data transfer
- Registration option via Xbutton
- Digital display with oration using click wheel
- Display of the following information in addition to the Exrt 2.0 control functions: network status, network configuration, Xnet monitoring of the welding parameters in real time, component information, errors and warnings in the system
- **For using it, an Xnet-machine licence is required**

Designation	PU	Item no.			
Exrt XQ 2.0 with LAN gateway	stk				
	1	092-003308-00000			



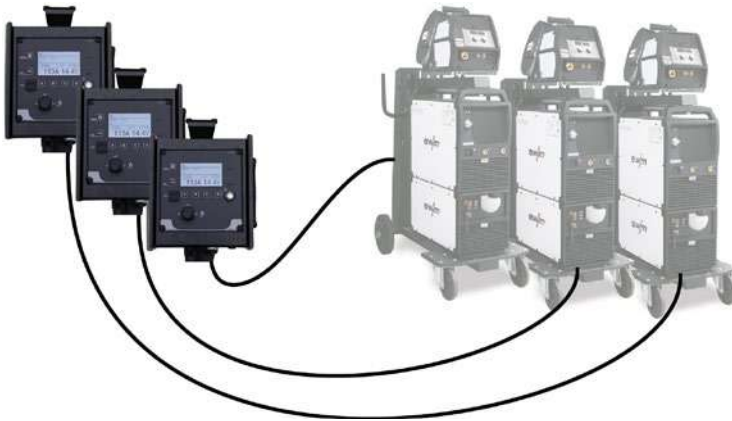
Exrt XQ 2.0 control with LAN/WiFi gateway for connecting to ewm Xnet

- Intuitive user guidance on LCD panel and through plain text display of all welding parameters and functions
- Data transfer via WiFi or network cable
- USB interface for data recording and data transfer
- Registration option via Xbutton
- Digital display with oration using click wheel
- Display of the following information in addition to the Exrt 2.0 control functions: network status, network configuration, Xnet monitoring of the welding parameters in real time, component information, errors and warnings in the system
- **For using it, an Xnet-machine licence is required**

Designation	PU	Item no.			
Exrt XQ 2.0 with LAN/WiFi gateway	stk				
	1	092-003309-00000			

Step 2 B) • Hardware configuration

Xnet retrofitting for all EWM welding machines with 7-pole, digital interface



Xnet retrofitting set for LAN consisting of:

- An Xnet LAN gateway in a robust industry-compatible casing
- A machine usage licence
- A network cable (10 m)
- A 7-pole connection cable (5 m)
- **Range of functions:**
 - Connecting welding machines without integrated Xnet components to an Xnet system (for all EWM machines with integrated 7-pole interface)
 - Data transfer via network cable
 - USB interface for data recording and data transfer
 - Connection of a barcode scanner possible
 - Registration option via Xbutton
 - Digital display with oration using click wheel
 - Showing the following information on the display: network status, network configuration, nominal/actual welding parameters, JOB information, Xnet monitoring of the welding parameters in real time, WPQR welding data assistant, component information, errors and warnings in the system
- **We offer bulk prices, use the price advantage**

Designation	from	PU stk	Item no.			
Xnet retrofitting set LAN: One machine licence, one LAN gateway, one network cable (10 m), one 7-pole connection cable (5 m), including connection for barcode scanner	1.0	1	091-008833-00001			
	5.0	1	091-008833-00001			
	10.0	1	091-008833-00001			
	20.0	1	091-008833-00001			



Xnet retrofitting set for WiFi consisting of:

- An Xnet WiFi gateway in a robust industry-compatible casing
- A machine usage licence
- A 7-pole connection cable (5 m)
- **Range of functions:**
 - Connecting welding machines without integrated Xnet components to an Xnet system (for all EWM machines with integrated 7-pole interface)
 - Data transfer via WiFi or network cable
 - USB interface for data recording and data transfer
 - Connection of a barcode scanner possible
 - Registration option via Xbutton
 - Digital display with oration using click wheel
 - Showing the following information on the display: network status, network configuration, nominal/actual welding parameters, JOB information, Xnet monitoring of the welding parameters in real time, WPQR welding data assistant, component information, errors and warnings in the system
- **We offer bulk prices, use the price advantage**

Designation	from	PU stk	Item no.			
Set: One machine licence, one Wi-Fi gateway, one 7-pole connection cable (5 m)	1.0	1	091-008834-00001			
	5.0	1	091-008834-00001			
	10.0	1	091-008834-00001			
	20.0	1	091-008834-00001			

Step 3 • Defining the machine usage licences

Xnet machine usage licences



- Xnet machine usage licences
- Not included if Xnet retrofitting set LAN (091-008833-0000x) and Xnet retrofitting set WiFi (091-008834-0000x) are being used
- The number of available machine usage licences determines the maximum number of welding machines which can be active in Xnet at the same time
- A machine usage licence is valid for each machine, but is not linked to a scific machine
- For unlimited riord
- **We offer bulk prices, use the price advantage**

Designation	from	PU stk	Item no.			
Xnet machine licence	1.0	1	090-008787-LIZ01			
	5.0	1	090-008787-LIZ01			
	10.0	1	090-008787-LIZ01			
	20.0	1	090-008787-LIZ01			

Step 4 • Commissioning and training by EWM

Services



- The main goal of the workshop is to be able to use the full extent of Xnet and for participants to be able to determine the potential for their own companies. Participants must recognise the advantages of using the system in their daily work. At the same time, customer suggestions for future updates are noted and identified. The workshop forms the basis of implementation of the Xnet system in the ongoing welding production process. To sum up, the workshop, along with the EWM exrts, helps to recognise daily benefits, reduce costs and increase the day-to-day efficiency. The result of the decision will prove the correctness of your decision and on up new possibilities for cooration with EWM.

Designation	PU	Item no.			
Xnet workshop „Working efficiently with Xnet“	1	KOS-V00076-00000			
Hourly rate for installation and commissioning of the Xnet system	1	KOS-V00028-00000			

Order placement guide Xnet

x = absolutely necessary

Selection	Name	Note	Item no.	PG	
Step 1 – Xnet software configuration:					
x	Xnet 2.0 basic set consisting of USB dongle with serial number, installation file and software usage licence		091-008836-00000	D4	
<input type="radio"/>	WPQ-X Manager (Upgrade 1 – only with Xnet 2.0 Basic Set)		090-008814-00000	D4	
<input type="radio"/>	Component management (Upgrade 2 – only together with Xnet 2.0 Basic Set)		090-008816-00000	D4	
<input type="radio"/>	Authentication set: Programming box incl. cable, software key, dongle, 10 Xbuttons, 1 programming button	Individual Xbuttons can be found on Page 463	092-002911-00000	D4	
Step 2 A – Xnet configuration for Titan XQ puls					
<input type="radio"/>	Expert XQ 2.0 with LAN gateway	including connection for	092-003308-00000	D4	
<input type="radio"/>	Expert XQ 2.0 with LAN/Wi-Fi gateway	barcode scanner	092-003309-00000	D4	
Step 2 B – Xnet retrofitting for all EWM welding machines with 7-pole digital interface					
<input type="radio"/>	Xnet retrofitting set LAN: One machine licence, one LAN gateway, one network cable (10 m), one 7-pole connection cable (5 m), including connection for barcode scanner	Suitable for Titan XQ puls, Phoenix puls, Taurus Synergic S, Tatrix, Microplasma	091-008833-00001	D4	
<input type="radio"/>	Xnet retrofitting set WiFi: One machine licence, one WiFi gateway, one 7-pole connection cable (5 m), including connection for barcode scanner	Bulk prices available	091-008834-00001	D4	
Step 3 – Defining the number of machine usage licences					
<input type="radio"/>	Xnet machine usage licence	Included in all retrofitting sets Bulk prices available	090-008787-LIZ01	D4	
Step 4 – Commissioning and training by EWM					
<input type="radio"/>	Per-hour rate, installation and commissioning	Absolutely essential for all EWM locations and sales partners without Key User certification	KOS-V00028-00000	N1	
<input type="radio"/>	Customer workshop “Working efficiently with Xnet”		KOS-V00076-00000	N1	
Accessories					
	See the following pages				

Xnet accessories

Xnet Plug and Play Set



- The Xnet Plug and Play Set allows smooth and easy commissioning and use. It is thus the perfect solution for a rapid, order-based documentation of welding parameters with a power source. With the Xnet 2.0 Basic Set already installed, welding data can be recorded and an efficiency analysis can be generated.
- With the pre-configured PC and Gateway, the system can be connected with just a few steps through plug-and-play. The precondition is a welding machine with 7-pole interface without fixed integrated Xnet components.

● **Contents:**

- Laptop PC with pre-installed Xnet software (Xnet 2.0 basic set)
- USB dongle with software usage licence and one machine usage licence, Xnet basic set
- Xnet LAN gateway
- Cable (7-pole, LAN network)
- Plastic trunk with Trolley

Designation	PU	Item no.			
	stk				
Xnet Plug and Play Set	1	092-003342-00000			

Xnet LAN Gateway



- Xnet LAN gateway
- **Range of functions:**
- Connecting welding machines without integrated Xnet components to an Xnet system (for all EWM machines with integrated 7-pole interface)
- Data transfer via network cable
- USB interface for data recording and data transfer
- Connection of a barcode scanner possible
- Registration option via Xbutton
- Digital display with operation using click wheel
- **Showing the following information on the display:**
- network status, network configuration, nominal/actual welding parameters, JOB information, Xnet monitoring of the welding parameters in real time, WPQR welding data assistant, component information, errors and warnings in the system

● **For using it, an Xnet-machine licence is required**

Designation	from	PU	Item no.			
		stk				
LAN gateway in external housing	1.0	1	090-008833-00502			
	5.0	1	090-008833-00502			
	10.0	1	090-008833-00502			
	20.0	1	090-008833-00502			

Xnet WiFi Gateway



- Xnet WiFi gateway
- **Range of functions:**
- Connecting welding machines without integrated Xnet components to an Xnet system (for all EWM machines with integrated 7-pole interface)
- Data transfer via WiFi or network cable
- USB interface for data recording and data transfer
- Connection of a barcode scanner possible
- Registration option via Xbutton
- Digital display with oration using click wheel
- **Showing the following information on the display:**
- network status, network configuration, nominal/actual welding parameters, JOB information, Xnet monitoring of the welding parameters in real time, WPQR welding data assistant, component information, errors and warnings in the system
- **For using it, an Xnet-machine licence is required**

Designation	from	PU	Item no.			
		stk				
	1.0	1	090-008834-00502			
WiFi gateway in external casing	5.0	1	090-008834-00502			
	10.0	1	090-008834-00502			
	20.0	1	090-008834-00502			

Barcode scanner



- Barcode scanner
- For component management in conjunction with Xnet 2.0 software
- Optional OW 8-pole scanner (092-003372-00000) required on the machine side
- Scanner function only in conjunction with Xnet 2.0 for Titan XQ-welding machines with integrated Exrt 2.0 XQ and for welding machines with connected LAN or WiFi Gateway
- Scanner holder only suitable for Titan XQ welding machines

Designation	PU	Item no.			
	stk				
Barcode scanner	1	090-008823-00000			
Scanner holder, left	1	092-003434-00000			

Digital 7-pole cable



- Digital 7-pole cable
- Extension for 7-pole remote control with rmanently installed cable
- Connection cable for remote control and gateway without rmanently installed cable

Connection	7-pole
------------	--------

Designation	Cable length	PU	Item no.			
	m					
	0.5	1	092-000201-00004			
	1.0	1	092-000201-00002			
	5.0	1	092-000201-00003			
Digital 7-pole cable	10.0	1	092-000201-00000			
	15.0	1	092-000201-00005			
	20.0	1	092-000201-00001			
	25	1	092-000201-00007			

Xnet accessories

Network cable



Length					10
Designation	PU	Item no.			
	stk				
Network cable	1	094-020672-00000			


Industrial USB flash drive

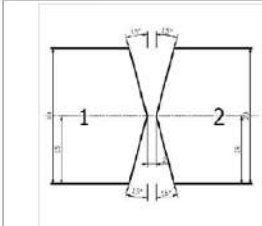
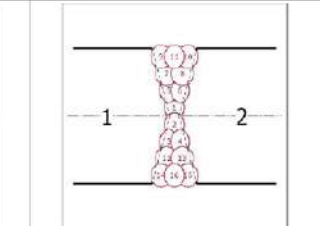


- Extremely process-stable industrial USB flash drive for use in rough environments

Designation	PU	Item no.			
	stk				
Extremely process-stable industrial USB flash drive	1	094-021748-00000			

WPQ Manager single-station solution

ewm		Schweißanweisung (WPS)		WPS-Nr.	Rev.	Seite 1. 1
				000		
						
Hersteller	EWM AG	Schweißnaht	Schweißnaht			
SozSt	Fluss 1	Schweißgeschwindigkeit	minimale Schweißgeschwindigkeit			
GA	Typ	Art der Vorbehandlung und Aufbereitung	P0000			
WPQR Nr.	01 202 044-020000-00-017	Beibehaltung der Wurdfolge	nein			
Prüfer oder Prüfstelle	Prüfstelle	Schweißnaht Geschwindigkeit 1	0366 JR			
		Schweißnaht Geschwindigkeit 2	0366 JR			
		Werkstoffklasse 1 [mm]	00			
		Werkstoffklasse 2 [mm]	00			
		Außendurchmesser [mm]	0			
		Schweißposition	PS			
		Blattfolge/Blattreihenfolge	Recht / Links			

Schweißnahtkonstante	Schweißfolge
	

WPQR-Nr.	Prüfstelle	Fluss	WPS	Schweißgeschwindigkeit [mm]	Strom [A]	Spannung [V]	Werkstoffklasse / Prüfung	Werkstoffklasse / Prüfung	Schweißgeschwindigkeit	Werkstoffklasse / Prüfung
01 202 044-020000-00-017	Fluss 1	Fluss 1	000	0,2	70-110	20-30	SPR001bogen (E)	SPR001bogen (E)	0,2	0,275
01 202 044-020000-00-017	Fluss 1	Fluss 1	000	1,2	210-230	20-31	SPR001bogen (E)	SPR001bogen (E)	1,2	1,620

Bezeichnung	Materialname	Materialnr.	Schweißnahttyp	Schweißnahttyp	Zeit [h]	Temperatur [°C]
1.05 0.01 #1150 1634 L.A. - G42 1.ME 1.010 795 65			Fluss	Fluss		

Easy, quick creation and management of a database by WPQR and pWPS/WPS on a local PC

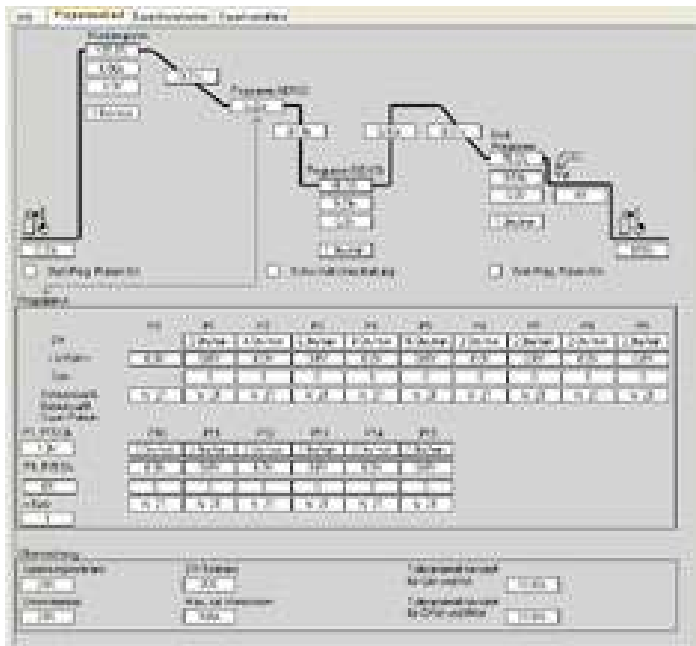
- Direct creation of a pWPS/WPS from welding data recorded with Xnet
- Creation and management of a database for welder and welder qualification **on a local PC**
- Reminder in case of due confirmation/extension of welder qualification
- **The WPQ Manager cannot be readily used in combination with Xnet products**

Designation

WPQ Manager: Software for creation and management of welding documentation and welder qualification on a local PC

PU	Item no.			
stk				
1	090-008813-00000			

PC-software • PC300 XQ Set



Welding parameter software

- Windows interface makes oration straightforward
- Structured orating menus and levels for changing, setting and programming all welding parameters
- Management of up to 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 mapd directly to the welding process (ideal for training and test welding purposes)
- Integrated password protection to protect against unauthorised changes
- Connection to a standard serial COM interface on the welding machine
- 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 oration, 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 ntium (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

Designation	PU	Item no.			
PC300 XQ welding parameter software set, including CMSTICK, cable and SECINT X10 USB interface	stk	090-008777-00000			

Overview welding accessories

Accessories			Page		
Welding machine accessories	General accessories	Transport carts	Trolly 35-1	470	
			Trolly 35.2-2	471	
			Trolly 35-6	472	
			Trolly 38-2 E	472	
			Trolly 55-5	473	
			Trolly 55-6	474	
		Welding accessories	Welding leads	477	
			Electrode holders	485	
			Pressure regulators	489	
		Accessories	General accessories	Gouging	491
				Spare parts set	492
Test machine for retention test	498				
Calibration device	499				
Services	Welding simulation	Welding Trainer Soldamatic	500		
			502		
			507		

Transport cart - Trolley series

Trolley 35-1



- Transport cart
- Solid, stable design
- 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

Designation	PU	Item no.			
	stk				
Trolley for power source, 10 l – 33 l shielding gas cylinder	1	090-008629-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 180 puls	090-002003-00502	423	Picotig 200 puls TG	090-002058-00502	346
Pico 220 cel puls	090-002057-00502	424	Picotig 200 MV puls TG	090-002059-00502	346
Picomig 180 puls TKG Set	091-005545-00502	225	Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353
Picomig 180 puls TKG	090-005545-00502	224	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Picomig 180 Synergic Set	091-005546-00502	227	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Picomig 180 Synergic TKG	090-005546-00502	226	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353

Trolley 35.2-2



- Transport cart
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder
- In case of use with machines of the Picomig 185/355 TKM, Phoenix 355 TKM and Taurus 355 TKM series, **no** additional cooling unit can be installed on the Trolley
- Can be lifted by crane (option ON CS Trolley 35.2-2 required)

Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Designation	PU	Item no.
Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008296-00000
Packing unit: 6 Trolley 35.2-2	1	092-015282-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Picomig 355 Synergic TKM	090-005512-00502	235	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Taurus 355 Basic TKM	090-005406-00502	196	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Taurus 355 Synergic S LP MM TKM	090-005421-00502	128	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Taurus 355 Synergic S HP MM TKM	090-005407-00502	128	Tetrix 300 Comfort TM	090-000099-00502	362
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 300 Smart TM	090-000125-00502	362

ON CS Trolley 35.2-2



- Suspension for instant, easy crane transportation of welding machine and Trolley

Designation	PU	Item no.
Crane susnsion for Trolley 35.2-2	1	092-002931-00000

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Trolley 35.2-2	090-008296-00000	471	6x Trolley 35.2-2	092-015282-00000	451

Transport cart - Trolley series

Trolley 35-6



- Transport cart
- Best suited to particularly uneven areas
- Housing for a power source and a wire feeder
- Solid, stable design

Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Designation	PU	Item no.			
	stk				
Transport cart for a power source with a wire feeder	1	090-008827-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 505 Basic S	090-005601-00502	181
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 505 Progress puls MM TDM	090-005322-00502	100			
Taurus 405 Basic S	090-005591-00502	180			
Taurus 355 Basic TDM	090-005286-00502	198			
Taurus 355 Synergic S MM TDM	090-005336-00502	130			

Trolley 38-2 E



- Transport cart
- 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

Designation	PU	Item no.			
	stk				
Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008270-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355	Tetrix 300 Comfort TM	090-000099-00502	362
Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369	Tetrix 300 Smart TM	090-000125-00502	362

Trolley 55-5_



- Transport cart
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder

Trolley dimensions L x W x H in mm	1068 x 540 x 1150
Trolley weight	35 kg

Designation	PU	Item no.			
	stk				
Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, mounted	1	090-008632-00000			
Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder, dismantled	1	090-008632-00001			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 505 Basic S	090-005601-00502	181
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Picomig 355 Synergic TKM	090-005512-00502	235	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Taurus 405 Basic S	090-005591-00502	180	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Taurus 355 Basic TDM	090-005286-00502	198	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Taurus 355 Basic TKM	090-005406-00502	196	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Taurus 355 Synergic S LP MM TKM	090-005421-00502	128	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Taurus 355 Synergic S MM TDM	090-005336-00502	130	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Taurus 355 Synergic S HP MM TKM	090-005407-00502	128	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357

Transport cart - Trolley series

Trolley 55-6



- Transport cart
- Solid, stable design
- For transporting a power source, a cooling unit and one or two shielding gas cylinders
- Can be lifted by crane as standard
- Supplied with roll brakes

Trolley dimensions L x W x H in mm	1114 x 684 x 1160
Trolley weight	35 kg

Designation	PU	Item no.			
	stk				
Trolley for power source, 1 module, 10 l-50 l shielding gas cylinder	1	090-008825-00000			
Transport cart for a power source, cooling unit and two shielding gas cylinders	1	090-008826-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Microplasma 25	090-007027-00502	390	Taurus 405 Basic TDM	090-005241-00502	199
Microplasma 55	090-007028-00502	390	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 505 Basic S	090-005601-00502	181
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Picomig 355 Synergic TKM	090-005512-00502	235	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Taurus 405 Basic S	090-005591-00502	180	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Taurus 355 Basic TDM	090-005286-00502	198	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Taurus 355 Basic TKM	090-005406-00502	196	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Taurus 355 Synergic S LP MM TKM	090-005421-00502	128	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Taurus 355 Synergic S MM TDM	090-005336-00502	130			

ON Extender



- Extension for Trolley 55-6 for holding another module
- Thus, for example, a power source, a water block and a toolbox can be fitted on the Trolley

Designation	PU	Item no.			
	stk				
Extension for Trolley 55-6 to house a further module	1	092-003507-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Trolley 55-6 DF	090-008826-00000	474	Trolley 55-6	090-008825-00000	474

ON Case



- Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6
- All tools and replacement parts always to hand.
- Only available in conjunction with Trolley 55-5 without an additional cooling unit
- In conjunction with Trolley 55-6, if using a cooling unit, the option "ON Extender" must also be ordered

Designation	PU	Item no.			
	stk				
Tool box for mounting to transport cart Trolley 55-5/Trolley 55-6	1	092-002899-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Taurus 405 Basic S	090-005591-00502	180
Microplasma 25	090-007027-00502	390	Taurus 355 Basic TDM	090-005286-00502	198
Microplasma 55	090-007028-00502	390	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Taurus 505 Basic S	090-005601-00502	181
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Trolley 55-5	090-008632-00000	473
Picomig 185 puls TKG	090-005547-00502	229	Trolley 55-5 DM	090-008632-00001	473
Picomig 185 Synergic TKG	090-005548-00502	231	Trolley 55-6 DF	090-008826-00000	474
Picomig 355 puls TKM	090-005542-00502	233	Trolley 55-6	090-008825-00000	474
Picomig 355 Synergic TKM	090-005512-00502	235			

ON TR Trolley 55-5 / 55-6



- Large cross arm for housing a wire feeder
- Mandatory when using EWM tigSed and Drive 4X IC/Drive 4 IC in conjunction with Trolley 55-6/Trolley 55-5
- Can also be used as a rack and handle for better processing of designs without a wire feeder

Designation	PU	Item no.			
	stk				
Cross arm and holder for wire feeder	1	092-002700-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Trolley 55-5	090-008632-00000	473	Trolley 55-6 DF	090-008826-00000	474
Trolley 55-5 DM	090-008632-00001	473	Trolley 55-6	090-008825-00000	474

Transport cart - Trolley series

ON PS Trolley 55-5 / 55-6



- Wire feeder pivots 360° on the welding machine
- For all wire feeders from the drive 4X series on Trolley 55-6/Trolley 55-5

Designation	PU	Item no.			
	stk				
Pivot support (360°) for wire feeders	1	092-002712-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Trolley 55-5	090-008632-00000	473	Trolley 55-6 DF	090-008826-00000	474
Trolley 55-5 DM	090-008632-00001	473	Trolley 55-6	090-008825-00000	474

ON PS Trolley 55-5 / 55-6 drive D200



- Pivot support for D200 wire feeders
- Necessary for safe installation of D200 wire feeder on ON PS Trolley 55-5/55-6
- Wire feeder pivots 360° on the welding machine
- Option 092-002712-00000 is absolutely necessary to connected a wire feeder!
- For drive D200 on Trolley 55-5/55-6

Designation	PU	Item no.			
	stk				
Pivot support for D200 wire feeders	1	092-002634-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Trolley 55-5	090-008632-00000	473	Trolley 55-6 DF	090-008826-00000	474
Trolley 55-5 DM	090-008632-00001	473	Trolley 55-6	090-008825-00000	474

Welding accessories - Welding leads

WK25mm² 230A/60% 4m FIX



Duty cycle	230 A , 60 %
Cross-section	25 mm ²
Plug Ø	9 mm
Characteristics	Original FIX® ground clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with original FIX clamp	1	398-000593-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picomig 180 puls TKG Set	091-005545-00502	225	Picomig 180 Synergic Set	091-005546-00502	227
Picomig 180 puls TKG	090-005545-00502	224	Picomig 180 Synergic TKG	090-005546-00502	226

WK35mm² 290A/60% 4m FIX



Duty cycle	290 A , 60 %
Cross-section	35 mm ²
Plug Ø	13 mm
Characteristics	Original FIX® ground clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with original FIX clamp	1	398-000594-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Picotig 200 AC/DC puls 5P TG	090-000188-00502	349
Microplasma 25	090-007027-00502	390	Picotig 200 AC/DC puls 8P TG	090-000188-00504	349
Microplasma 55	090-007028-00502	390	Picotig 200 MV puls TG	090-002059-00502	346
Mira 151 FKG	090-005084-00502	236	Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353
Mira 221 MV FKG	090-005085-00502	236	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Mira 251 FKG	090-005086-00502	237	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Mira 301 M1.02 FKG	090-005181-00502	237	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353
Mira 301 M2.20 FKG	090-005207-00502	238	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Mira 301 M2.40 FKG	090-005182-00502	238	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Pico 180 puls	090-002003-00502	423	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Pico 220 cel puls	090-002057-00502	424	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picotig 200 puls TG	090-002058-00502	346	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
			Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355

Welding accessories - Welding leads

WK50mm² 350A/60% 4m FIX



Duty cycle	350 A , 60 %
Cross-section	50 mm ²
Plug Ø	13 mm
Characteristics	Original FIX® ground clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with original FIX clamp	1	398-000597-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Pico 350 cel puls	090-002060-00502	426	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Picomig 355 Synergic TKM	090-005512-00502	235	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Saturn 301 M1.02 FKG	090-004977-00502	243	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Saturn 301 M2.20 FKG	090-004978-00502	244	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Saturn 301 M2.40 FKG	090-004979-00502	244	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Saturn 351 FDG	090-004991-00502	247	Tetrix 300 Comfort TM	090-000099-00502	362
Taurus 355 Basic TDM	090-005286-00502	198	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Taurus 355 Basic TKM	090-005406-00502	196	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
			Tetrix 300 Smart TM	090-000125-00502	362

WK70mm² 450A/60% 4m FIX



Duty cycle	450 A , 60 %
Cross-section	70 mm ²
Plug Ø	13 mm
Characteristics	Original FIX® ground clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with original FIX clamp	1	398-000596-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Basic FKW	090-005408-00502	206
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 401 Synergic FW	090-000179-00502	359
Saturn 351 M1.02 FKG	090-004983-00502	243	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Saturn 351 M2.20 FKG	090-004984-00502	245	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Saturn 351 M2.40 FKG	090-004985-00502	245	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Basic FKW	090-005419-00502	205	Wega 401 FDW	090-004949-00502	254
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Wega 401 FDG	090-004948-00502	252
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Wega 401 M1.02 FKG	090-005224-00502	248
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Wega 401 M1.02 FKW	090-005227-00502	250
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Wega 401 M2.20 FKG	090-005225-00502	249
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Wega 401 M2.20 FKW	090-005228-00502	251
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Wega 401 M2.40 FKG	090-005226-00502	249
Taurus 401 Basic FDG	090-005249-00502	208	Wega 401 M2.40 FKW	090-005229-00502	251
Taurus 401 Basic FDW	090-005250-00502	211			
Taurus 401 Basic FKG	090-005426-00502	204			

Welding accessories - Welding leads

WK95mm² 550A/60% 4m FIX



Duty cycle	550 A , 60 %
Cross-section	95 mm ²
Plug Ø	13 mm
Characteristics	Original FIX® ground clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with original FIX clamp	1	398-000595-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 501 Synergic S HP MM FKW	090-005411-00502	136
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 505 Basic TDM	090-005221-00502	200
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 505 Synergic S MM TDM	090-005338-00502	132
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 551 Synergic FW	090-000093-00502	360
Set Taurus 505 Basic Duo Gouging	092-008313-00000	201	Wega 501 FDW	090-005088-00502	255
Taurus 501 Synergic S LP MM FKW	090-005424-00502	136	Wega 601 FDW	090-005089-00502	255

WK16mm² 170A/60% 4m/K



Duty cycle	170 A , 60 %
Cross-section	16 mm ²
Plug Ø	9 mm
Characteristics	Clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	094-005314-00000			

Suitable for:

Ty	Item no.	Page
Pico 162 MV	090-002042-00502	422

WK16mm² 170A/60% 4m/K



Duty cycle	170 A , 60 %
Cross-section	16 mm ²
Plug Ø	13 mm

Designation	Item no.			
Workpiece lead with clamp	094-005801-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Microplasma 55	090-007028-00502	390
Microplasma 25	090-007027-00502	390	Pico 160	090-002128-00502	418
			Pico 160 cel puls	090-002129-00502	419

WK25mm² 230A/60% 4m/K



Duty cycle	230 A , 60 %
Cross-section	25 mm ²
Plug Ø	9 mm
Characteristics	Clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	092-000016-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picomig 180 puls TKG Set	091-005545-00502	225	Picomig 180 Synergic Set	091-005546-00502	227
Picomig 180 puls TKG	090-005545-00502	224	Picomig 180 Synergic TKG	090-005546-00502	226

WK35mm² 290A/60% 4m/K



Duty cycle	290 A , 60 %
Cross-section	35 mm ²
Plug Ø	13 mm
Characteristics	Clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	092-000008-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Mira 151 FKG	090-005084-00502	236	Picotig 200 MV puls TG	090-002059-00502	346
Mira 221 MV FKG	090-005085-00502	236	Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353
Mira 251 FKG	090-005086-00502	237	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Mira 301 M1.02 FKG	090-005181-00502	237	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Mira 301 M2.20 FKG	090-005207-00502	238	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353
Mira 301 M2.40 FKG	090-005182-00502	238	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Pico 180 puls	090-002003-00502	423	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Pico 220 cel puls	090-002057-00502	424	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picotig 200 puls TG	090-002058-00502	346	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
			2x Mira 221 MV FKG	092-015239-00502	241

Welding accessories - Welding leads

WK50mm² 350A/60% 4m/K



Duty cycle	350 A , 60 %
Cross-section	50 mm ²
Plug Ø	13 mm
Characteristics	Clamp

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	092-000003-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Saturn 351 FDG	090-004991-00502	247
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Saturn 351 M1.02 FKG	090-004983-00502	243
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Saturn 351 M2.20 FKG	090-004984-00502	245
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Saturn 351 M2.40 FKG	090-004985-00502	245
Pico 300 cel	090-002043-00502	425	Taurus 355 Basic TDM	090-005286-00502	198
Pico 300 cel pws	090-002044-00502	425	Taurus 355 Basic TKM	090-005406-00502	196
Pico 300 cel pws svrd 12V	090-002044-00504	425	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Pico 300 cel pws vrd 12V	090-002044-00503	425	Taurus 355 Synergic S MM TDM	090-005336-00502	130
Pico 300 cel svrd 12V	090-002043-00504	425	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Pico 300 cel vrd 12V	090-002043-00503	425	Taurus 400 Basic TDG	090-005446-00502	193
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Picomig 355 Synergic TKM	090-005512-00502	235	Tetrix 300 Comfort TM	090-000099-00502	362
Saturn 301 M1.02 FKG	090-004977-00502	243	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Saturn 301 M2.20 FKG	090-004978-00502	244	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Saturn 301 M2.40 FKG	090-004979-00502	244	Tetrix 300 Smart TM	090-000125-00502	362

WK70mm² 450A/60% 4m/Z



Duty cycle	450 A , 60 A
Cross-section	70 mm ²
Plug Ø	13 mm
Characteristics	Clamp with wing nut

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	092-000013-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Basic FKW	090-005408-00502	206
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKW	090-005423-00502	136
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S MM FDG	090-005342-00502	138
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Taurus 505 Basic S	090-005601-00502	181
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Taurus 405 Basic S	090-005591-00502	180	Tetrix 401 Synergic FW	090-000179-00502	359
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 351 Basic FKG	090-005425-00502	203	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Synergic S MM FDG	090-005341-00502	138	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S MM FDW	090-005345-00502	141	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134	Wega 401 FDW	090-004949-00502	254
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134	Wega 401 FDG	090-004948-00502	252
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136	Wega 401 M1.02 FKG	090-005224-00502	248
Taurus 355 Basic TDM	090-005286-00502	198	Wega 401 M1.02 FKW	090-005227-00502	250
Taurus 355 Synergic S MM TDM	090-005336-00502	130	Wega 401 M2.20 FKG	090-005225-00502	249
Taurus 401 Basic FDG	090-005249-00502	208	Wega 401 M2.20 FKW	090-005228-00502	251
Taurus 401 Basic FDW	090-005250-00502	211	Wega 401 M2.40 FKG	090-005226-00502	249
Taurus 401 Basic FKG	090-005426-00502	204	Wega 401 M2.40 FKW	090-005229-00502	251

Welding accessories - Welding leads

WK95mm² 550A/60% 4m/Z



Duty cycle	550 A , 60 A
Cross-section	95 mm ²
Plug Ø	13 mm
Characteristics	Clamp with wing nut

Designation	PU	Item no.			
	stk				
Workpiece lead with clamp	1	092-000171-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 501 Synergic S LP MM FKW	090-005424-00502	136	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 501 Synergic S HP MM FKW	090-005411-00502	136	Wega 501 FDW	090-005088-00502	255
Taurus 505 Basic S	090-005601-00502	181	Wega 601 FDW	090-005089-00502	255
Taurus 505 Basic TDM	090-005221-00502	200			
Taurus 505 Synergic S MM TDM	090-005338-00502	132			

Welding accessories - Electrode holders

- Fully assembled electrode holder with cable

EH 16 mm² 170 A/60% 4 m



Duty cycle	170 A , 60 %
Cross-section	16 mm ²
Plug Ø	9 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	094-005313-00000			

Suitable for:

Ty	Item no.	Page
Pico 162 MV	090-002042-00502	422

EH 16 mm² 170 A/60% 4 m



Duty cycle	170 A , 60 %
Cross-section	16 mm ²
Plug Ø	13 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holders	1	094-005800-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 160	090-002128-00502	418	Pico 160 cel puls	090-002129-00502	419

EH 25mm² 230A/60% 4m



Duty cycle	230 A , 60 %
Cross-section	25 mm ²
Plug Ø	9 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	092-000017-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picomig 180 puls TKG Set	091-005545-00502	225	Picomig 180 Synergic Set	091-005546-00502	227
Picomig 180 puls TKG	090-005545-00502	224	Picomig 180 Synergic TKG	090-005546-00502	226

Welding accessories - Electrode holders

EH 35mm² 290A/60% 4m



Duty cycle	290 A , 60 %
Cross-section	35 mm ²
Plug Ø	13 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	092-000052-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 180 puls	090-002003-00502	423	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Pico 220 cel puls	090-002057-00502	424	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Picotig 200 puls TG	090-002058-00502	346	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picotig 200 MV puls TG	090-002059-00502	346	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355

EH 50mm² 350A/60% 4m



Duty cycle	350 A , 60 %
Cross-section	50 mm ²
Plug Ø	13 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	092-000004-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TDM	090-005352-00502	102	Picomig 355 puls TKM	090-005542-00502	233
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Picomig 355 Synergic TKM	090-005512-00502	235
Phoenix 355 Progress puls MM TDM	090-005320-00502	98	Taurus 355 Basic TKM	090-005406-00502	196
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Pico 300 cel	090-002043-00502	425	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Pico 300 cel pws	090-002044-00502	425	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 300 cel pws svrd 12V	090-002044-00504	425	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 Comfort TM	090-000099-00502	362
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 300 Smart TM	090-000125-00502	362

EH 70m² 450A/60% 4m



Duty cycle	450 A , 60 %
Cross-section	70 mm ²
Plug Ø	13 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	092-000011-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 401 Synergic S HP MM FKG	090-005432-00502	134
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 401 Synergic S LP MM FKG	090-005429-00502	134
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Synergic S HP MM FKW	090-005409-00502	136
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 405 Basic TDM	090-005241-00502	199
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 405 Synergic S MM TDM	090-005337-00502	131
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Basic FDG	090-005176-00502	208
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 451 Synergic S MM FDG	090-005343-00502	139
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Tetrix 351 DC Comfort 2.0 puls	090-000246-00502	359
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 405 Exrt 2.0 puls MM TDM	090-005353-00502	103	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 405 Progress puls MM TDM	090-005321-00502	99	Tetrix 351 Synergic FW	090-000118-00502	359
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 401 DC Comfort 2.0 puls	090-000247-00502	359
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 401 Synergic FW	090-000179-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 451 DC Comfort 2.0 puls	090-000248-00502	359
Taurus 405 Basic S	090-005591-00502	180	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Taurus 351 Basic FDG	090-005389-00502	208	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Taurus 351 Basic FDW	090-005390-00502	211	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Taurus 351 Basic FKW	090-005419-00502	205	Tetrix 451 Synergic FW	090-000103-00502	359
Taurus 351 Synergic S LP MM FKW	090-005422-00502	136			
Taurus 351 Synergic S MM FDG	090-005341-00502	138			
Taurus 351 Synergic S MM FDW	090-005345-00502	141			
Taurus 351 Synergic S HP MM FKG	090-005431-00502	134			
Taurus 351 Synergic S LP MM FKG	090-005428-00502	134			
Taurus 351 Synergic S HP MM FKW	090-005420-00502	136			
Taurus 400 Basic TDG	090-005446-00502	193			
Taurus 401 Basic FDG	090-005249-00502	208			
Taurus 401 Basic FDW	090-005250-00502	211			
Taurus 401 Basic FKW	090-005408-00502	206			
Taurus 401 Synergic S LP MM FKW	090-005423-00502	136			
Taurus 401 Synergic S MM FDG	090-005342-00502	138			
Taurus 401 Synergic S MM FDW	090-005346-00502	141			

Welding accessories - Electrode holders

EH 95m² 550A/60% 4m



Duty cycle	550 A , 60 %
Cross-section	95 mm ²
Plug Ø	13 mm
Length	4 m

Designation	PU	Item no.			
	stk				
Electrode holder with cable	1	092-000010-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Taurus 551 Basic FDG	090-005178-00502	209
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 505 Exrt 2.0 puls MM TDM	090-005354-00502	104	Taurus 551 Synergic S MM FDG	090-005344-00502	139
Phoenix 505 Progress puls MM TDM	090-005322-00502	100	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Tetrix 551 DC Comfort 2.0 puls	090-000249-00502	360
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Phoenix 551 Progress puls MM FDW	090-005328-00502	111	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Taurus 505 Basic S	090-005601-00502	181	Tetrix 551 Synergic FW	090-000093-00502	360
Taurus 505 Basic TDM	090-005221-00502	200			
Taurus 505 Synergic S MM TDM	090-005338-00502	132			

Welding accessories - Pressure regulators

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 r minute)
- With cut-off valve

Gas ty	Argon/CO2/mixed gas
Hose connection	G 1/4" RH
Cylinder connection	W21,8x1/14" RH
Bottle pressure	230 bar
Standards	ISO 2503

Designation	Gas flow	PU	Item no.
	l	stk	
Pressure regulator with manometer	15.0	1	394-002910-00015
	30	1	394-002910-00030

DM 801 Ar/CO2 230bar UK



- 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 r minute)

Gas ty	Argon/CO2/mixed gas
Hose connection	G3/8" RH
Cylinder connection	G5/8" RH
Bottle pressure	230 bar
Standards	ISO 2503

Designation	Gas flow	PU	Item no.
	l	stk	
Pressure regulator with manometer	15.0	1	394-002911-00015
	30	1	394-002911-00030

Tigex



- Single stage pressure regulator with float ty meter for flow measurement

Bottle pressure	200 bar
Standards	ISO 2503
Version	Float ty meter One-stage

Designation	Gas ty	Cylinder thread	Hose connection	Gas flow	PU	Item no.
				l/min	stk	
Pressure regulator with flow meter	Argon / Mix	W 21,8 x 1/14" LH	G 1/4"	0 - 5	1	094-001812-00001
	Argon/H2 (forming gas)		G3/8" LH		1	094-001813-00001
	Argon / Mix	W 21,8 x 1/14"	G 1/4"	0 - 20	1	094-001980-00000

Welding accessories - Pressure regulators

Maxex AR/MIX



- Single-stage pressure regulator for measuring pressure
- Controller in front of gas metering units, for example

Gas ty	Argon / Mix
Cylinder thread	W 21,8 x 1/14"
Hose connection	G 1/4"
Bottle pressure	200 bar
Standards	DIN EN ISO 2503
Version	Manometer display One-stage

Designation	Bottle pressure bar	Working pressure bar	PU stk	Item no.			
Pressure regulator	200	0 - 10	1	096-000000-00000			

Maxex Hydrogen



- Single-stage pressure regulator for measuring pressure
- Controller in front of gas metering units, for example

Gas ty	H2
Cylinder thread	W 21,8 x 1/14"LH
Hose connection	G3/8" LH
Bottle pressure	200 bar
Working pressure	0 bar - 10 bar
Standards	DIN EN ISO 2503
Version	Manometer display One-stage

Designation	PU stk	Item no.			
Pressure regulator	1	096-000001-00000			

Welding accessories - Gouging

GT 600 SKK95



- Compressed air gouging torch for separating metals
- Suitable for round carbon electrode \varnothing 3–10 mm, flat carbon electrode (width 10/16 mm; 5 mm thick)
- High-strength, heat-insulated grip
- Rotatable nozzle

Electrode \varnothing	3 mm - 10 mm
Welding current	600 A

Designation	PU	Item no.			
	stk				
Gouging torch	1	094-016099-00000			

Binzel ABIARC



- Carbon electrodes for gouging
- Best electrical conductivity thanks to pure copr coating
- High metal removal capacity
- Very low burnback rate
- Cost savings thanks to extended service life
- Further carbon electrode tys available on request

Material ty	Carbon sticks, copr-plated
--------------------	----------------------------

Designation	Electro- de \varnothing	Load capa- city	PU	Item no.			
	mm	A	v50				
Carbon electrodes	4.0	250	50	097-003239-00000			
	5.0	300	50	097-003240-00000			
	6.5	400	50	097-003241-00000			
	8.0	500	50	097-003242-00000			
	9.5	600	50	097-003243-00000			
	13.0	900	50	097-003244-00000			

General accessories

L-BOXX 102



- Compact box for transporting stick electrodes or small to medium-sized tools and accessories
- Safe transport and protection in the workshop, at the construction site and for other construction jobs
- Easy to connect and disconnect multiple L-BOXXes with just one grip
- Convenient transport of multiple L-BOXXes at the same time
- Vehicle integration in TÜV-tested Sortimo vehicle storage system
- Compatible with systems from many well-known manufacturers

Weight	2.1 kg
External dimensions (W x D x H)	442 x 357 x 117
Internal dimensions (W x D x H)	378 x 313 x 71

Designation	Item no.
Sturdy transport box	094-003900-00000

L-BOXX 374



- Large box for transporting heavy tools and accessories
- Safe transport and protection in the workshop, at the construction site and for other construction jobs
- Easy to connect and disconnect multiple L-BOXXes with just one grip
- Convenient transport of multiple L-BOXXes at the same time
- Vehicle integration in TÜV-tested Sortimo vehicle storage system
- Compatible with systems from many well-known manufacturers

Weight	3.4 kg
External dimensions (W x D x H)	442 x 357 x 389
Internal dimensions (W x D x H)	378 x 296 x 345

Designation	Item no.
Sturdy transport box	094-003899-00000

Set LC 35 mm²



Designation	PU	Item no.
	stk	
Set: Two 5-metre load cables (35 mm ²) and one 20-metre load cable (35 mm ²) for degaussing	1	092-002921-00000

Suitable for:

Ty	Item no.	Page
Pico 350 cel puls pws dgs	090-002127-00502	428

5POLE/CEE/16A/M

Designation	PU	Item no.			
	stk				
Mains plug	1	094-000712-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Pico 350 cel puls pws	090-002061-00502	427
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Pico 350 cel puls pws dgs	090-002127-00502	428
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Picomig 355 puls TKM	090-005542-00502	233
Pico 220 cel puls	090-002057-00502	424	Picomig 355 Synergic TKM	090-005512-00502	235
Pico 300 cel	090-002043-00502	425	Saturn 301 M1.02 FKG	090-004977-00502	243
Pico 300 cel pws	090-002044-00502	425	Saturn 301 M2.20 FKG	090-004978-00502	244
Pico 300 cel pws svrd 12V	090-002044-00504	425	Saturn 301 M2.40 FKG	090-004979-00502	244
Pico 300 cel pws vrd 12V	090-002044-00503	425	Taurus 355 Basic TKM	090-005406-00502	196
Pico 300 cel svrd 12V	090-002043-00504	425	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Pico 300 cel vrd 12V	090-002043-00503	425	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 Comfort TM	090-000099-00502	362
			Tetrix 300 Smart TM	090-000125-00502	362

5POLE/CEE/32A/M

- Suitable for all machines with a welding current of 350 A and above (except compact Phoenix 355, compact Taurus 355 and Picomig 355)

Designation	PU	Item no.			
	stk				
Mains plug	1	094-000207-00000			

SCHUKO/16A

Designation	PU	Item no.			
	stk				
Shock-proof plug, solid rubber	1	094-001756-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 160	090-002128-00502	418	Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353
Pico 160 cel puls	090-002129-00502	419	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Pico 180 puls	090-002003-00502	423	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Picomig 180 puls TKG Set	091-005545-00502	225	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353
Picomig 180 puls TKG	090-005545-00502	224	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Picomig 180 Synergic Set	091-005546-00502	227	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Picomig 180 Synergic TKG	090-005546-00502	226	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picotig 200 puls TG	090-002058-00502	346	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picotig 200 AC/DC puls 5P TG	090-000188-00502	349	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355

General accessories

ADAP SCHUKO/16CEE



Designation	PU	Item no.			
	stk				
Earth contact coupling/CEE16A plug	1	092-000812-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Pico 160 L-BOXX Set	091-002128-00502	420	Picotig 200 AC/DC puls 5P TG	090-000188-00502	349
Pico 160 cel puls L-BOXX Set	091-002129-00502	421	Picotig 200 AC/DC puls 8P TG	090-000188-00504	349
Microplasma 105	090-007029-00502	390	Picotig 200 MV puls TG	090-002059-00502	346
Microplasma 25	090-007027-00502	390	Tetrix 200 DC Comfort 2.0 puls 5P	090-000261-00502	353
Microplasma 55	090-007028-00502	390	Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353
Pico 160	090-002128-00502	418	Tetrix 200 DC Smart 2.0 puls 5P	090-000262-00502	353
Pico 160 cel puls	090-002129-00502	419	Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353
Pico 162 MV	090-002042-00502	422	Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	090-000239-00502	367
Pico 180 puls	090-002003-00502	423	Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367
Picomig 180 puls TKG	090-005545-00502	224	Tetrix 230 AC/DC Smart 2.0 puls 5P TM	090-000241-00502	367
Picomig 180 Synergic TKG	090-005546-00502	226	Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 230 Comfort 2.0 puls 5P TM	090-000240-00502	355
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Picotig 200 puls TG	090-002058-00502	346	Tetrix 230 DC Smart 2.0 puls 5P TM	090-000242-00502	355
			Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355

ADAP CEE/SCHUKO



Designation	PU	Item no.			
	stk				
Plug socket adapter, 0,5 m 16 A CEE/shock-proof	1	092-000928-00000			

ADAP 8-5 POL



- Adapter for connecting a 5-pole welding torch to an 8-pole welding machine

Designation	PU	Item no.			
	stk				
8-to-5-pole cable adapter	1	092-000940-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Picotig 200 AC/DC puls 8P TG	090-000188-00504	349	Tetrix 230 Comfort 2.0 puls 8P TM	090-000240-00504	355
Tetrix 200 DC Comfort 2.0 puls 8P	090-000261-00504	353	Tetrix 230 DC Smart 2.0 puls 8P TM	090-000242-00504	355
Tetrix 200 DC Smart 2.0 puls 8P	090-000262-00504	353	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	090-000239-00504	367	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Tetrix 230 AC/DC Smart 2.0 puls 8P TM	090-000241-00504	367	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
			Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357

ADAP 16/25-35 QMM



Designation	PU	Item no.			
	stk				
Welding current socket adapter, 9/13 mm (16 mm ² /35 mm ²)	1	094-001780-00000			

Suitable for:

Ty	Item no.	Page
Pico 162 MV	090-002042-00502	422

ADAP DINSE



Designation	PU	Item no.			
	stk				
Adapter for welding torches with Dinse connector to use Euro torch connector on the machine	1	094-016765-00000			

ADAP DINSE EZA/DZA



Designation	PU	Item no.			
	stk				
Adapter for welding torches with Euro torch connector to use Dinse connector on the machine	1	394-000134-00000			

ADAP DINSE



- Adapter for welding torch with Euro torch connector on Cloos connection (gas/water on the outside) on the machine
- Cloos is a registered trademark of Carl Cloos Schweißtechnik GmbH

Designation	PU	Item no.			
	stk				
Adapter for welding torch with Euro torch connector on CLOOS connection (gas/water outside) on the machine	1	094-019852-00000			

AK300



- Wire spool adapter for use with a wire basket spool (B 300)

Designation	PU	Item no.			
	stk				
Wire spool adapter B300	1	094-001803-00001			

CA D200



- Centering adapter 5 kg (D200) spools on wire spool support for 15 kg (D300) spools

Designation	PU	Item no.			
	stk				
Centering adapter for 5 kg spool	1	094-011803-00000			

Gas hose



- Shielding gas hose
- Equipd with plastic nuts on both sides for tool-free assembly

Gas ty	Argon/H2/CO2 (forming gas)				
Standards	DIN EN ISO 3821 / DIN EN 1256				
Hose connection	2 x G1/4"				
Working pressure	6 bar				

Designation	Length	PU	Item no.		
	m	stk			
Gas hose	2.0	1	094-000010-00001		
	3.0	1	094-000010-00003		
	5.0	1	094-000010-00005		

General accessories

ADAP3 G1/4-G1/4 LKS



Designation	PU	Item no.			
	stk				
Threaded adapter	1	094-001652-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Microplasma 105	090-007029-00502	390	Microplasma 25	090-007027-00502	390
			Microplasma 55	090-007028-00502	390

HOSE BRIDGE UNIVERSAL

- Hose bridge
- For orating gas-cooled torches on water-cooled welding machines



Designation	PU	Item no.			
	stk				
Hose bridge	1	092-007843-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 351 Exrt 2.0 puls MM 2DVX FDW	090-005329-54502	122	Taurus 351 Basic FDW	090-005390-00502	211
Phoenix 351 Exrt 2.0 puls MM FDW	090-005329-00502	113	Taurus 351 Synergic S MM FDW	090-005345-00502	141
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	119	Taurus 401 Basic FDW	090-005250-00502	211
Phoenix 351 Progress puls MM D FDW	090-005325-10502	116	Taurus 401 Synergic S MM FDW	090-005346-00502	141
Phoenix 351 Progress puls MM FDW	090-005325-00502	110	Taurus 451 Basic FDW	090-005150-00502	211
Phoenix 401 Exrt 2.0 puls MM 2DVX FDW	090-005330-54502	122	Taurus 451 Synergic S MM FDW	090-005347-00502	142
Phoenix 401 Exrt 2.0 puls MM FDW	090-005330-00502	113	Taurus 551 Basic FDW	090-005151-00502	212
Phoenix 401 Exrt 2.0 puls MM FKW	090-005549-00502	108	Taurus 551 Synergic S MM FDW	090-005348-00502	142
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	119	Tetrix 351 AC/DC Synergic FW	090-000109-00502	371
Phoenix 401 Progress puls MM D FDW	090-005326-10502	116	Tetrix 351 AC/DC Comfort 2.0 puls	090-000250-00502	371
Phoenix 401 Progress puls MM FDW	090-005326-00502	110	Tetrix 351 DC Smart 2.0 puls	090-000253-00502	359
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	106	Tetrix 351 AC/DC Smart 2.0 puls	090-000257-00502	371
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	106	Tetrix 401 DC Smart 2.0 puls	090-000254-00502	359
Phoenix 451 Exrt 2.0 puls MM 2DVX FDW	090-005331-54502	123	Tetrix 451 AC/DC Synergic FW	090-000112-00502	371
Phoenix 451 Exrt 2.0 puls MM FDW	090-005331-00502	114	Tetrix 451 AC/DC Comfort 2.0 puls	090-000251-00502	371
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	120	Tetrix 451 DC Smart 2.0 puls	090-000255-00502	359
Phoenix 451 Progress puls MM D FDW	090-005327-10502	117	Tetrix 451 AC/DC Smart 2.0 puls	090-000258-00502	371
Phoenix 451 Progress puls MM FDW	090-005327-00502	111	Tetrix 551 AC/DC Synergic FW	090-000115-00502	371
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	106	Tetrix 551 AC/DC Comfort 2.0 puls	090-000252-00502	371
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	106	Tetrix 551 DC Smart 2.0 puls	090-000256-00502	360
Phoenix 551 Exrt 2.0 puls MM 2DVX FDW	090-005332-54502	123	Tetrix 551 AC/DC Smart 2.0 puls	090-000259-00502	371
Phoenix 551 Exrt 2.0 puls MM FDW	090-005332-00502	114	Wega 401 FDW	090-004949-00502	254
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	120	Wega 501 FDW	090-005088-00502	255
Phoenix 551 Progress puls MM D FDW	090-005328-10502	117	Wega 601 FDW	090-005089-00502	255
Phoenix 551 Progress puls MM FDW	090-005328-00502	111			

ON AL D13/27



Designation	PU	Item no.			
	stk				
Cap for load sockets	1	092-003282-00000			

OW CEE16A



- Factory fitting (no retrofitting)

Max. welding current	16 A
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Designation	PU	Item no.			
	stk				
Mains plug, assembled	1	092-008214-00000			

Suitable for:

Ty	Item no.	Page	Ty	Item no.	Page
Phoenix 355 Exrt 2.0 puls MM TKM	090-005445-00502	96	Picomig 355 Synergic TKM	090-005512-00502	235
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	94	Saturn 301 M1.02 FKG	090-004977-00502	243
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	94	Saturn 301 M2.20 FKG	090-004978-00502	244
Pico 220 cel puls	090-002057-00502	424	Saturn 301 M2.40 FKG	090-004979-00502	244
Pico 300 cel	090-002043-00502	425	Taurus 355 Basic TKM	090-005406-00502	196
Pico 300 cel pws	090-002044-00502	425	Taurus 355 Synergic S LP MM TKM	090-005421-00502	128
Pico 300 cel pws svrd 12V	090-002044-00504	425	Taurus 355 Synergic S HP MM TKM	090-005407-00502	128
Pico 300 cel pws vrd 12V	090-002044-00503	425	Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	090-000235-00502	369
Pico 300 cel svrd 12V	090-002043-00504	425	Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	090-000235-00504	369
Pico 300 cel vrd 12V	090-002043-00503	425	Tetrix 300 AC/DC Smart 2.0 puls 5P TM	090-000243-00502	369
Pico 350 cel puls	090-002060-00502	426	Tetrix 300 AC/DC Smart 2.0 puls 8P TM	090-000243-00504	369
Pico 350 cel puls pws	090-002061-00502	427	Tetrix 300 Comfort 2.0 puls 5P TM	090-000238-00502	357
Pico 350 cel puls pws dgs	090-002127-00502	428	Tetrix 300 Comfort 2.0 puls 8P TM	090-000238-00504	357
Picomig 185 puls TKG	090-005547-00502	229	Tetrix 300 Comfort TM	090-000099-00502	362
Picomig 185 Synergic TKG	090-005548-00502	231	Tetrix 300 DC Smart 2.0 puls 5P TM	090-000244-00502	357
Picomig 355 puls TKM	090-005542-00502	233	Tetrix 300 DC Smart 2.0 puls 8P TM	090-000244-00504	357
			Tetrix 300 Smart TM	090-000125-00502	362

OW CEE32A



- Factory fitting (no retrofitting)
- Suitable for all machines with a welding current of 350 A and above (except compact Phoenix 355, compact Taurus 355 and Picomig 355)

Max. welding current	32 A
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Designation	PU	Item no.			
	stk				
Mains plug, assembled (CEE 32 A)	1	092-008215-00000			

Starter equipment

SERVICE SYSTEM SS01



- 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, jammers, 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)

Designation	PU stk	Item no.			
Spare parts starter set, two boxes	1	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

Designation	PU stk	Item no.			
Spare parts starter kit, box 1	1	092-007781-00001			
Spare parts starter kit, box 2	1	092-007786-00001			

Service Case 1-8



- Separate assortment boxes
- The contents can be ordered separately or in packing units (see replacement parts catalogue)

Designation	PU stk	Item no.			
Assortment box without drawers	1	094-014770-00000			
Assortment box 1: Screws, hexagon spacers	1	092-007782-00001			
Assortment box 2: Rotary dials and covers, gas valves, spacers, lifting eyes	1	092-007783-00001			
Assortment box 3: Hose clamps, couplings, filters, pressure controllers, quick connect coupling, tank covers	1	092-007784-00001			
Assortment box 4: Safety fuses	1	092-007785-00001			
Assortment box 5: Burndy pin/socket contact, connection sockets	1	092-007787-00001			
Assortment box 6: Minifit/old Burndy pin/socket contacts	1	092-007788-00001			
Assortment box 7: Blind caps/caps	1	092-007789-00001			
Assortment box 8: Switches, triggers, jammers, drive pinions, strain relief, automatic cutouts	1	092-007790-00001			

A3-SH SET

- Test machine with CE mark for retention tests as r 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 rformed according to IEC/EN 60974-4
- Scial test routines for EWM machines
- Universal test routines also for testing other manufacturers' machines
- Extensive database functions
- Test logs printed with your customer logo
- Test Machine A3-SH
- Measuring leads
- 230 V connecting cable/AC
- Control/testing/logging software
- Test log as r IEC/EN 60974-4 and VDE 0701-0702
- Free software urades for changes or modifications to test procedures
- EWM scific software with test programs (EWM machines and machines by other manufacturers)

A3-SH SET

- **Scio of supply:**



Designation	PU	Item no.			
Test machine for retention test	stk	090-008210-00000			
	1				

Accessories - Calibration device

KLE

Calibration device



- 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 on 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

Designation	PU stk	Item no.
Calibration device	1	090-008297-00502

Calibration costs

Designation	from	PU stk	Item no.
Calibration costs r welding machine	1	1	KOS-S00018-00000
Calibration certificate	1	1	KOS-V00038-00000
	25	1	KOS-V00038-00000

LS 600A



- Load-simulation equipment up to 600 A, mobile
- The load voltage can be adjusted for MIG/MAG, TIG and MMA
- 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	1110 x 550 x 890

Designation	PU stk	Item no.
Load simulation device	1	090-008059-00101
Weekly rental LS600A, incl. calibration unit and TESTO 470	1	KOS-S00019-00000
Monthly rental LS600A, incl. calibration unit and TESTO 470	1	KOS-S00020-00000

TESTO 470



- Measurements of rotational 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

Designation	PU	Item no.			
	stk				
Measuring instrument for rotational speeds, velocities and lengths	1	098-005120-00000			

Set DGC meter



- Measuring instrument in the set for gas quantity measurement
- Checking the tolerance values with OW DGC fitted
- After a successful inspection, a certificate is issued
- Digital measurement data display of the gas quantity
- Operation through a contact-sensitive LCD display
- EWM strongly recommends participating in an EWM calibration seminar!
- Set in robust L-BOXX consisting of: Measuring instrument, gas hose (2 m), threaded nipple and sealing rings

Designation	PU	Item no.			
	stk				
Measuring instrument in the set for gas quantity measurement	1	090-008837-00000			

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
- Sco 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

Welding Trainer Soldamatic Set



Designation	PU stk	Item no.			
Welding trainer, stand-alone version incl. work stand and transport case	1	094-022842-00000			
Welding trainer, network version incl. work stand and transport case	1	094-022843-00000			
Welding trainer, stand-alone version	1	094-022850-00000			
Welding trainer, network version	1	094-022853-00000			
Licence for additional software	1	094-022844-00000			
	1	094-022845-00000			
MIG/MAG welding course, German	1	094-022846-00000			
MIG/MAG welding course, English	1	094-022846-00001			
TIG welding course, German	1	094-022847-00000			
TIG welding course, English	1	094-022847-00001			
MMA welding course, German	1	094-022848-00000			
MMA welding course, English	1	094-022848-00001			
Work stand, holder for the workpieces	1	094-022852-00000			
Transport case	1	094-022851-00000			
Soldamatic server	1	094-022849-00000			

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

- All prices in this price list are net prices excluding any applicable sales or value-added tax and are not subject to any additional discounts.
- The prices remain valid until a new price list is released.
- 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 (Euroan 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

Ty	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 exnses!

Ty	Designation	Item no.		
KOS3	Manual welding: hourly rate for welding exrts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exrts, electrical engineers, test welding	KOS-A00000-I0003		
KOS49-01	Automated welding: Hourly rate for welding exrts, electrical engineers, process survision	KOS-V00013-00001		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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 exnses!

Ty	Designation	Item no.		
KOS27	Commissioning: 1 hour	KOS-V00027-00000		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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 rformance 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 exnses!

Ty	Designation	Item no.		
KOS29	Instruction/basic training: 2 hours	KOS-V00029-00000		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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 sent. 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 exnses!

■ 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.

Ty	Designation	Item no.		
KOS29	Machine update, hourly rate for welding exrts, 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 exnses for technicians and engineers	KOS-V00057-00000		

Calibration

Our calibration service is designed for those with the highest quality exctations.

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 exnses!

Ty	Designation	Item no.		
KOS60	Calibration costs r welding machine	KOS-S00018-00000		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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

Ty	Designation	Item no.		
KOS3	Manual welding: hourly rate for welding exerts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exerts, electrical engineers, test welding	KOS-A00000-I0003		
KOS3-I	Hourly rate for development staff, technicians/engineers	KOS-A00000-I0002		

Preparing a characteristic

■ Costs

Ty	Designation	Item no.		
KOS51	Fixed price r 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

Ty	Designation	Item no.		
KOS3	Manual welding: hourly rate for welding exerts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exerts, electrical engineers, test welding	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 exnses!

Ty	Designation	Item no.		
KOS49	Manual welding: hourly rate for welding exerts, electrical engineers	KOS-V00013-00000		
KOS49-01	Automated welding: Hourly rate for welding exerts, electrical engineers, process supervision	KOS-V00013-00001		
KOS4-I	Automated welding: Hourly rate for welding exerts, electrical engineers, test welding	KOS-A00000-I0003		
KOS49-I	Hourly rate for development staff, technicians/engineers	KOS-V00013-I0000		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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!

Ty	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, test welding	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 complementary courses, €50.00 is payable for each participant.

Ty	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. retition test)

■ Included in delivery

- Repair or servicing, including retition 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 exnse 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 exnses!

■ 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.

Ty	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 exnses 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 exnses!

Ty	Designation	Item no.		
KOS54	Hourly rate for metallurgic testing	KOS-A00009-00000		
KOS3	Manual welding: hourly rate for welding exrts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exrts, electrical engineers, test welding	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.

Ty	Designation	Item no.		
KOS3	Manual welding: hourly rate for welding exrts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exrts, electrical engineers, test welding	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 exnses!

Ty	Designation	Item no.		
KOS3	Manual welding: hourly rate for welding exrts, electrical engineers	KOS-A00000-00002		
KOS4-I	Automated welding: Hourly rate for welding exrts, electrical engineers, test welding	KOS-A00000-I0003		
KOS24	Mileage allowance	KOS-S00010-00000		
KOS57	Hourly rate for travel exnses 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 modify 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 effect. 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

Germany's Used Electrical Equipment Law (Elektro-Altgeräte-Gesetz) stipulates that this machine does not belong in domestic waste.

The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of. Do not dispose of the machine in household waste! Observe local regulations on disposal!



EWM participates in an approved waste disposal and recycling scheme and is registered in the National Register for Waste Electric Equipment (EAR) with reference number WEEE DE 57686922.

Please contact EWM regarding the options for returning your used electrical equipment: info@ewm-group.com

Machines can also be returned to EWM sales partners across Euro.

■ Packaging return

- German packaging legislation states that EWM is obliged to take back product packaging and guarantee its recycling or disposal. We work with an approved disposal system to meet these requirements.
- Packaging can be returned to any EWM sales partner after purchase. Please contact EWM directly in the case of machines purchased online.
- We, EWM AG in Mündersbach, Germany, hereby confirm that all products which we supply to you that are subject to the RoHS Directive comply with RoHS requirements (Directive 2011/65/EU).

■ Compliance with RoHS requirements

- German packaging legislation states that EWM is obliged to take back product packaging and guarantee its recycling or disposal. We work with an approved disposal system to meet these requirements.
- Packaging can be returned to any EWM sales partner after purchase. Please contact EWM directly in the case of machines purchased online.
- We, EWM AG in Mündersbach, Germany, hereby confirm that all products which we supply to you that are subject to the RoHS Directive comply with RoHS requirements (Directive 2011/65/EU).

■ Manufacturer's declaration to end user

- According to Euroan provisions (Directive 2012/19/EU of the Euroan Parliament and the Council of 13 August 2012), 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 help to protect the environment and ensure that this machine is placed in the appropriate collection category when you no longer wish to use it.
- German law (reform of the law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment [ElektroG] dated 20 October 2015) states that you are required to place used machines in a collection system separate from unsorted municipal waste. 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 ask your state or municipal government about options available in your area for returning or collecting used equipment.

HEADQUARTERS

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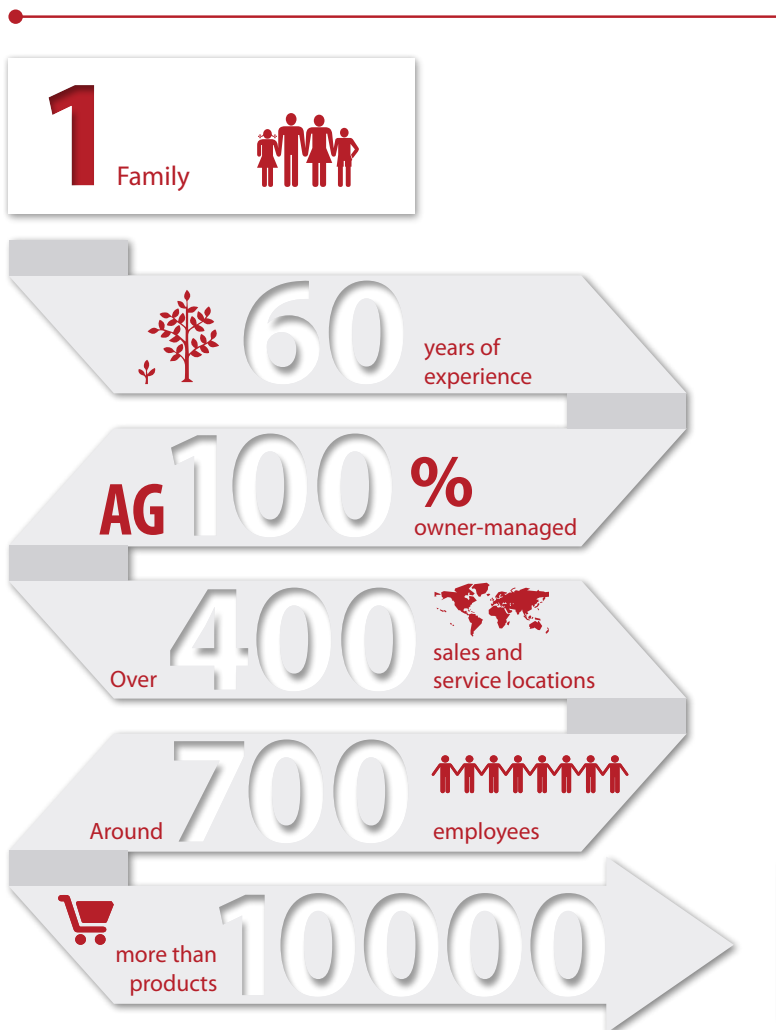
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