

# Soldering, Welding

	<p><b>Tinning</b></p> <p>Page 3</p>		<p><b>Autogenic welding rods, hard solder</b></p>
	<p><b>Soldering</b></p> <p>Page 4</p>		<p><b>Protective equipment for welding</b></p> <p>Page 59</p>
	<p><b>Soldering Set, Soldering Accessories, Soldering</b></p> <p>Page 10</p>		<p><b>Chemical products for welding</b></p>
	<p><b>Induction Warmer</b></p> <p>Page 28</p>		<p><b>Plasma cutting</b></p>
	<p><b>Welding Machines</b></p> <p>Page 30</p>		<p><b>Pickling tools, pickling accessories</b></p>
	<p><b>Welding accessories</b></p>		
	<p><b>Welding and cutting equipment</b></p>		
	<p><b>Welding wire, rods, electrodes</b></p>		

# Corrossion Protection-Set Re-Zinc

- Enables additional electrolytic zinc coating of repair spots on the car body, where already primers, zinc sprays or zinc dust colours were applied
- Creates a very pure, adhesive and matt zinc coat
- Suitable for all repaired bare ground spots
- Long-lasting sealing of weld spots and weld seams as well as hoods, mudguards, wheel arches, sills and doors
- When replacing the bonded screen, if the flange coating is damaged during cutting out of the screen
- Only metallic bare spots are zined, no damage of intact paint
- Excellent adhesion of zinc coat on filling solder
- No drying time necessary
- Excellent adhesion of filling solder, filler and paint
- Cleaning of slightly rusted sheets
- Also suitable for vintage cars

Article No.	Article Description	QTY
5492 1	CORROSION PROTECT.SET RE-ZINC	1

### Scope of delivery:

- 1x Art.-No. 5492 1 1: power supply 220 V
- 1x Art.-No. 5492 1 10 5: handle Ø 80
- 2x Art.-No. 5492 1 20: handle electrode rectangle 30
- 3x Art.-No. 5492 1 10 1: Pad Ø 80
- 10x Art.-No. 5492 1 20 1: Pad rectangle 30
- 1x Art.-No. 5492 1 10: electrode Ø 80
- 1x Art.-No. 5492 1 30 1: shell
- 1x Art.-No. 5492 1 10 2: contact plate
- 1x Art.-No. 5492 1 30: electrolyte 1 l
- 1x Art.-No. 5492 1 2: cable red (+)
- 1x Art.-No. 5492 1 3: cable black (-)



5492 1 1



5492 1 2



5492 1 3



5492 1 10



5492 1 10 1



5492 1 10 2



5492 1 10 3



5492 1 10 4



5492 1 10 5



5492 1 20



5492 1 20 1



5492 1 30



5492 1 30 1

## Filling Solder – 3 Metal Alloy, Lead-free

- According to DIN EN 29453
- 3 metal alloy: 90% Sn (tin) , 7% Zn (zinc) , 3% Cu (copper)
- Working temperature: +220 °C to +300 °C

Article No.	Article Description	QTY
5490 3	KG FILLING SOLDER SN90 ZN7 CU3	e 20



## Tinning Paste, Lead-free

- Flux according to DIN 29454-1 3.1.1.C
- 97% Sn (tin) , 3% Cu (copper)
- Ready-for-use soft solder metal paste for tinning body parts, containers, equipment, etc.
- Brush included

Article No.	Article Description	QTY
5490 5	CAN(1KG)TINN.PASTE S-SN97 CU3	1



## Soldering Oil – Steel and Stainless Steel

- Flux according to DIN EN 29454-1 3.2.2.A
- Acidic
- **Please note:** Remove flux residues with soap water and neutralise after tinning

Article No.	Article Description	QTY
5490 6	FL(500ML)SOLDERING OIL STEEL	1



# Filling Solder – 3 Metal Alloy, Leaded

- According to DIN 29453

**Art.-No. 5490 25:**

- 3 metal alloy: 74 % Pb (lead) , 25 % Sn (tin) , 1 % Sb (antimony)
- Working temperature: +190 °C to +250 °C

**Art.-No. 5490 33:**

- 3 metal alloy: 67 % Pb (lead), 33 % Sn(tin), 0,5 % Sb (antimony)
- working temperature: +250 °C to + 350 °C

**Art.-No. 5490 40:**

- 3 metal alloy: 59.5 % Pb (lead), 40% Sn (tin), 0.5 % Sb (antimony)
- Working temperature: +200 °C to +350 °C

**Art.-No. 5490 50:**

- 3 metal alloy: 50 % Pb (lead), 50 % Sn (tin), 0,5 % Sb (antimony)
- Working temperature: +250 °C to +300 °C

**Art.-No. 5490 60:**

- 3 metal alloy: 40 % Pb (lead), 60 % Sn (tin), 0,5 % Sb (antimony)
- Working temperature: +220 °C to +350 °C



Article No.	Article Description	QTY
5490 25	KG FILLING SOLDER PB. 25%	e 25
5490 33	KG FILLING SOLDER PB. 33%	ü 25
5490 40	KG FILLING SOLDER PB. 40%	ü 25
5490 50	KG FILLING SOLDER PB. 50%	ü 25
5490 60	KG FILLING SOLDER PB. 60%	ü 25

(% = tin fraction)

## Solder Paddles

- Hornbeam, turned, finely polished

**Technical Data**

Article No.	Design/spreading area	Length
5491 101	Bottom: round, 110 x 32 mm Front side: flat 58 x 32 mm	260mm
5491 102	Flat & narrow, 135 x 32 mm	260mm
5491 104	Oval & pointed, 80 x 50 mm	200mm
5491 105	Flat & wide, 100 x 58 mm	200mm

Article No.	Article Description	QTY
5491 101	SOLDER PADDLE 101 ROUND/FLAT	1
5491 102	SOLDER PADDLE 102 FLAT, NARROW	1
5491 104	SOLDER PADDLE 104 OVAL/POINTED	1
5491 105	SOLDER PADDLE 105 FLAT, WIDE	1



## Solder Wires – Electric/Electron. Solder.Lead-free

- S-Sn99/Cu1 with halogen-free flux filling according to DIN EN 29454-1 1.1.3.B
- Flux residues are transparent, dry, solid, and will not act corrosively

Article No.	Article Description	QTY
5470 05 250 1	SOLD.WIRE SN99/CU1 0.5MM 250G	1
5470 08 250 1	SOLD.WIRE SN99/CU1 0.8MM 250G	1
5470 10 250 1	SOLD.WIRE SN99/CU1 1.0MM 250G	1
5470 15 250 1	SOLD.WIRE SN99/CU1 1.5MM 250G	1

(Wire Ø in mm / g/coil)



## Solder Wires-Electric/Electronic Sold.Plumbiferous

- S-Sn60Pb40 with halogen-free, activated rosin flux filling according to DIN EN 29454-1 1.1.3B
- Flux residues are transparent, dry, solid, and will not act corrosively

Article No.	Article Description	QTY
5470 05 100	ELEC.SOL.WIRES60/40 0.5MM 100G	1
5470 05 250	ELEC.SOL.WIRES60/40 0.5MM 250G	1
5470 08 100	ELEC.SOL.WIRES60/40 0.75MM100G	1
5470 08 250	ELEC.SOL.WIRES60/40 0.75MM250G	1
5470 10 250	ELEC.SOLDER WIRE60/40 1MM 250G	1
5470 10 500	ELEC.SOL.WIRES60/40 1.0MM 500G	1
5470 15 250	ELEC.SOL.WIRES60/40 1.5MM 250G	1
5470 15 500	ELEC.SOL.WIRES60/40 1.5MM 500G	1
5470 15 1000	ELEC.SOL.WIRES60/40 1.5MM1000G	1

(Wire Ø in mm / g/coil)



## Soldering Paste

- According to DIN EN 29454-1 1.1.2.C
- Flux for soldering in the electro-mechanical and electronics areas
- Content: 50 g

Article No.	Article Description	QTY
5470 50	CONTACT-SOLDERING PASTE 50G	1



## Solder Wires for Metal Soldering, Plumbiferous

- S – 40Sn/60Pb with flux filling according to DIN EN 29454-1 2.1.2A
- For soldering on all kinds of metals except aluminium
- Not suitable for electric/electronic soldering
- Please remove flux residues after soldering

Article No.	Article Description	QTY
5471 15 500	SOFT SOL.WIRE.W.FLUX1.5MM 500G	1
5471 15 1000	SOFT SOL.WIRE.W.FLUX1.5MM1000G	1
5471 20 500	SOFT SOL.WIRE.W.FLUX2.0MM 500G	1
5471 20 1000	SOFT SOL.WIRE.W.FLUX2.0MM1000G	1

(Wire Ø in mm / g/coil)



## Soldering Grease

- According to DIN EN 29454-1 3.1.1.C
- Flux for soldering tin plated and leaded sheet metal, for tin-plating copper and brass
- Not suitable for electric/electronic soldering
- Contains zinc chloride: acidic

Article No.	Article Description	QTY
5479 1 100	SOLDERING GREASE 100G	1
5479 1 250	SOLDERING GREASE 250G	1



## Soldering Water

- According to DIN EN 29454-1 3.1.1..A
- Flux for soft soldering iron, steel, copper, brass as well as for all soldering work
- Contains zinc chloride: acidic
- 2500 ml = 3.4kg

Article No.	Article Description	QTY
5479 2 50	SOLDERING WATER 50ML	1
5479 2 500	SOLDERING WATER 500ML	1



## Soldering Water Brush

- Tin plate with natural bristles
- Suitable for soldering grease and water

Article No.	Article Description	QTY
5479 9	SOLDERING WATER BRUSH	e 10



## Soldering Fluid Bottle

- Made from yellow polyethylene

Article No.	Article Description	QTY
5479 4	SOLDER. FLUID BOTTLE YEL.EMPTY	1



## Hydrochloric Acid Bottle

- Made from blue polyethylene

Article No.	Article Description	QTY
5479 3	HYDROCHLO.ACID BOTTLE BL.EMPTY	1



## Fitting Solder No.3

- 97/3 L-SN Cu 3
- 97 % tin, 3 % copper according to DIN EN 29453
- Monitored with the RAL quality sign of the German Quality Association for copper pipe (Gütegemeinschaft Kupferrohr) Lead-free – for all cold and hot water installations of copper pipes as drinking water and heating pipes
- Coil Ø 44 mm

Article No.	Article Description	QTY
8696 27	FITTING SOLDER NO 3 2.7MM 250G	z 50



## Fitting Solder Paste

- Lot L-Sn 97 Cu 3 DIN 1707 / DIN EN 29453 (part 60 weight %)
- Flux agents / DIN 8511 F-SW 21 DIN EN 29454 3.1.1.C
- DVGW tested DVGW FI 058 GW7 – for the cold and hot water installation of copper pipes as drinking water and heating pipes
- Monitored with the RAL quality sign of the German Quality Association for copper pipe (Gütegemeinschaft Kupferrohr)e.V., RAL-RG 641/3
- Flux agent residues are soluble in cold and hot water

Article No.	Article Description	QTY
8696 250	FITTING SOLDER PASTE 250G	e 12

### Scope of delivery:

- 1x brush holder
- 1x brush



## Soldering Gun 60W

- Protection class II, protective insulation
- With integrated solder joint light and 2 tips
- Heating up time: 5 seconds

Article No.	Article Description	QTY
5478 60	SOLDERING GUN 220V 60W	1
5478 60 1	SOLDER TOP SET F.SOLD.GUN 60W	1



## Soldering Irons 15/30W

- Low-power soldering irons for electronic soldering
- Plastic handle and straight, nickel-plated tip
- 1.5m power cord with CEE 7/7 (hybrid Schuko) plug

### Art.-No. 5478 15:

- 15 Watt
- Peak temperature: approx. +370° C
- Heating up time: approx. 1.5 min

### Art.-No. 5478 30:

- 30 Watt
- Peak temperature: approx. +410 °C
- Heating up time: approx. 1.5 min

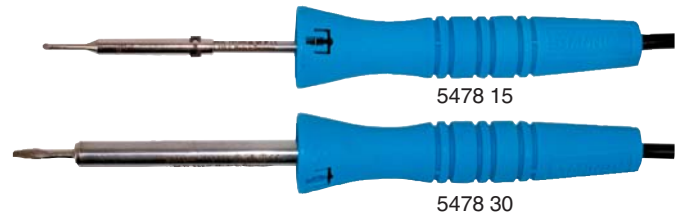
Article No.	Article Description	QTY
5478 15	FINE SOLD.IRON 220V/230V 15W	1
5478 15 1	COPPER TOP SET F.SOLD.IRON 15W	1
5478 30	SOLDERING IRON 220/230V 30W	1
5478 30 1	COPPER TOP SET F.SOLD.IRON 30W	1

### Contents Art.-No. 5478 15 1:

- each 1x bevelled, pencil and chisel-shaped tip

### Contents Art.-No. 5478 30 1:

- each 1x straight and bent tip



## Soldering Irons 100/200W

- For general soldering work
- Plastic handle and straight, nickel-plated tip
- 1.5m power cord with CEE 7/7 (hybrid Schuko) plug

### Art.-No.. 5478 100:

- 100 Watt
- Peak temperature: approx. +500 °C
- Heating up time: approx. 2.5 min

### Art.-No. 5478 200:

- 200 Watt
- Peak temperature: approx. +530 °C
- Heating up time: approx. 4 min
- Also for joint soldering on metal sheets up to 1 mm thickness

Article No.	Article Description	QTY
5478 100	SOLDERING IRON 220/230V 100W	1
5478 100 1	COPPER TOP SET F.SOLD.IRON100W	1
5478 200	SOLDERING IRON 220/230V 200W	1
5478 200 1	COPPER TOP F.SOLD.IRON 200W	1

### Content Art.-No. 5478 100 1:

- each 1x straight and bent tip

### Content Art.-No. 5478 200 1:

- each 1x straight tip





# Soldering Iron Accessories

## Art.-No. 5478 910:

- Fold-away

## Art.-No. 5478 900:

- For cleaning soldering tips
- Dimensions (L x W x H): 65 x 45 x 20 mm

Article No.	Article Description	QTY
5478 910	SOLDERING IRON PILLAR	1
5478 920	SOLDERING IRON HOLDER	1
5478 900	SALMIAK-SOLD.STONE 65X45X20MM	1

## Art.-No. 5478 920:

- 1x Sheet metal foot
- 1x Sponge tray



# Desoldering Pump

- With PTFE peak and integrated nozzle cleaner
- Strong suction effect for desoldering work on electric/electronic parts

Article No.	Article Description	QTY
5478 950	DESOLDERING PUMP	1
5478 950 1	DESOLDERING PUMP TOP - SET	1

## Contents Art.-No. 5478 950 1:

- 2x Replacement nozzle



# Butane-gas soldering iron kit 125W

- For demanding and delicate soldering tasks without a power supply
- Operation with common butane gas (lighter gas)
- Infinitely variable control from 30 – 125 Watt (as compared to electric solder irons)
- Stable metal housing with fill-level monitoring
- Extensive accessories for diverse applications
- In VAROsoft system insert and stable plastic case



## Technical Data

<b>Power:</b>	30 – 125 Watt
<b>Heating time:</b>	approx. 1 min to reach 250 °C
<b>Soldering tip temperature:</b>	250 – 550 °C
<b>Flame temperature:</b>	1,300 °C
<b>Tank volume:</b>	38 ml
<b>Operating time:</b>	approx. 200 min (continuous with medium flame)
<b>Ignition:</b>	Piezo-igniter
<b>Weight:</b>	166 g (filled)
<b>Dimensions (L x W x H):</b>	255 x 30 x 30 mm

Article No.	Article Description	QTY
5482 125	BUTANE-GAS SOLD.IRON KIT 125W	1

## Contents:

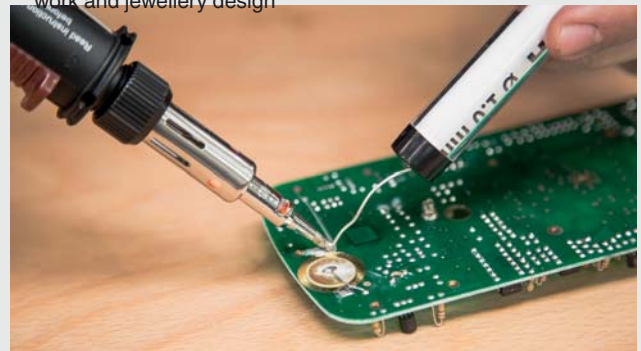
- 1x 5482 125 1: Butane-gas soldering iron 125W
- 1x 5482 125 2: Soldering tip 1.6 mm
- 1x 5482 125 3: Chisel tip 2.4 mm
- 1x 5482 125 4: Knife point
- 1x 5482 125 5: Hot-air attachment for deflector
- 1x 5482 125 6: Deflector
- 1x 5482 125 7: Gas-throttle insert
- 1x 5482 125 8: Soft soldering wire 60/40 1.0 mm
- 1x 5482 125 9: Solder cleaning sponge
- 1x 5482 125 10: Storage tray
- 1x 9026 644: VS system insert
- 1x 4415 14 47 1: Plastic case: Gr. A

## Your Advantage / Benefit

- Portable usage
- Piezo igniter
- Short heating time
- Long operating times

## Application

- For soldering, shrinking, hot cutting, or plastic welding in the automotive electrical sector, refrigeration and air-conditioning technology, TV and radio technology, model building, jeweller work and jewellery design



# Butane-gas soldering kit accessories

Article No.	Article Description	QTY
5482 125 1	BUTANE-GAS SOLDERING IRON 125W	1
5482 125 2	SOLDER TIP 1.6 MM	1
5482 125 3	CHISEL TIP 2.4 MM	1
5482 125 4	KNIFE POINT	1
5482 125 5	HOT-AIR ATTACHM.DEFLECTOR	1
5482 125 6	DEFLECTOR	1
5482 125 7	GAS-THROTTLE INSERT	1
5482 125 8	SOFT SOLDER WIRE 60/40 1.0MM	1
5482 125 9	SOLDER CLEANING SPONGE	1
5482 125 10	STORAGE TRAY	1



5482 125 1



5482 125 2



5482 125 3



5482 125 4



5482 125 5



5482 125 6



5482 125 7



5482 125 8



5482 125 9



5482 125 10

## Special Inert Gas Welding Wire for Zn Sheets

For laying of bitumen sheets, thawing, drying, heating the roof crafts and road construction

# Welding Torch

- Good regulation of the working flame from the handle
- Quick and precise switch between the pilot and working flame using lever on the handle
- Includes base for the torch
- Connection: left thread R 3/8"
- Art.-No. 5483 1 34 400: especially for detail work in corners and at edges
- Optimum operating pressure 4 bar

Technical Data			
<b>Article No.:</b>	<b>5483 1 34 400</b>	<b>5483 1 60 850</b>	<b>5483 1 50 850</b>
<b>Total length:</b>	400 mm	850 mm	850 mm
<b>Neck pipe length:</b>	100 mm	-	-
<b>Torch head:</b>	Ø 34 mm	Ø 60 mm	Ø 2 x 50 mm
<b>Power:</b>	52 kW	114 kW	130 kW
<b>Weight:</b>	790 g	1105 g	1365 g

Article No.	Article Description	QTY
5483 1 34 400	WELDING TORCH 34/400	1
5483 1 60 850	WELDING TORCH 60/850	1
5483 1 50 850	DOUBLE WELDING TORCH 50/850	1



# Welding Torch Set Ø 60 mm / 850 mm

- Complete set including hose and pressure regulator
- Good regulation of the working flame from the handle
- Quick and precise switch between the pilot and working flame using lever on the handle
- Includes base for the torch
- Propane high pressure hose according to EN 559 6, 3 x 5 mm frost-resistant up to approx. -30°C
- Pressure regulator with integrated hose breakage protection

Technical Data		
<b>Art.-No.:</b>	<b>5483 1 60 850 5</b>	<b>5483 1 60 85010</b>
<b>Total length torch:</b>	850 mm	850 mm
<b>Hose length:</b>	5,000 mm	10,000 mm
<b>Torch head:</b>	60 mm	60 mm
<b>Power:</b>	110 kW	110 kW
<b>Weight:</b>	3,300 g	4,250 g

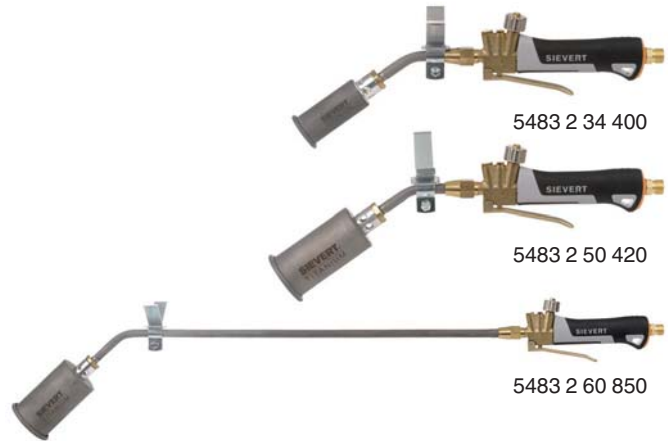
Article No.	Article Description	QTY
5483 1 60 850 5	WELD.TORCH SET Ø 60/ 850 MM 5M	1
5483 1 60 85010	WELD.TORCH SET Ø 60/ 850 MM10M	1



# Titanium Welding Torch

- Up to 60 % lighter than conventional welding torches made from steel and brass
- Good regulation of the working flame from the handle
- Quick and precise switch between the pilot and working flame using lever on the handle
- Including base for the torch
- Connection: left thread R 3/8"
- Optimum operating pressure 4 bar
- Art.-No. 5483 2 34 400 and 5483 2 50 420 especially for detail work in corners and at edges

Technical Data			
<b>Art.-No.:</b>	<b>5483 2 34 400</b>	<b>5483 2 50 420</b>	<b>5483 2 60 850</b>
<b>Total length:</b>	400 mm	420 mm	850 mm
<b>Torch head:</b>	Ø 34 mm	Ø 50 mm	Ø 60 mm
<b>Power:</b>	52 kW	86 kW	114 kW
<b>Weight:</b>	658 g	692 g	768 g

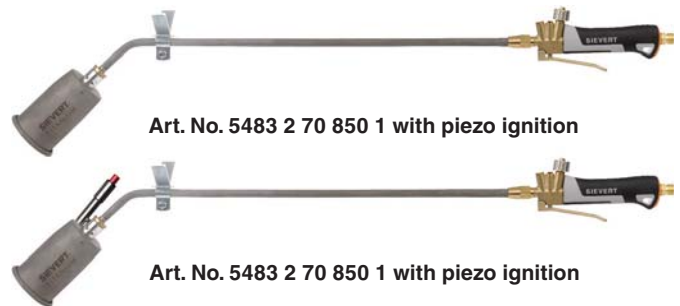


Article No.	Article Description	QTY
5483 2 34 400	TITANIUM WELDING TORCH 34/400	1
5483 2 50 420	TITANIUM WELDING TORCH 50/420	1
5483 2 60 850	TITANIUM WELDING TORCH 60/850	1

# Titanium Welding Torch 155 kW

- Up to 55 % lighter than conventional welding torches made from steel and brass
- Quick and precise switch between pilot and working flame using the lever on the handle
- Suitable for welding bituminous roof and roof sealing membranes, surface drying or heating surfaces for roadworks
- Includes support for the torch
- Connection: left thread R 3/8"
- Optimum operating pressure 4 bar

Technical Data		
<b>Art.-No.:</b>	<b>5483 2 70 850</b>	<b>5483 2 70 850 1</b>
<b>Total length:</b>	850 mm	850 mm
<b>Torch head:</b>	Ø 70 mm	Ø 70 mm
<b>Neck pipe length:</b>	500 mm	500 mm
<b>Power:</b>	155 kW	155 kW
<b>Piezo ignition:</b>	no	yes
<b>Weight:</b>	840 g	855 g



Article No.	Article Description	QTY
5483 2 70 850	TITAN.WELDING TORCH 70/850	1
5483 2 70 850 1	TITAN.WELD. TORCH 70/850 PIEZO	1

## Titanium Welding Torch Sets

- Complete set including hose and pressure regulator
- Up to 60 % lighter than conventional welding torches made from steel and brass
- Good regulation of the working flame from the handle
- Quick and precise switch between pilot and working flame using the lever on the handle
- Includes base for the torch
- Propane high pressure hose according to EN 559 6.3 mm x 5 mm frost-resistant up to -30 °C
- Pressure regulator 4 bar with integrated hose breakage protection



### Technical Data

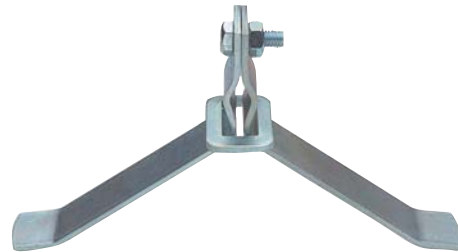
<b>Article No.:</b>	<b>5483 2 60 850 5</b>	<b>5483 2 60 85010</b>
<b>Total length torch:</b>	850 mm	850 mm
<b>Hose length:</b>	5,000 mm	10,000 mm
<b>Pressure regulator:</b>	4 bar with SBS	4 bar with SBS
<b>Power:</b>	114 kW	114 kW
<b>Weight:</b>	2618 g	2918 g

Article No.	Article Description	QTY
5483 2 60 850 5	TITAN.WELD.TORCH SET 60/850 5M	1
5483 2 60 85010	TITAN.WELD.TORCH SET60/850 10M	1

## Support for Welding Torch

- To hold the torch securely

Article No.	Article Description	QTY
5483 2 1	LEG SUPPORT F.WELDING TORCH	1



## Handle for standard burner

- Double-valve handle for Standard and Titan weld-on burners
- The pilot flame is set at the factory to approx. 7 cm and can be readjusted as required
- Fast switching between pilot and working flame using a fast-switching lever



### Technical Data

<b>Operating pressure:</b>	1.5 - 8 bar
<b>Weight:</b>	385 g
<b>Length:</b>	205 mm
<b>Height:</b>	90 mm
<b>Connection:</b>	R 3/8" left

Article No.	Article Description	QTY
5483 1 38	HANDLE STANDARD 3/8"	1

## Gas lighter

Article No.	Article Description	QTY
5400 128	GAS LIGTHER BOW-SHAPED	1
5400 129	PK(50)REPL.STONES F.GAS LIGHT.	1



5400 128



**Welding Wire, Inert Gas for Galv.Plates**

For laying of bitumen sheets, thawing, drying, heating, soldering in the roof, installation, telecommunications and crafts as well as in road construction

# Handle with Integrated Piezo Ignition

- Integrated piezo ignition with on / off function
- Quick to change the torch without need for a tool due to bayonet catch
- Hose connection turns to prevent the hose from twisting
- Ergonomic two-component handle for comfort when handling



**Technical Data**

<b>Art.-No.:</b>	<b>5483 3 38</b>
<b>Handle:</b>	336611
<b>Operating pressure:</b>	1.5-4 bar
<b>Length:</b>	180 mm
<b>Weight:</b>	300 g
<b>Height:</b>	80 mm

Article No.	Article Description	QTY
5483 3 38	HANDLE W.PIEZO IGNITION 3/8"	1

# Welding Torch with Handle

- For handle with integrated piezo ignition and quick release fastener
- Quick to change the torch without need for a tool
- Wind-resistant due to countersunk nozzle
- Optimum operating pressure: 4 bar
- Art.-No. 5483 3 40 250 for detail work on the roof, pre-heating work and shrinking work
- **Art.-No. 5483 3 60 600 1: titanium welding torch**

**Technical Data**

<b>Art.-No.:</b>	<b>5483 3 40 250</b>	<b>5483 3 60 600</b>	<b>5483 3 60 600 1</b>
<b>Torch Ø:</b>	40 mm	60 mm	60 mm
<b>Gas consumption</b>			
<b>At 4 bar:</b>	3.350 g/h	8.000 g/h	8.000 g/h
<b>Power:</b>	43,5 kW	102 kW	102 kW
<b>Length:</b>	250 mm	600 mm	60 mm
<b>Weight:</b>	800 g	1.100 g	310 g

Article No.	Article Description	QTY
5483 3 40 250	WELD. TORCH W. HANDLE 40/250	1
5483 3 60 600	WELD. TORCH W. HANDLE 60/600	1
5483 3 60 600 1	WELD. TORCH W.HAND.60/600 TITAN	1



## Hot Air Torch 38 mm

- For handle with integrated piezo ignition and quick release fastener
- Hot-air torch with powerful wind-resistant hot-air stream
- Ideal for all type of shrinking work
- Optimum working pressure 2 bar

### Technical Data

Art.-No.:	5483 3 38 1
Torch Ø:	38 mm
Gas consumption at 2 bar:	125 g/h
Power:	1.6 kW



Article No.	Article Description	QTY
5483 3 38 1	HOT AIR TORCH 38 MM	1

## Soft Soldering Torch 25 mm

- For handle with integrated piezo ignition and quick release fastener
- Standard torch for soft soldering, heating work and tin-plating work
- Optimum working pressure 2 bar

### Technical Data

Art.-No.:	5483 3 25
Torch Ø:	25 mm
Gas consumption at 2 bar:	580 g/h
Power:	7.4 kW
Soft soldering:	Ø 70 mm



Article No.	Article Description	QTY
5483 3 25	SOFT SOLDERING TORCH 25 MM	1

## Hard-Soldering Torch

- For a handle with integrated Piezo ignition and quick release
- Suitable for kinds of hard-soldering, but can also be used for soft soldering
- Optimal 2 bar working pressure

### Technical Data

Art.-No.:	5483 3 19	5483 3 25 1
Burner- Ø:	19 mm	25 mm
Gas usage at 2 bar:	250 g/h	580 g/h
Power:	3.2 kW	7.4 kW
Soft soldering:	Ø 32 mm	Ø 70 mm
Brazing:	Ø 18 mm	Ø 32 mm



Article No.	Article Description	QTY
5483 3 19	HARD-SOLDERING TORCH 19MM	1
5483 3 25 1	HARD-SOLDERING TORCH 25MM	1

## Soldering iron insert

- for handle with integrated Piezo ignition
- compatible with copper pieces:
  - Art.-No. 5483 3 350
  - Art.-No. 5483 3 370

### Technical Data

Art.-No.:	5483 3 10
Gas consumption at 2 bar:	140 g/h
Power:	1.8 kW
Weight:	542 g



Article No.	Article Description	QTY
5483 3 10	SOLD.IRON INSERT F.HANDLE 3/8"	1



# Copper piece for soldering iron use

- cold-formed copper piece made of high-quality electrolytic copper

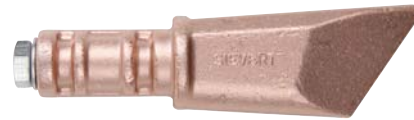
## Technical Data

Art.-No.:	5483 3 350	5483 3 370
Length:	115 mm	130 mm

Article No.	Article Description	QTY
5483 3 350	COPPER PIECE FORM HAMMER 350G	1
5483 3 370	COPPER PIECE POINTED SH.370G	1



5483 3 350



5483 3 370

# Soft- and Hard-Soldering Set 1000

- Ideal for all types of hard and soft soldering

Article No.	Article Description	QTY
5483 1000	SOFT-HARD-SOLDERING SET 1000	1

## Scope of delivery:

- Handle
- Brazer Art.-No: 5483 3 19
- Soft soldering iron 19 mm
- Pressure regulator
- Hose rupture protection
- Propane hose 2 m
- Steel case



# Heat-Shrink Torch Set 3000

- Ideal for heat-shrinking work in the construction of cables and pipe-lines
- All conventional shrink tubing can be processed

## Technical Data

Burner diameter:	28 mm	38 mm	50 mm
For shrink tubing up to:	50 mm Ø	150 mm Ø	150 mm Ø
Gas usage at 2 bar:	460 g/h	900 g/h	2000 g/h
Weight:	5.9 kW	11.5 kW	26 kW

Article No.	Article Description	QTY
5483 3000	HEAT-SHRINK TORCH SET 3000	1

## Scope of delivery:

- Handle
- Hot shrink burner 28 mm, 38 mm, 50 mm
- Standard burner
- Safety pressure regulator
- Propane hose 4 m
- 2x Spanners 17 x 19
- Steel case



## High Pressure Hose 6.3 x 5 mm

- Propane high pressure hose according to EN 559 6.3 x 5 mm, frost-resistant up to approx. -30 °C
- Operating pressure up to 4 bar

### Technical Data

<b>Art.-No.:</b>	<b>5483 4 5</b>	<b>5483 4 10</b>
<b>Connection:</b>	R 3/8" li x R 3/8" li	R 3/8" li x R 3/8" li
<b>Length:</b>	5 m	10 m
<b>Weight:</b>	1700 g	2610 g



Article No.	Article Description	QTY
5483 4 5	HIGH PRESS.HOSE 6.3X5 MM 5M	1
5483 4 10	HIGH PRESS.HOSE 6.3X5 MM 10M	1

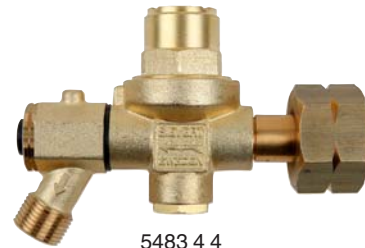
## Pressure Regul. w. Integrated Hose Breakage Protec

- with integrated hose breakage protection
- Art.-No.5483 4 4: for working below ground with leakage gas test equipment
- Art.-No. 5483 4 1 4: with stepless adjustable working pressure of 1 - 4 bar

### Technical Data

<b>Art.-No.:</b>	<b>5483 4 4</b>	<b>5483 4 1 4</b>
<b>Bottle connection:</b>	DIN Kombi	DIN Kombi
<b>Hose connection:</b>	R 3/8" li	R 3/8" li
<b>Operating pressure:</b>	4 bar	1-4 bar
<b>Max. flow capacity:</b>	12 kg/h	5-12 kg/h
<b>Weight:</b>	500 g	430 g

Article No.	Article Description	QTY
5483 4 4	PRESSURE REGULATOR HRV 4 BAR	1
5483 4 1 4	PRESSURE REGULATOR HRV 1-4 BAR	1



5483 4 4



5483 4 1 4

## Multi-Bottle Connector

- By connecting the adaptor, in conjunction with the hose piece, two or more 5 kg, 11 kg or 33 kg gas bottles can be connected

Article No.	Article Description	QTY
5483 4 2	MULTI-BOTTLE CONNECTOR PIECE	1
5483 4 2 1	MULTI-BOTTLE HOSE LINE	1



# Soft Soldering Iron

- High quality soft soldering capacity for high flame stability, even when windy
- Hose connection turns to prevent the hose from twisting
- Classical air slide for precisely regulating the flame from soft to hard
- Very good to operate, particularly when soldering gutters (soft soldering)
- Ergonomic shaped two-component handle for comfort when handling



Technical Data	
Art.-No.:	5483 5 1
Hose connection:	3/8" li
Gas consumption at 1.5 bar:	130 g/h
Weight:	415 g

Article No.	Article Description	QTY
5483 5 1	SOFT SOLDERING IRON 3/8"	1

# Support for Soft Soldering Iron

Article No.	Article Description	QTY
5483 5 2	SUPPORT F. SOFT SOLDERING IRON	1

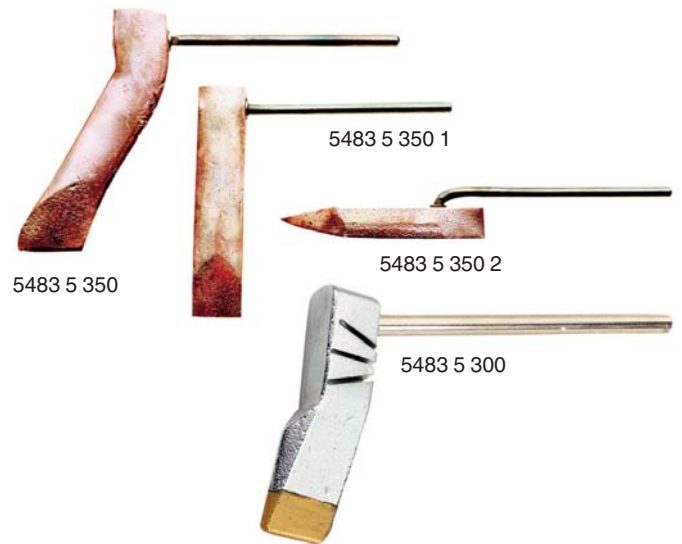


# Copper Piece for Soft Soldering Iron

**Art.-No. 5483 5 300:**

- Long life copper piece with special coating
- no re-forging
- no re-filing

Technical Data				
Art.-No.:	5483 5 350	5483 5 350 1	5483 5 350 2	5483 5 300
Shape:	hammer shape	hammer shape, straight	conical	hammer shape
Weight:	350 g	350 g	350 g	300 g



Article No.	Article Description	QTY
5483 5 350	COP.PIECE RO.HAMMER SHAPE 350G	1
5483 5 350 1	COP.PIECE STR.HAMMER SHAPE350G	1
5483 5 350 2	COPPER PIECE POINT. SHAPE 350G	1
5483 5 300	COPPER PIECE 300GR LONG LIFE	1

# Ammonium Chloride Block 65 x 45 x 40

- To clean copper top pieces
- For wetting the copper top pieces

Article No.	Article Description	QTY
5483 5 16	AMMON. CHLORIDE BLOCK 65X45X40	1



## High Pressure Hose 4 x 4 mm

- Propane high pressure hose as per EN 559, 4 x 4 mm, frost resistant to approx. -30 °C
- Working pressure up to 2 bar

### Technical Data

<b>Art.-No.:</b>	<b>5483 5 3</b>	<b>5483 5 3</b>
<b>Attachment:</b>	R 3/8" li x R 3/8" li	R 3/8" li x R 3/8" li
<b>Length:</b>	3 m	5 m
<b>Weight:</b>	780 g	1.130 g



Article No.	Article Description	QTY
5483 5 3	HOSE KIT 4X4MM 3M	1
5483 5 5	HOSE KIT 4X4MM 5M	1

## Gas Bottle 0.425 kg, Refillable

- Refillable propane gas bottle
- Protected against corrosion inside, varnished on the outside
- Approved design with safety valve against excess pressure
- Complete with valve and hook
- Hose attachment: Left threaded R 3/8"
- **Please note: Gas bottle is delivered empty!**

### Technical Data

<b>Height:</b>	30 cm
<b>Ø:</b>	8.5 cm
<b>Gas contents:</b>	0.42 kg
<b>Weight:</b>	1.72 kg

Article No.	Article Description	QTY
5483 5 6	GAS BOTTLE 0.425 KG RE-FILLAB.	1



## Wooden Case for Soft Soldering Unit

- Very stable wooden case with metal fittings and steel angles completely reinforced
- Enables your soldering machine to be transported safely
- Pre-assembled soldering machines are permitted to be transported in cars with a ventilation system

Article No.	Article Description	QTY
5483 5 10	WOOD.CASE F.SOFT SOLDER. UNIT	1



## Filling Nozzle for Gas Bottle

- For filling the 5 kg and 11 kg gas bottle for small bottle 0.425 kg
- Connection thread: left thread R 3/8"

### Technical Data

<b>Connection:</b>	household x 3.8 le
<b>Weight:</b>	157 g



Article No.	Article Description	QTY
5483 5 7	FILL. NOZZLE F.GAS BOTTLE 3/8"	1

## Rotating Coupling 3/8"

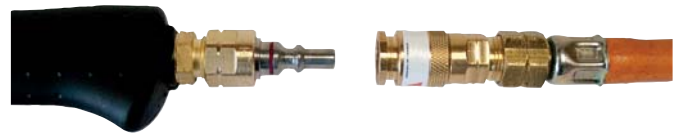
- Prevents the high pressure hose from twisting



Article No.	Article Description	QTY
5483 4 38	ROTATING COUPLING 3/8"	1

## Plug-In Connector 3/8"

- Quick to release and connect
- Manufactured according to EN561, ISO 7289
- Approved for attaching to consumer appliances and for using with propane gas
- Double-sealed, better protection against dust and dirt
- Plug-in nipple made from stainless steel
- Connection: 3/8" left-hand thread



Article No.	Article Description	QTY
5483 4 3	PLUG-IN CONNECTOR 3/8" TORCH	1

## Plug-In Connector 3/8"

- Quick to release and connect
- Manufactured according to EN561, ISO 7289
- Approved for attaching to consumer appliances and for using with propane gas
- Double-sealed, better protection against dust and dirt
- Plug-in nipple made from stainless steel
- Connection: 3/8" left-hand thread



Article No.	Article Description	QTY
5483 4 38 1	PLUG-IN CONNECTOR 3/8"	1

## Plug-In Nipple 3/8"

- Quick to release and connect
- Manufactured according to EN561, ISO 7289
- Approved for attaching to consumer appliances and for using with propane gas
- Double-sealed, better protection against dust and dirt
- Plug-in nipple made from stainless steel
- Connection: 3/8" left-hand thread



Article No.	Article Description	QTY
5483 4 38 2	PLUG-IN NIPPLE 3/8"	1

## Soft Soldering Set Titanium with Copper Piece

- Complete set incl. soldering iron, bent and hammer-shaped copper piece 350 g, pressure regulator, gas bottle and high pressure hose
- **Warning! Gas bottle is delivered empty**

### Technical Data

Hose length:	2 m
Connection:	3/8" li
Weight:	2.400 g

Article No.	Article Description	QTY
5483 5 8	SOFT SOLD.SET HAMMER SHAPE350G	1



## Soft Soldering Set Titanium w. Conical Copper Piece

- Complete set incl. soldering iron, bent and conical copper piece 350 g, pressure regulator, gas bottle and high pressure hose
- **Warning! Gas bottle is delivered empty**

### Technical Data

Hose length:	2 m
Connection:	3/8" le
Weight:	2.400 g

Article No.	Article Description	QTY
5483 5 9	SOFT SOLD.SET POINT. SHAPE350G	1



## Cartridge Soldering Iron Set

### Technical Data

Gas consumption at 2 bar:	75 g/h
Power, kW:	945 W
Length:	230 mm
Handle Ø:	50 mm
Weight:	810 g

Article No.	Article Description	QTY
5483 6 1	CARTRIDGE SOLDERING IRON SET	1

### Contents:

- 1x Art.-No. 5483 6: Cartridge soldering iron
- 1x Metal transport case
- 2x Art.-No. 5483 6 60: Gas cartridges
- 1x Art.-No. 5483 5483 6 250 1: Copper piece (250 g)
- 2x Replacement gas nozzles



## Cartridge Welding Iron with Piezo Ignition

- Integrated piezo ignition
- Highly mobile due to use of cartridges
- Ergonomically shaped handle
- Particularly wind-resistant due to special design of the torch and housing
- Low weight due to use of titanium and aluminium and therefore reduced signs of fatigue
- No flicker effect - possible to use the soldering iron in all positions (360°)
- Supplied without copper piece and cartridge



Article No.	Article Description	QTY
5483 6	CARTR.WELD.IRON (NO COP.PIECE)	1

## Copper for Cartridge Welding Iron

### Technical Data

Art.-No.:	5483 6 250	5483 6 250 1
Copper piece.:	conical	hammer shape
Weight:	250 g	250 g

Article No.	Article Description	QTY
5483 6 250	POINTED COPPER PIECE 250G	1
5483 6 250 1	HAMMER SHAP.COPPER PIECE 250G	1



## Gas Cartridges for Cartridge Welding Iron

- Special gas mixture consisting of propane, butane, acetone and propene
- Flame temperature approx. 2100°C

### Technical Data

Connection:	EU
Weight:	110 g
Contents:	60 g
Contents:	210 ml

Article No.	Article Description	QTY
5483 6 60	GAS CARTR.F.CARTR.WELD.IRON60G	e 12



# Soldering Gun Powerjet

- The professional and light-weighted soldering lamp for hard-, soft soldering and warming up works
- For the usage with gas cartridges for Powerjet
- Stepless gas regulation
- With piezo ignition
- Can be also used in combination with Sievert Powergas



## Technical Data

<b>Working pressure:</b>	2 bar
<b>Torch diameter:</b>	14 mm
<b>Weight:</b>	1,005 g

Article No.	Article Description	QTY
5483 7	POWERJET F.GAS CARTRIDGE 2205	1

## Contents:

- 1x PowerJet Ultra burner head
- 1x Art.-No. 5483 7 1: PowerJet cyclone burner
- 1x Art.-No. 5483 7 210: gas cartridge Ultragas

# Cyclone Torch for Powerjet

- For hard and soft soldering
- Powerful whirling flame enables the pipe to be evenly warmed by soldering
- Quick and effective heating of the pipe is guaranteed

## Technical Data

<b>Burner Ø:</b>	14 mm
<b>Gas consumption at 2 bar:</b>	170 g/h
<b>Power:</b>	2.2 kW
<b>Soft soldering at 2 bar:</b>	Ø 40 mm
<b>Hard soldering at 2 bar:</b>	Ø 18 mm



Article No.	Article Description	QTY
5483 7 1	CYCLONE TORCH FOR POWERJET	1

# Heat-Shrink Burner for Powerjet

- Wind-resistant torch
- Special shrinking torch for small shrinking hoses
- Can also be used as soft soldering torch

## Technical Data

<b>Burner Ø:</b>	24 mm
<b>Gas consumption at 2 bar:</b>	230 g/h
<b>Power:</b>	Ø 3.5 kW
<b>Soft soldering at 2 bar:</b>	Ø 22 mm



Article No.	Article Description	QTY
5483 7 2	HEAT-SHRINK BURNER F.POWERJET	1



# Disposable Gas Cartridge for Powerjet

- Flame temperature approx. 2100°C
- Disposable gas cartridge with self-closing vent
- Powerful gas mixture of propane, propene, butane and acetone
- Flame is quiet and does not flicker, highly stable

## Technical Data

<b>Weight:</b>	337 g
<b>Contents:</b>	210 g
<b>Contents:</b>	380 ml

Article No.	Article Description	QTY
5483 7 210	GAS CARTRIDGE F.POWERJET 210G	e 20



# Hot-Spot Mini Gas Torch

- Self-igniting through piezo ignition
- Safety lock
- Flame temperature up to +1,300 °C

**Applications:**

- For small soldering work, solder heat shrink connectors, shrink hoses, etc.

**Art.-No. 5482 50:**

- Art.-No. 5482 50 1: Empty lighter included in delivery scope



Article No.	Article Description	QTY
5482 50	HOT-SPOT MINI GAS TORCH	1
5482 50 1	LIGHTER EMPTY F.HOT-SPOT MINI	1

# Hot-Spot Gas Torch

- Self-igniting with piezo ignition
- Safety lock
- Base
- Flame temperature up to +1,300 °C
- With gas tank
- Interlock for pilot flame
- Continuous gas regulation
- Dimensions (L x W x H): 100 x 70 x 155mm



Article No.	Article Description	QTY
5482 2	HOT-SPOT GAS TORCH	1
5482 20	LIGHTER GAS 100ML	5

# Power-Spot

- Compact easy-to-use professional gas torch
- Flame temperature approx. 1,800 °C
- Self-igniting with piezo ignition
- Exchangeable burner nozzles for different usages
- Interlock for pilot flame
- Continuous gas regulation
- Burning time per cartridge approx. 4 hours Power Spot



Article No.	Article Description	QTY
5482 60	POWER-SPOT SET	1
5482 63	POWER-SPOT GAS CARTRIDGE 600ML	e 12

**Contents Art. No. 5482 60:**

- Power-spot gas torch
- Standard burner nozzle
- Gas cartridge

# Power-Spot Parts

**Art.-No. 5482 61:**

- Supplies hot air for removing paint and for light shrinking work, etc.

Technical Data		
Art.-No.	Soft soldering of copper pipes with Ø [mm]	Hard soldering of copper pipes with Ø [mm]
5482 65	10	-
5482 64	18	-

- Art.-No. 5482 62 nozzle: only suitable for burning tubes
- Art.-No. 5482 65 and 5482 66

Article No.	Article Description	QTY
5482 61	POWER-SPOT SOLDER TIP	1
5482 62	POWER-SPOT SOLDER TOP	1
5482 64	POWER-SPOT STAND.BURN.NOZZLE	1
5482 65	POW-SPOT POINT.FLA.BURN.NOZZLE	1



# Cartridge - Soldering Device

- Cartridge - soldering device with high-performance burner and base made of metal

**Art.-No. 5482 2000:**

- Cartridge- soldering device with piezo-ignition
- **Caution: This soldering device may only be used with a standard high-performance burner! The burner accessory set with article number 5482 3000 1 is not applicable!**

### Technical Data

Flame temperature:	approx. 1700°C
Processing temperature:	approx. 650°C

Article No.	Article Description	QTY
5482 3000	CARTRIDGE-SOLD.DEVICE MET.BODY	1
5482 2000	CARTR.-SOLD.DEV.W.PIEZO-IGNIT.	1



5482 3000



5482 2000

## Cartridge-Soldering Device Accessories

Article No.	Article Description	QTY
5482 3000 1	BURNER-ACCESSORY-SET 3-PART	1
5482 2000 2	BUTAN-STECHKARTUSCHE GS 190G	e 36



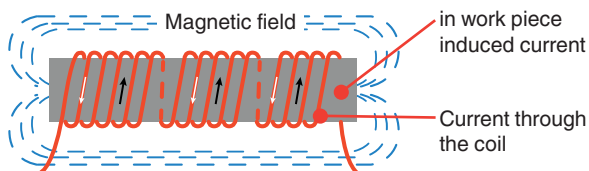
5482 300 1



5482 2000 2

# Induction heater F-1200

- Induction heating is a quick, efficient, accurate and contact-free method of heating metals and other electrically conducting materials
- Microprocessor-controlled induction cycle and sensor-controlled cooling with overrunning fan
- Innovative clamping mechanism eliminates the need for tools when changing induction lines and ensures a secure connection



#### Technical Data

Supply voltage:	230 V / 50 – 60 Hz
Fuse (slow-acting)	16 A
Power:	1,200 W
Switching stages:	6
Operating temperature:	5 °C to +40 °C
Protection class:	IP 20

Article No.	Article Description	QTY
5463 120 5	INDUCTION HEATER F-1200 SET	1

#### Material supplied:

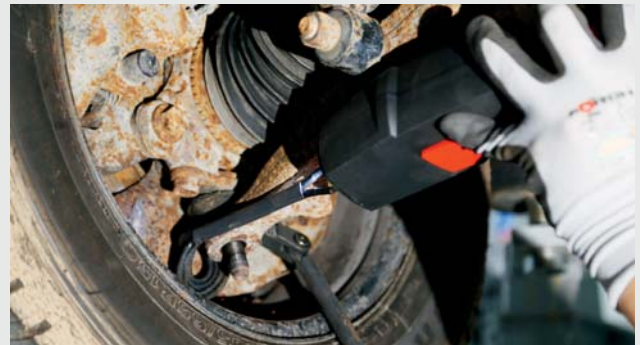
- 1x induction heater F-1200
- 1x induction coil Ø 18 mm L 150 mm
- 1x induction coil Ø 23 mm L 150 mm
- 1x induction line, flexible L 1.100 mm
- 1x induction line, can be shaped L 600 mm

## Your Advantage / Benefit

- Mobile and flexible in practice
- Safe heating without naked flames
- High capacity of 1,200 Watt
- Heating time and power can be adjusted incrementally
- Integrated LED light
- Induction coils in various sizes

## Application

- Ideal for releasing rusted and seized connections
- Shrink fitting and removal of metal components such as bolts, steering knuckles, tie rods, bearings, etc.
- Removal of decorative strips, bumpers, stickers, coatings and underfloor protection



# Accessories for F-1200 induction heater



5463 120 10

5463 120 10 10  
5463 120 10 11

5463 120 10 9

5463 120 10 12

5463 120 10 13

## Technical Data

Art.-No.	Wire Ø	Inner Ø	Coils	Length	Heat resistance
5463 120 10 1	3,5 mm	18,0 mm	3,5	150,0 mm	250 °C
5463 120 10 2	3,5 mm	23,0 mm	3,5	150,0 mm	250 °C
5463 120 10 3	3,5 mm	23,0 mm	3,5	250,0 mm	250 °C
5463 120 10 4	3,5 mm	26,0 mm	3,5	200,0 mm	250 °C
5463 120 10 5	3,5 mm	32,0 mm	3,5	200,0 mm	250 °C
5463 120 10 6	3,5 mm	40,0 mm	3,5	200,0 mm	250 °C
5463 120 10 7	3,5 mm	47,0 mm	3,5	240,0 mm	250 °C
5463 120 10 8	3,5 mm	52,0 mm	3,5	240,0 mm	250 °C
5463 120 10 9	3,5 mm	–	–	600,0 mm	250 °C
5463 120 10 10	3,5 mm	–	–	1.100,0 mm	450 °C
5463 120 10 11	3,5 mm	–	–	2.000,0 mm	450 °C
5463 120 10 12	3,5 mm	70,0 mm	–	250,0 mm	250 °C
5463 120 10 13	3,5 mm	55,0 mm	4,0	200,0 mm	450 °C

Article No.	Article Description	QTY
5463 120 10	INDUCTION COIL SET 6-PCE	1
5463 120 10 1	INDUCTION COIL Ø 18MM L 150MM	1
5463 120 10 2	INDUCTION COIL Ø 23MM L 150MM	1
5463 120 10 3	INDUCTION COIL Ø 23MM L 250MM	1
5463 120 10 4	INDUCTION COIL Ø 26MM L 200MM	1
5463 120 10 5	INDUCTION COIL Ø 32MM L 200MM	1
5463 120 10 6	INDUCTION COIL Ø 40MM L 200MM	1
5463 120 10 7	INDUCTION COIL Ø 47MM L 240MM	1
5463 120 10 8	INDUCTION COIL Ø 52MM L 240MM	1
5463 120 10 9	INDUCT.LINE MALLEABLE L600MM	1
5463 120 10 10	INDUCT.LINE MALLEABLE L1100MM	1
5463 120 10 11	INDUCT.LINE FLEXIBLE L2000MM	1
5463 120 10 12	INDUCT.PAD 100X100MM	1
5463 120 10 13	INDUCTION COIL BALL HEADS	1

### Scope of delivery Art.-No.: 5463 120 10

- 1× 5463 120 10 3 Induction coil Ø 23 mm L 250 mm
- 1× 5463 120 10 4 Induction coil Ø 26 mm L 200 mm
- 1× 5463 120 10 5 Induction coil Ø 32 mm L 200 mm
- 1× 5463 120 10 6 Induction coil Ø 40 mm L 200 mm
- 1× 5463 120 10 7 Induction coil Ø 47 mm L 240 mm
- 1× 5463 120 10 8 Induction coil Ø 52 mm L 240 mm

# Welding Unit Minarc Evo 180 **FÖRCH**\*\*\*\*\*

- For rod electrodes and TIG with contact ignition (Lift-Arc)
- Superior welding performance thanks to advanced inverter technology
- PFC technology for high efficiency and lower energy consumption
- Automatic arc force control (welding dynamics) for excellent arc stability in all positions
- Large, clear gauge making it easy to accurately set the current

## Your Advantage / Benefit

- Powerful, portable and compact
- Can be used with all types of electrodes up to 4 mm
- High current output and duty cycle
- Can be controlled directly or remotely
- Can be used with long power cable to the mains or generator

## Application

- For MMA and TIG welding of steel, stainless steel, galvanized material, aluminium and cast materials e.g. agriculture, forestry, assembly, metal working, railings, etc.



Article No.	Article Description	QTY
5460 18	WELDING UNIT MINARC EVO 180	1

### Scope of delivery:

- 1 x Art.-No. 5460 1 1 Earth cable
- 1 x Art.-No. 5460 1 2 Electrode holder
- 1 x Art.-No. 5460 1 3 Carry strap

### Technical Data

<b>Power supply:</b>	3~50 / 60 Hz	230 V ± 15 %
<b>Power consumption:</b>	MMA	max. 5.7 kVA (170 A / 26.8 V)
	WIG	max. 4.0 kVA (180 A / 17.2 V)
<b>Connection cables:</b>	H07RN-F	3G1.5 (1.5 mm, 3 m)
<b>Slow-acting fuse</b>	Typ C	16A
<b>Capacity+40 °C:</b>	30 % ED MMA	170 A / 26.8 V
	100 % ED MMA	115 A / 24.6 V
	35 % ED WIG	180 A / 17.2 V
	100 % ED WIG	130 A / 15.2 V
<b>Welding range:</b>	MMA	10V / 170 A-32 V / 180 A
	WIG	10V / 180A – 30 V / 180 A
<b>Open-circuit voltage:</b>	Average	90 V (VRD 30 V)
<b>Open-circuit current:</b>		30 W
<b>Power factor 100 % ED</b>		0.99
<b>Efficiency 100 % ED</b>	MMA	0.84 %
<b>Electrodes:</b>		1.5 – 4.0 mm
<b>Protection class:</b>		IP 23S
<b>Dimensions:</b>	L x W x H	361 x 139 x 267 mm
<b>Weight:</b>		5.85 kg
<b>Standards</b>		IEC 60974-1 IEC 60974-10 IEC 61000-3-12

# Minarc 150 Welding Machine Accessories



5460 1 1



5460 1 2



5460 1 3



5460 1 4



5460 7 3

Article No.	Article Description	QTY
5460 1 1	GROUND CABLE W/CLIP F.M150	1
5460 1 2	WELDING CABLE W/ELECT.HLDR	1
5460 1 3	SHOULDER STRAP	1
5460 1 4	TIG BURNER TTM 15V 4M	1
5460 7 3	REMOTE CONTROL R10 5M	1

# MMA/TIG 180 welding tool

- Powerful electrode welding inverter
- Simple control panel with analogue control dials
- For all common steel, stainless steel and cast iron electrodes with rutile or basic coating

**MMA welding modes:**

- The device has three special functions to improve welding properties
- **Hot start** increases the welding current for igniting the electrodes
- **Arc force** prevents the electrodes sticking when they are dipped in the weld pool
- **Anti=stick** switches off the power to prevent the electrodes overheating if they stick as mentioned above

**WIG welding:**

this device has optional accessories that enable WIG welding with contact ignition.



## Your Advantage / Benefit

- Ultra compact and light with a carry handle for easy transport
- Can be used with a generator and has overvoltage protection up to 400 V

## Application

- For industrial maintenance work in the workshop and on construction sites

**Technical Data**

<b>Supply voltage:</b>	1-50/60 Hz 230 V
<b>Slow-blow fuse:</b>	Type C 16 A
<b>Power output 40°C (MMA):</b>	25 % 180 A
	60 % 120 A
	100 % 85 A
<b>Power output 40°C (WIG):</b>	27 % 200 A
	60 % 140 A
	100 % 115 A
<b>No-load voltage:</b>	72 V
<b>Diameter of E-hand electrodes:</b>	1.6 - 4.0 mm
<b>Protection class:</b>	IP 21
<b>Machine weight:</b>	5 kg
<b>Dimensions (L x W x H):</b>	270 x 140 x 180 mm
<b>Case dimensions (L x W x H):</b>	420 x 370 x 170 mm
<b>Can be used with a generator, minimum output:</b>	7 kW
<b>Standards:</b>	EN 60974-1:2012
	EN 50445:2008
	EN 60974-10:2014 / A1:2015
	EN 50581:2012

Article No.	Article Description	QTY
5460 1 180	WELDING UNIT MMA/TIG 180A	1

**Delivery includes:**

- Earth cable 1.6 m, 16 mm<sup>2</sup>
- Electrode holder 2 m, 16 mm<sup>2</sup>
- Hard shell case

**Optional cable assembly for WIG welding:**

- Art.-No. 5458 17 400 1: Cable assembly TSP17V 4 m

# Welding unit MMA / TIG 180 set

**Contents:**

Article No.	Article Description	Quantity
5400 80	WELD.HAND PROTECTION SHIELD	1
5400 80 2	SAFETY LENS CLEAR 90X110MM	1
5400 80 3	SAFETY LENS GREEN A9 90X110MM	1
5405 8 10	WELD.GLOVES CALF LEATH.SIZE10	1
5451 25 350 10	PK(5KG)ELECTRODE RC 3 2.5	1
5459 400	CHIPPING HAMM.STEEL HANDLE400G	1
5460 1 180	WELDING UNIT MMA/TIG 180A	1
5850 3	HAND-WIRE BRUSH 3-ROW STEEL	1
9003 4	VAROBOXX SIZE:4 EMPTY	1



Article No.	Article Description	QTY
5460P 2	WELDING UNIT SET MMA/TIG 180A	1



# MMA/TIG 200 welding tool

- Microprocessor-controlled electrode welding inverter
- Simple membrane control panel with clear digital display
- Power factor correction filter (PFC) and automatic mains voltage adaptation (flexible voltage, FV) for efficient, effective use of mains power
- For all common steel, stainless steel and cast iron electrodes with rutile or basic coating
- Also suitable for WIG welding

**MMA welding modes:**

- The device has three special functions to improve welding properties
- **Hot start** increases the welding current for igniting the electrodes
- **Arc force** prevents the electrodes sticking when they are dipped in the weld pool
- **Anti-stick** switches off the power to prevent the electrodes overheating if they stick as mentioned above

**WIG welding modes:**

- **WIG lift** facilitates ignition without contamination of the weld seam by the wolfram electrodes
- **ADS** automatic slope down function with timer



## Your Advantage / Benefit

- Ultra compact and light with a carry handle for easy transport
- Can be used with a generator and has overvoltage protection up to 400 V

## Application

- For industrial maintenance work in the workshop and on construction sites

Technical Data	
<b>Supply voltage:</b>	1~50/60 Hz 230 V
<b>Slow-blow fuse:</b>	Type C 16 A
<b>Power output 40°C (MMA):</b>	20 % 200 A
	60 % 120 A
	100 % 90 A
<b>Power output 40°C (WIG):</b>	27 % 200 A
	60 % 145 A
	100 % 117 A
<b>No-load voltage:</b>	96 V
<b>Diameter of E-hand electrodes:</b>	1.6 - 5.0 mm
<b>Protection class:</b>	IP 23 S
<b>Machine weight:</b>	5.5 kg
<b>Dimensions (L x W x H):</b>	270 x 140 x 210 mm
<b>Case dimensions (L x W x H):</b>	420 x 370 x 170 mm
<b>Can be used with a generator, minimum output:</b>	7 kW
<b>Standards:</b>	EN 60974-1:2012
	EN 50445:2008
	EN 60974-10:2014 / A1:2015
	EN 50581:2012

Article No.	Article Description	QTY
5460 1 200	WELDING TOOL MMA/TIG 200A	1

**Delivery includes:**

- Earth cable 1.6 m, 25 mm<sup>2</sup>
- Electrode holder 2 m, 25 mm<sup>2</sup>
- Hard shell case

**Optional cable assembly for WIG welding:**

- Art.-No. 5458 17 400 1: Cable assembly TSP17V 4 m

## Accessoires MMA / TIG 180 / 200



5460 103



5460 104



5458 17 400 1

Article No.	Article Description	QTY
5460 103	ELECTRODE HOLDERS 25QMM 4M	1
5460 104	EARTHING CABLE PICOMIG 180	1

Article No.	Article Description	QTY
5458 17 400 1	HOSE SET TSP17V 4M	1

# Welding Apparatus Minarc TIG EVO 200

- For DC- WIG welding of steel and stainless steel and E-hand welding (special accessories)
- 200 amps
- User-friendly LED display for the configuration
- HF-ignition / contact ignition can be precisely selected
- Retrievable welding functions such as gas pre- and post flow time control , current up-slope and down-slope time
- Various remote control options
- 2-cycle or 4-cycle burner control
- Designed for use with long power cable over 100m (3 x 2.5mm<sup>2</sup>) or with a generator (synchronised)



## Technical Data

<b>Supply voltage:</b>	1~50/60 Hz	230 V +/- 15 %
<b>installed power:</b>	35 % ED (WIG)	200 A/4,9 kVA
	35 % ED (E-Hand)	170 A/5,7 kVA
<b>Supply current:</b>	WIG	21,1 A
	E-Hand	24,8 A
<b>Safety straps:</b>	Type C	16 A
<b>Power output 40 °C:</b>	WIG	35 % ED 200 A/18,0 V 100 % ED 110 A /24,4 V
	E-Hand	35 % ED 170 A/26,8 V 100 % ED 110 A/24,4 V
<b>Welding current range:</b>	WIG	5 A/10,2 V – 200 A/18,0 V 10 A/20,4 V – 170 A/26,8 V
<b>Open circuit voltage:</b>	E-Hand	95,0 V; VRD 30,0 V
<b>Arc striking voltage:</b>	Average	6 – 12 kV
<b>E-Hand electrodes Ø:</b>		1,5 – 4,0 mm
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		11 kg
<b>Dimensions (L x W x H):</b>		449 x 210 x 358 mm
<b>can be used w.a generator, min.output</b>		IEC 60974-1
<b>Standards:</b>		IEC 60974-3 IEC 60974-10 IEC 6100-3-12

Article No.	Article Description	QTY
5460 60	MINARC WELD.MACH.TIG EVO 200	1

## Scope of delivery:

- 1x Art.-No. 5460 9 2: WIG torch TTC 220, 4 m
- 1x Art.-No. 5460 6 2: earthing cable with clamp, 5 m
- 1x Art.-No. 5460 2 3: protection gas hose, 4.5 m
- 1x Art.-No. 5460 1 3: straps

# MasterTIG MLS 2300 ACDCWelding Machine

- For professional WIG welding of steel, stainless steel and aluminium
- 230 Volt
- 230 Ampere
- High-frequency contact firing
- Can be adjusted to stick electrode - welding (special accessory)
- One-knob operation for all welding-function/parameters
- Water cooling possible (special accessory)
- Highly impact-resistant plastic housing
- Without panel, hose package and ground cable



## Technical Data

<b>Supply voltage:</b>	1~ 50/60 Hz	230 V +/- 15 %
<b>Connected load:</b>	40 % MMA	6,0 kVA / 180 A
	60 % MMA	4,8 kVA / 150 A
	100 % MMA	3,7 kVA / 120 A
	40 % WIG	5,7 kVA / 230 A
	60 % WIG	4,8 kVA / 200 A
	100 % WIG	3,9 kVA / 170 A
<b>Connection cable:</b>		3x 2.5 mm <sup>2</sup> , 3.3 m long
<b>Fuse inert:</b>		16 A
<b>Plug:</b>		Schuko
<b>Welding area:</b>	MMA	10 A / 20,5 V – 180 A / 27,2 V
	WIG	3 A / 10 V – 230 A / 19,2 V
<b>Max. welding voltage:</b>	MMA	32 V / 180 A
<b>Operation factor:</b>		58 V DC
<b>Utilization rate at nominal value:</b>	MMA	0,99
	WIG	0,99
<b>Power coefficient at nominal value:</b>	MMA	99 %
	WIG	99 %
<b>Electrode-Ø:</b>	MMA	1,5 – 4,0 mm
<b>Protection class:</b>		IP23C
<b>Weight:</b>		15 kg
<b>Dimensions (L x W x H):</b>		430 x 180 x 390 mm
<b>can be used w. a generator, min.output</b>		IEC 60974-1
<b>Standards:</b>		IEC 60974-4
		IEC 60974-10
		IEC 61000-3-12

Article No.	Article Description	QTY
5460 9	MASTERTIG MLS 2300 WEL.MACHINE	1

### Scope of delivery (without hose package):

- 1x Art.-No. 5460 1 3: Shoulder strap

- 1x gas hose, 1.5m

### matching hose package:

- Art.-No. 5460 9 2: WIG Burner TTC 220 4m FÖRCH 5\*

### Optional water cooling:

- Art.-No. 5460 9 4: Mastercool 20 water cool.device FÖRCH 5\*

### matching hose package for water cooling:

- Art.-No. 5460 9 3: WIG Burner TTC 250W 4m FÖRCH 5\*

# Accessories: MasterTIG MLS 2300 ACDC Welder

**Art.-No. 5460 9 1 ACS Panel:**

- Current
  - MMA: AC, DC-, DC+
  - WIG: AC, MIX, DC-, DC+
- Gas pre and post-arc current
- Starting current, increasing and decreasing current time
- Current and voltage display, welding parameter displays
- Quick Setup
- 2/4 step operation (keypad function for burner)
- High frequency and contact ignition
- Selection of remote controlling and setting of welding current range (LO/Hi)
- Tester for function for water cooling system
- Tester for function for gas (Gas Test)

**Art.-No. 5460 9 1 1 ACX Panel equal to Art. No. 5460 9 1 includes:**

- 4 step T-Log and Minilog keyboard function
  - Start, Minilog and end crater current
  - Spot timer
  - Long pulse
  - Synergistic quick pulse
  - Memory 10 channels
- Art.-No. 5460 9 4 Water cooling device Mastercool 20:**
- Supply voltage: 230 V +/- 15 %
  - Cooling performance: 1.0 kW
  - Max. pressure: 4.0 bar
  - Recommended cooling fluid: 20 - 40 % ethanol/water
  - Tank contents: 3 litres
  - Dimensions L x W x H: 500 x 180 x 260 mm
  - Weight: 8 kg



5460 9 1



5460 9 1 1



5460 9 3



5460 9 4



5460 9 5

Article No.	Article Description	QTY
5460 9 1	ACS PANEL FOR MLS 2300	1
5460 9 1 1	ACX PANEL FOR MLS 2300	1
5460 9 3	WIG BURNER TTC 250W 4M	1

Article No.	Article Description	QTY
5460 9 4	MASTERCOOL20 WATER COOL.DEVICE	1
5460 9 5	TROLLEY T200 FOR MLS 2300	1

# Minarc TIG 200 Welding Machine Accessories



5460 6 3



5460 6 2



5460 9 2



5460 2 3



5460 6 5



5460 7 3



5460 9 6



5460 9 7

Article No.	Article Description	QTY
5460 6 3	W.CABLE.W/ELECT.HLDR F.TIG180	1
5460 6 2	GROUND CABLE 16MM <sup>2</sup> 5M	1
5460 9 2	WIG BURNER TTC 220W 4M	1
5460 2 3	INERT GAS HOSE 4.5M	1

Article No.	Article Description	QTY
5460 6 5	FOOT REM.CONTR.R11F F.TIG180	1
5460 7 3	REMOTE CONTROL R10 5M	1
5460 9 6	RTC 10 POTI-REGUL.F.TTC BURNER	1
5460 9 7	RTC20 UP-DOWN REGUL.F.TTC BUR.	1

# TIG PULSE 200 welding tool

- Microprocessor-controlled WIG welding inverter with pulse function
- Simple control panel with clear digital display including five memory locations
- Contactless HF ignition or WIG lift contact ignition
- Three different burn modes: 2-stroke/4-stroke/4-stroke LOG
- Power factor correction filter (PFC) and automatic mains voltage adaptation (flexible voltage, FV) for efficient, effective use of mains power

**WIG welding modes:**

- **WIG** Control of pre-gas and post-gas flow time, base current, slope up and slope down
- **WIG pulse** (Normal) main current, base current and frequency can be set manually
- **WIG pulse** (Easy) automatic control of main current, base current and frequency
- **WIG spot** for joining components quickly and easily (2 stroke mode)

**MMA welding modes:**

- Welds all common steel, stainless steel and cast iron electrodes with rutile or basic coating
- The device has three special functions to improve welding properties
- **Hot start** increases the welding current for igniting the electrodes
- **Arc force** prevents the electrodes sticking when they are dipped in the weld pool
- **Anti=stick** switches off the power to prevent the electrodes overheating if they stick as mentioned above



## Your Advantage / Benefit

- Easy to set welding parameters
- Ultra compact and light with a carry handle for easy transport
- Can be used with a generator and has overvoltage protection up to 400 V

## Application

- Ideal for repair and maintenance work on steel, stainless steel and copper

**Technical Data**

<b>Supply voltage:</b>	1-50/60 Hz	230 V
<b>Slow-blow fuse:</b>	Type C	16 A
<b>Power output 40°C (WIG):</b>	30% duty cycle	200 A
	60 % duty cycle	140 A
<b>Power output 40°C (MMA):</b>	100 % duty cycle	125 A
	100 % duty cycle	200 A
	100 % duty cycle	110 A
<b>Welding current range:</b>	20 % duty cycle	5 A-200 A
	60 % duty cycle	10 A - 200 A
<b>Pulse frequency:</b>	60 % duty cycle	0.2-20 Hz
<b>No-load voltage:</b>	cycle	76 V
<b>Diameter of E-hand electrodes:</b>	100 % duty cycle	1.6-5.0 mm
<b>Protection class:</b>	WIG	IP 23 S
<b>Weight:</b>	WIG	12 kg
<b>Dimensions (L x W x H):</b>	E-hand	420 x 150 x 310 mm
	WIG	7 kW
<b>Can be used with a generator, minimum output:</b>		
<b>Standards:</b>		EN 60974-1:2012
		EN 50445:2008
		EN 60974-10:2014 / A1:2015
		EN 60974-3:2014
		EN 50581:2012

Article No.	Article Description	QTY
5460 2 200	WELDING TOOL TIG PULSE 200A	1

**Delivery includes (no cable assembly):**

- WIG accessories set
- Earth cable 3 m, diameter 25 mm<sup>2</sup>
- Electrode holder 3 m, diameter 25 mm<sup>2</sup>
- Gas hose

**Suitable cable assemblies:**

- Art.-No. 5458 17 400: Cable assembly TSP17V 4 m
- Art.-No. 5458 17 800: Cable assembly TSP17V 8 m

# TIG PULSE AC/DC 200 welding tool

- Microprocessor-controlled WIG welding inverter with AC/DC and pulse function
- Simple control panel with clear digital display including five memory locations
- Contactless HF ignition or WIG lift contact ignition
- Three different burn modes: 2-stroke/4-stroke/4-stroke LOG
- Power factor correction filter (PFC) and automatic mains voltage adaptation (flexible voltage, FV) for efficient, effective use of mains power

## WIG welding modes:

- **WIG** Control of pre-gas and post-gas flow time, base current, slope up and slope down
- AC balance (20–60%) cleaning/weld penetration
- AC frequency to stabilise the arc (20–200 Hz)
- **WIG pulse** (Normal) main current, base current and frequency can be set manually
- **WIG pulse** (Easy) automatic control of main current, base current and frequency
- **WIG spot** for joining components quickly and easily (2 stroke mode)
- **Optional:** Welding inverter can also be combined with water cooling system

## MMA welding modes:

- Welds all common steel, stainless steel and cast iron electrodes with rutile or basic coating
- The device has three special functions to improve welding properties
- **Hot start** increases the welding current for igniting the electrodes
- **Arc force** prevents the electrodes sticking when they are dipped in the weld pool
- **Anti=stick** switches off the power to prevent the electrodes overheating if they stick as mentioned above



## Your Advantage / Benefit

- AC/DC for aluminium
- Easy to set welding parameters
- Ultra compact and light with a carry handle for easy transport
- Can be used with a generator and has overvoltage protection up to 400 V

## Application

- Ideal for repair and maintenance work on aluminium, steel, stainless steel and copper

### Technical Data

<b>Supply voltage:</b>	1~50/60 Hz	230 V
<b>Slow-blow fuse:</b>	Type C	16 A
<b>Power output 40°C (WIG):</b>	13 % duty cycle	200 A
	(AC)	95 A
	60 % duty cycle	80 A
	(AC)	160 A
<b>Power output 40°C (MMA):</b>	100 % duty cycle	95 A
	(AC)	80 A
	21 % duty cycle	160 A
	(DC)	95 A
<b>Welding current range: (WIG):</b>	60 % duty cycle	80 A
	(DC)	10 A – 200 A
	100 % (DC)	5 A – 160 A
<b>Pulse frequency (WIG):</b>	21 % duty cycle	0.2–2 Hz
	60 % duty cycle	0.2–20 Hz
	100 % duty cycle	10 A – 160 A
<b>Welding current range (MMA):</b>	100 % duty cycle	10 A – 160 A
<b>No-load voltage:</b>	AC	70 V
<b>Diameter of E-hand electrodes:</b>	DC	1.6–5.0 mm
<b>Protection class:</b>	AC	IP 23 S
<b>Weight:</b>	DC	19 kg
<b>Dimensions (L x W x H):</b>		390 x 200 x 360 mm
<b>Can be used with a generator, minimum output:</b>		6 kW
<b>Standards:</b>		EN 60974-1:2012 EN 50445:2008 EN 60974-10:2014 / A1:2015 EN 60974-3:2014 EN 50581:2012

Article No.	Article Description	QTY
5460 2 207	WELD.TOOL TIG PULSE AC/DC 200A	1

### Delivery includes (no cable assembly):

- WIG accessories set
- Earth cable 3 m, diameter 25 mm<sup>2</sup>
- Electrode holder 3 m, diameter 25 mm<sup>2</sup>
- Gas hose

### Suitable cable assemblies:

- Art.-No. 5458 26 400: Cable assembly TSP26HF 4 m
- Art.-No. 5458 26 800: Cable assembly TSP26HF 8 m

### Optional water cooling system:

- Art.-No. 5460 2 207 10: TIG PULSE AC/DC 200A cooling unit

### Suitable cable assemblies for the water cooling system:

- Art.-No. 5458 20 400: Cable assembly TSP20WK 4 m
- Art.-No. 5458 20 800: Cable assembly TSP20WK 8 m

Technical data subject to change.

Availability subject to country specific rules and regulations.

Source: Theo Förch GmbH & Co. KG

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## Accessoires TIG PUSLE 200 / AC/DC 200



5460 6 2



5460 6 3



5458 17 400  
5458 17 800  
5458 26 400  
5458 26 800

Article No.	Article Description	QTY
5460 6 2	GROUND CABLE 16MM <sup>2</sup> 5M	1
5460 6 3	W.CABLE.W/ELECT.HLDR F.TIG180	1
5458 17 400	HOSE PACKAGE TSP17HF 4M	1
5458 17 800	HOSE PACKAGE TSP17HF 8M	1
5458 26 400	HOSE PACKAGE TSP26HF 4M	1
5458 26 800	HOSE PACKAGE TSP26HF 8M	1

## Accessories for TIG PULSE AC/DC 200

Cooling system for TIG Pulse AC/DC 200

Enables the upgrading of your TIG device to a liquid-cooled welding system.

- Easy to operate and handle; can be filled with Art.-No. 6730 0999 Coragard CS 330 – special coolant
- Safety valves prevent the coolant from leaking out when the welding system is disconnected
- Independent mains connection allows the system to be switched off without problems when the welding unit is used with an air-cooled burner

### Technical Data

<b>Connection:</b>	230 V – 10 A – 50/60 Hz
<b>Capacity (coolant):</b>	1.5 l
<b>Max. pressure:</b>	6 bar
<b>Cooling power:</b>	400 W
<b>Dimensions (mm):</b>	420 × 199 × 178 mm
<b>Weight (unfilled):</b>	8.2 kg
<b>Standards:</b>	EN 60974-2: 2007



5460 2 207 10

Article No.	Article Description	QTY
5460 2 207 10	COOL.DEV.CHARG.TIG P.AC/DC200A	1
5458 20 400	HOSE PACKAGE TSP20WK 4M	1
5458 20 800	HOSE PACKAGE TSP20WK 8M	1

Specifications for use with TIG devices:

- max. 250 A
- max. dimensions 200 mm x 380 mm



5458 20 400  
5458 20 800



# Minarc MIG EVO 200 Welding Machine

- Suitable for MIG and MAG welding of steel, stainless steel, aluminium and filler wires, as well as for MIG soldering (after conversion of the cable assembly)
- 200 amperes
- Highest weld quality and precise arc striking, is monitored and controlled by an adaptive arc control system
- Large graphics display for configuration
- Automatic/manual operation
- Simple selection of materials, sheet thickness and seam shape
- Material selection includes iron, stainless steel, aluminium and also CuSi soldering wires in 1 kg and 5 kg reels
- Designed for use with a long power supply cable over 100 m (3 × 2.5 mm<sup>2</sup>) or a power generator (synchronous)



## Technical Data

<b>Supply voltage:</b>	1~50/60 Hz	230 V ± 15 %
<b>Power consumption:</b>	35 % duty cycle	200 A / 6.2 kVA
<b>Supply current:</b>	35 % duty cycle	26.2 A
	I 1max	13.2 A
<b>Slow-blow fuse:</b>	100 % duty	16 A
<b>Power output 40°C:</b>	cycle I 1eff	200 A/24 V
	Type C	120 A/20 V
<b>Welding current range:</b>	35 % duty cycle	20 A / 15 V – 200 A / 26 V
<b>No-load voltage:</b>	100 % duty	74 V
<b>Power factor at maximum current:</b>	cycle	0.99
<b>Efficiency at highest current:</b>		82 %
<b>Filler material Ø:</b>		0.6–1.0 mm
		0.8–1.0 mm
		0.8–1.0 mm
	Fe solid wire	1.0 mm
	Fe filler wire	0.8–1.0 mm
<b>Adjustment range for feed:</b>	SS	1 – 13 m/min
<b>Wire coil:</b>	Al	200 mm / 5 kg
<b>Inert gas:</b>	CuSi	CO <sub>2</sub> , Ar, Ar + CO <sub>2</sub> mixture
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>	max. Ø	13 kg
<b>Dimensions (L × W × H):</b>		450 × 227 × 368 mm
<b>Can be used with a generator, minimum output:</b>		IEC 60974-1
		IEC 60974-5
<b>Standards:</b>		IEC 60974-10
		IEC 6100-3-12

Article No.	Article Description	QTY
5460 3	MINARC MIG 180 WELDING MACHINE	1

## Scope of delivery:

- 1x Art. No. 5460 320 Hose package MMG 20 for Fe
- 1x Art. No. 5460 2 3 Inert gas hose, 4.5 m
- 1x Art. No. 5460 3 08 1 Current nozzle M6, Ø 0.8 mm
- 1x Art. No. 5460 1 3 Shoulder strap

# Accessories: Minarc MIG EVO 200 Welder



Article No.	Article Description	QTY
5460 2 2	GROUND CABLE WITH CLIP 3M	1
5460 3 22	HOSE SET MMG 22	1
5460 2 3	INERT GAS HOSE 4.5M	1
5460 2 4	FEEDING ROLL 0.6-1.0MM	1
5460 2 5	FEEDING ROLL 0.6-1.0MM FOR FD	1

Article No.	Article Description	QTY
5460 2 7	REAR WIRE GUIDE	1
5460 2 13	COIL FLANGE	1
5460 2 14	SPRING FOR MINARC	1
5460 2 15	WIRE COIL CATCH	1
5460 1 3	SHOULDER STRAP	1

# Kempact Pulse 3000 welding tool FÖRCH\*\*\*\*\*

- Light, compact power source with precise arc control
- For MIG and MAG welding of steel, stainless steel and aluminium, and MIG soldering
- Synergy, pulse and double pulse welding improve the appearance of the seam and the quality of the weld
- 100 memory channels for storing specific parameter values
- Spot weld timer for precise tack and interval welding
- Compatible connector Art.-No. 3891 16 1 (not included in scope of delivery)
- Optional cooling unit for applications with a high welding current over a longer period of time

#### Areas of application:

- Thin sheet work
- Installation work
- Car and commercial vehicle workshops
- Repair and maintenance



#### Technical Data

<b>Supply voltage:</b>	3-50/60 Hz	400 V ±15 %
<b>Power consumption:</b>	40 % duty cycle	12 kVA/250 A
	60 % duty cycle	10 kVA/207 A
	60 % duty cycle	7.5 kVA/160 A
<b>Connection cables:</b>	cycle	4x 1.5 mm <sup>2</sup> , 5 m
<b>Slow-blow fuse:</b>	100 % duty cycle	16 A
<b>Connector plug:</b>	cycle	CEE
<b>Capacity +40 °C:</b>		250 A/26.5 V
		207 A/24 V
		160 A/22 V
<b>Welding range:</b>	40 % duty cycle	8 – 30 V
<b>Max. welding voltage:</b>	cycle	26.5 V/250 A
<b>No-load voltage:</b>	60 % duty cycle	56 V
<b>Utilisation ratio at nominal value:</b>	cycle	0.69 (250 A/26 V)
<b>Power coefficient at nominal value:</b>	100 % duty cycle	0.84 (250 A/26 V)
<b>Wire feed:</b>	cycle	4-roll drive
<b>Wire coil Ø:</b>		200 mm (5 kg), 300 mm (15 kg)
<b>Electrode Ø:</b>		0.6 – 1.0 mm
		0.9 – 1.2 mm
		0.9 – 1.2 mm
		0.8 – 1.0 mm
<b>Protection class:</b>		IP23C
<b>Weight:</b>		22 kg
<b>Dimensions (L x W x H):</b>	Fe, SS	580 x 280 x 440 mm
<b>Standards:</b>	Filler wire	IEC 60974-1
	Al	IEC 60974-4
	CuSi	IEC 60974-10
		IEC 61000-3-12



- Quick and easy in use
- Specially designed for vehicle repair and MIG soldering
- One-button operation
- Preset synergetic programmes for AlMg, AlSi, CuSi, Fe, Ss

Article No.	Article Description	QTY
5460 8	KEMPACT PULSE WELD.MACH.3000	1

#### Delivery includes (no cable assembly):

- 1x Art.-No. 5460 4 2: Earth cable 35 mm<sup>2</sup>, 5 m
- 1x Art.-No. 5460 4 3: Inert gas hose, 6 m

#### Suitable cable assembly:

- Art.-No. 5460 8 1: Burner PMT 32 3 m FÖRCH 5\*

#### Optional water cooling system:

- Art.-No. 5460 8 3: Kempactcool 10 water cooling unit FÖRCH 5\*

#### Suitable cable assembly for the water cooling system:

- Art.-No. 5460 8 2: Burner PMT 30W 3 m FÖRCH 5\*

## Accessories: Kempact MIG 2530 Welder

5460 4 1  
5460 5 8

5460 4 2



5460 4 3



5460 4 16

5460 5 9 1  
5460 5 9 25460 5 9 3  
5460 5 9 45460 8 7  
5460 8 8

3891 16 1

Article No.	Article Description	QTY
5460 4 1	HOSE PACKAGE MMT27 3M	1
5460 5 8	HOSE PACK.FOR KEMP.2800 4.5MM	1
5460 4 2	GROUND CABLE 35MM <sup>2</sup> 5M	1
5460 4 3	INERT GAS HOSE 6M	1
5460 4 16	WIRE COIL ADAPTER F.Ø200 COIL	1
5460 5 9 1	FEED R.0.8-0.9MM WHITE BOTTOM	1

Article No.	Article Description	QTY
5460 5 9 2	FEED R.0.8-0.9MM WHITE TOP	1
5460 5 9 3	FEED ROLL.1.0MM RED BOTTOM	1
5460 5 9 4	FEED ROLL.1.0MM RED TOP	1
5460 8 7	FEED ROLL 1.2MM ORANGE BOTTOM	1
5460 8 8	FEED ROLL 1.2MM ORANGE TOP	1
3891 16 1	CEE-PLUG 400V 16A	1

## Accessory for Kempact Pulse 3000 **FÖRCH**\*\*\*\*\*

### Art.-No. 5460 8 3 KempactCool 10 water cooling unit:

- Supply voltage: 50/60 Hz 400 V
- Power consumption: 100% duty cycle, 250 W
- Cooling power: 1.0 kW
- Maximum pressure: 4.5 bar
- Tank capacity: 3 l
- Dimensions (L x W x H): 580 x 280 x 300 mm
- Weight: 13 kg

### Suitable cable assembly:

- Art.-No. 5460 8 2 Burner PMT 30W 3 m FÖRCH 5\*

Article No.	Article Description	QTY
5460 8 1	BURNER PMT 32 3M	1
5460 8 3	KEMPACTCOOL 10 WAT.COOL.DEVICE	1
5460 8 2	BURNER PMT 30W 3M	1
5460 8 4	REMOTE CONTROL RMT10 FOR PMT	1



5460 8 1



5460 8 3



5460 8 2



5460 8 4

# Kempact 181A welding tool

- Modern energy source and cost-effective source of power
- for MIG-MAG welding of steel, stainless steel and aluminium with solid and filler wires and MIG soldering of copper alloys
- Large, easily legible LCD display at hip height
- 180 A at 50 % duty cycle, 230 V
- Precise and clean arc striking
- Excellent welding performance with mixed or CO<sub>2</sub> inert gas
- 2T / 4T burner cycle mode for stitch seam or continuous welding
- Arc timer for spot and interval welding
- Gas bottles can be loaded at floor level
- LED lighting inside housing to make threading wire easy in poor lighting conditions

## Areas of application:

- Car repair, coachwork and vehicle manufacture
- Steel and façade construction
- Ventilation and air conditioning technology

### Technical Data

<b>Supply voltage::</b>	1~50/60 Hz	230 V ±15 %
<b>Power consumption:</b>	50 % ED (180 A)	5 kVA
<b>Supply current:</b>	50 % ED (180 A)	22 A
	100% ED (140 A)	16 A
<b>Slow-blow fuse:</b>	Type C	16 A
<b>Welding current range:</b>		10 – 26 V/20 – 180 A
<b>No-load voltage:</b>		36 V
<b>No-load power:</b>		35 W
<b>Power factor at maximum current:</b>	180 A / 23 V	0,99
<b>Efficiency at 100 % duty cycle:</b>	140 A / 21 V	82 %
<b>Adjustment range for feed:</b>		1,0 – 14,0 m/min
<b>Filler material Ø:</b>	Fe solid wire	0,6 – 1,2 mm
	Fe filler wire	0,8 – 1,2 mm
	SS	0,8 – 1,2 mm
	Al	1,0 – 1,2 mm
	CuSi	0,8 – 1,0 mm
<b>Wire coil:</b>		max. 300 mm/20 kg
<b>Inert gas:</b>		CO <sub>2</sub> , Ar, Ar+CO <sub>2</sub> (mixture)
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		44 kg
<b>Dimensions L x W x H:</b>		623 x 579 x 1.070 mm
<b>Standards:</b>		IEC 60974-1 IEC 60974-5 IEC 60974-10 IEC 61000-3-12



- The adaptive models have 4 feed channels and allow you to set up using the adaptive mode, whereby the welding power is adjusted to the thickness of the material to be welded

- This model has a wire feed with two rollers



Article No.	Article Description	QTY
5460 181	WELDING TOOL KEMPACT 181A	1

### Scope of delivery:

- 1x Art.-No. 5460 20 50: Hose package FE20, 5 m
- 1x Art.-No. 5460 25 08: Contact tip 0.8 mm, M6 8x28
- 1x Art.-No. 5460 181 8: Feed roller set 181 Fe/0.8 – 9 V
- 1x Art.-No. 5460 4 2: Earth cable 35 mm<sup>2</sup>, 5 m
- 1x Gas hose 1.0 m

# Kempact 181A welding tool accessories



5460 20 50  
5460 20 35



5460 4 2



5460 4 16



5460 20 6  
5460 20 8  
5460 20 10  
5460 20 12



5460 21 10  
5460 21 12

Article No.	Article Description	QTY
5460 20 50	CABLE ASSEMBLY FE20 5M	1
5460 20 35	CABLE ASSEMBLY FE20 3.5M	1
5460 4 2	GROUND CABLE 35MM <sup>2</sup> 5M	1
5460 4 16	WIRE COIL ADAPTER F.Ø200 COIL	1
5460 20 6	FEEDROLLER SET 181 FE/0.6V	1

Article No.	Article Description	QTY
5460 20 8	FEEDROLLER SET 181 FE/0.8-9V	1
5460 20 10	FEEDROLLER SET 181 FE/1.0V	1
5460 20 12	FEEDROLLER SET 181 FE/1.2V	1
5460 21 10	FEEDROLLER SET 181 AL/1.0U	1
5460 21 12	FEEDROLLER SET 181 AL/1.2U	1

# Kempact 253A welding tool

- Modern energy source and cost-effective source of power
- for MIG-MAG welding of steel, stainless steel and aluminium with solid and filler wires and MIG soldering of copper alloys
- Large, easily legible LCD display at hip height
- 250 A at 40 % duty cycle, 400 V
- Precise and clean arc striking
- Excellent welding performance with mixed or CO<sub>2</sub> inert gas
- 2T / 4T burner cycle mode for stitch seam or continuous welding
- Arc timer for spot and interval welding
- Gas bottles can be loaded at floor level
- LED lighting inside housing to make threading wire easy in poor lighting conditions
- Compatible connector Art.-No. 3891 16 1 (Not included in scope of delivery)

## Areas of application:

- Coachwork and vehicle manufacture
- Transport and haulage businesses
- Metalwork, forestry and agricultural businesses

## Technical Data

<b>Supply voltage:</b>	3 ~ 50 / 60 Hz	400 V ±15%
<b>Power consumption:</b>	40% ED (250 A)	8.5 kVA
<b>Supply current:</b>	40% ED (250 A)	11.9 A
	100% ED (150 A)	6.1 A
<b>Slow-blow fuse:</b>	Type C	10 A
<b>Welding current range:</b>		10 – 31 V / 20 – 250 A
<b>No-load voltage:</b>		41 V
<b>No-load power:</b>		25 W
<b>Power factor at maximum current:</b>	250 A / 26.5 V	0.93
<b>Efficiency at 100 % duty cycle:</b>	150 A / 21.5 V	0.88%
<b>Einstellbereich Vorschub:</b>		1.0 – 18.0 m/min.
<b>Filler material Ø:</b>	Fe solid wire	0.8 – 1.2 mm
	Fe filler wire	0.8 – 1.2 mm
	SS	0.8 – 1.2 mm
	Al	1.0 – 1.2 mm
	CuSi	0.8 – 1.0 mm
<b>Wire coil:</b>	max.	300 mm / 20 kg
<b>Inert gas:</b>		CO <sub>2</sub> , Ar, Ar+CO <sub>2</sub> (mixture)
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		44 kg
<b>Dimensions L x W x H:</b>		623 x 579 x 1.070 mm
<b>Standards:</b>		IEC 60974-1 IEC 60974-5 IEC 60974-10 IEC 61000-3-12



- The adaptive models have four feed channels and allow set-up using the adaptive module, whereby the welding power is adjusted to the thickness of the material to be welded.
- This model has a wire feed with four rollers.



Article No.	Article Description	QTY
5460 253	WELDING TOOL KEMPACT 253A	1

## Scope of delivery:

- 1x Art.-No. 5460 32 50: Cable assembly FE32, 5 m
- 1x Art.-No. 5460 5 1 10 1: Contact tip M8 steel, 1.0 mm
- 1x Art.-No. 5460 4 2: Earth cable 35 mm<sup>2</sup>, 5 m
- 1x Art.-No. 5460 22 10: Feed roller set 253 Fe/323 – 1.0 V
- 1x Gas hose 1.0 m

# Kempact 323R welding tool

- Modern energy source and cost-effective source of power
- for MIG-MAG welding of steel, stainless steel and aluminium with solid and filler wires and MIG soldering of copper alloys
- Large, easily legible LCD display at hip height
- 320 A at 35 % duty cycle, 400 V
- Precise and clean arc striking
- Excellent welding performance with mixed or CO2 inert gas
- 2T / 4T burner cycle mode for stitch seam or continuous welding
- Arc timer for spot and interval welding
- Gas bottles can be loaded at floor level
- LED lighting inside housing to make threading wire easy in poor lighting conditions
- **Compatible connector Art.-No. 3891 16 1 (not included in scope of delivery)**

## Areas of application:

- Industrial, metal, steel, machine, apparatus and tool construction
- Metalwork, forestry and agricultural businesses

## Technical Data

<b>Supply voltage:</b>	3~50/60 Hz	400 V ±15%
<b>Power consumption:</b>	35% duty cycle (32012 kVA)	
<b>Supply current:</b>	A)	17,2 A
	35% duty cycle (3208,2 A)	
<b>Slow-blow fuse:</b>	A)	10 A
<b>Schweißstrombereich:</b>	100% duty cycle (1900 – 32,5 V/20 – 320 A)	
<b>No-load voltage:</b>	A)	45 V
<b>No-load power:</b>	Type C	25 W
<b>Power factor at maximum current:</b>	0,94	
<b>Efficiency at 100 % duty cycle:</b>	86%	
<b>Adjustment range for feed:</b>	1,0 – 20,0 m/min	
<b>Filler material Ø:</b>	320 A / 30 V	0,6 – 1,2 mm
	190 A / 23,5 V	0,8 – 1,2 mm
		0,8 – 1,2 mm
	Fe solid wire	1,0 – 1,2 mm
	Fe filler wire	0,8 – 1,0 mm
<b>Wire coil:</b>	SS	max. 300 mm/20 kg
<b>Inert gas:</b>	Ar	CO <sub>2</sub> , Ar, Ar+CO <sub>2</sub> (mixture)
<b>Protection class:</b>	CuSi	IP 23 S
<b>Weight:</b>	44 kg	
<b>Dimensions (L x W x H):</b>	623 x 579 x 1.070 mm	
<b>Standards:</b>	IEC 60974-1	
	IEC 60974-5	
	IEC 60974-10	
	IEC 61000-3-12	



- In addition to manual setting of the voltage and speed of the wire feed, the standard models offer a range of standard features. This includes selecting the type of gas, 2T / 4T burner cycle mode, and arc timer.

- This model has a wire feed with four rollers.



Article No.	Article Description	QTY
5460 323	WELDING TOOL KEMPACT 323R	1

## Scope of delivery:

- 1x Art.-No. 5460 32 50: Cable assembly FE32, 5 m
- 1x Art.-No. 5460 5 1 10 1: Contact tip M8 steel, 1.0 mm
- 1x Art.-No. 5460 4 2: Earth cable 35 mm<sup>2</sup>, 5 m
- 1x Art.-No. 5460 22 10: Feed roller set 253 Fe/323 – 1.0 V
- 1x Gas hose 1.0 m



# Kempact 253A / 323R welding tool accessories



5460 32 50  
5460 32 35



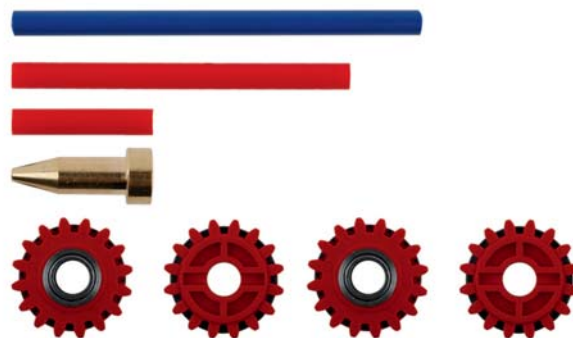
5460 4 2



5460 4 16



5460 22 8  
5460 22 10  
5460 22 12



5460 23 10  
5460 23 12



3891 16 1

Article No.	Article Description	QTY
5460 32 50	CABLE ASSEMBLY FE32 5M	1
5460 32 35	CABLE ASSEMBLY FE32 3.5M	1
5460 4 2	GROUND CABLE 35MM <sup>2</sup> 5M	1
5460 4 16	WIRE COIL ADAPTER F.Ø200 COIL	1
5460 22 8	FEEDROLLER SET 253/323 FE/0.8V	1

Article No.	Article Description	QTY
5460 22 10	FEEDROLLER SET 253/323 FE/1.0V	1
5460 22 12	FEEDROLLER SET 253/323 FE/1.2V	1
5460 23 10	FEEDROLLER SET 253/323 AL/1.0U	1
5460 23 12	FEEDROLLER SET 253/323 AL/1.2U	1
3891 16 1	CEE-PLUG 400V 16A	1

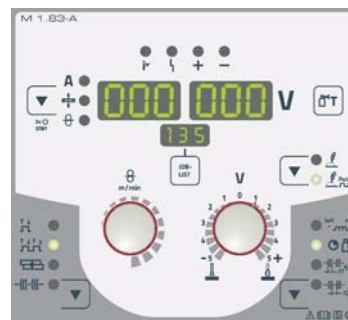
# Welding Machine Picomig 180 Puls

- Compact Inverter-DC-Welding Machine with integrated 4-roller wire feed system
- Robust plastic housing for each application
- 30 preset welding programmes (JOBS) for common MIG/MAG procedures
- **MIG/MAG**-welding of steel, stainless steel, aluminium, CuSi, flux-cored wire
- **WIG/TIG**-welding (Liftarc) of unalloyed, low and high-alloyed steels, nickel base alloys, copper and special materials
- **E-Hand**-welding with rutile and basic covering of unalloyed, low and high-alloyed steels, nickel base and copper alloys
- For production and repair works, metal construction, facade, heating and ventilation installation, pipeline, tank and apparatus engineering, vehicle, machine, plant and tool manufacturing



## Technical Data

Welding type:	MIG/MAG	WIG	E-Hand
Welding current (A):	5 - 180	5 - 180	5 - 150
Switch-on time at Ambient temperature °C:			
Switch-on time 25 %:	40	40	40
Switch-on time 30 %:	180	-	-
Switch-on time 35 %:	-	180	-
Switch-on time 40 %:	-	-	150
Switch-on time 60 %:	-	-	-
Switch-on time 100 %:	120	140	110
Open circuit voltage (V):	100	120	100
Power frequency (Hz):		90	
Mains fuse (A):		50/60	
Mains voltage (tolerance):		1 x 16	
		1 x 230 V (-40 % - +15%)	
Max. connected load kVA:	6.4	4.4	5.5
Rec. generator power kVA:		7.5	
Wire feed rollers:		4	
Wire speed m/min:		0.5 - 15	
Prot. class/insulation class:		IP23 / H	
Dimension (L x W x H) mm:		685 x 280 x 360	
Weight kg:		19	
Standards:		IEC 60 974-1 / IEC 60 974-5 / IEC 60 974-10 / CE / S-sign	



Article No.	Article Description	QTY
5460 100	WELD.MACHINE PICOMIG 180 3IN1	1

## Scope of delivery:

- 1x MIG/MAG-burner
- 1x Earthing cable
- 1x Gas hose, 3 m
- 1x Pressure reducer
- 1x D200 (2 kg) flux-cored wire 0.9 mm
- 1x D200 (2 kg) steel wire 0.8 mm (SG 2)
- 1x Gas nozzle flux-cored wire

# Welding Machine Picomig 180 Plus Accessories



5460 105



5460 101



5460 102



5460 104



5460 103

5460 117  
5460 118  
5460 119

5460 120



5460 121

Article No.	Article Description	QTY
5460 105	GAS HOSE PICOMIG 180	1
5460 101	MIG/MAG BURNER MT220G 3M	1
5460 102	WIG BURNER 1500GD 4M	1
5460 104	EARTHING CABLE PICOMIG 180	1
5460 103	ELECTRODE HOLDERS 25QMM 4M	1

Article No.	Article Description	QTY
5460 117	PK(2)FEED ROLLERS 0.6+0.8MM	1
5460 118	PK(2)FEED ROLLERS 0.8+1.0MM	1
5460 119	PK(2)FEED ROLLERS 1.0+1.2MM	1
5460 120	PK(2)COUNTER-PRESS.ROLLER FD	1
5460 121	PK(2)FEED ROLLER FD 0.8/0.9	1

# PowerMIG-4 200 welding tool

- Three phase, semi-synergistically controlled MIG/MAG welding system for welding steel, stainless steel and aluminium
- Seven settings supported by synergistic operating mode
- Three welding modes available:
  - **2-stroke**, torch switch stays pressed down until the end of the welding process
  - **Spot**, tack welding with variable welding time
  - **Delay**, intermittent welding with variable welding and pause times
- Automatic back up of the most recent welding parameters



## Your Advantage / Benefit

- Perfect welding results without setting the wire feed speed
- Only the following parameters have to be set:
  - Wire type
  - Wire diameter
  - Welding power
- 4-roll wire feed

## Application

- Suitable for welding tasks in metal workshops and car workshops

### Technical Data

<b>Supply voltage:</b>	3 ~ 50/60 Hz	400 V
<b>Slow-blow fuse:</b>	Type C	16 A
<b>Power output 40°C:</b>	30% duty cycle	200 A
	60% duty cycle	140 A
	100 % duty cycle	120 A
<b>Welding current range:</b>		30 – 200 A
<b>No-load voltage:</b>		34.5 V
<b>Filler material Ø:</b>	Fe solid wire	0.6–1.0 mm
	SS	0.6–1.0 mm
	Al	0.8–1.0 mm
	CuSi	0.8–1.0 mm
<b>Wire coil:</b>		200 / 300 mm
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		63 kg
<b>Dimensions (L x W x H):</b>		790 x 470 x 770 mm
<b>Standards:</b>		EN 60974-1:2012
		EN 50445:2008
		EN 60974-10:2014 / A1:2015
		EN 50581:2012

Article No.	Article Description	QTY
5460 3 200 4	WELDING TOOL POWERMIG-4 200A	1

### Delivery includes (no cable assembly):

- Earth cable 3 m, 25 mm<sup>2</sup>
- Set of steel feed rollers 0.8/1.0 mm
- Gas hose

### Suitable cable assemblies:

- Art.-No. 5458 15 300: Cable assembly SP15 3 m
- Art.-No. 5458 15 400: Cable assembly SP15 4 m
- Art.-No. 5458 15 500: Cable assembly SP15 5 m

# PowerMIG-4 250 welding tool

- Three phase, semi-synergistically controlled MIG/MAG welding system for welding steel, stainless steel and aluminium
- Ten settings supported by synergistic operating mode
- Three welding modes available:
  - **2-stroke**, torch switch stays pressed down until the end of the welding process
  - **4-stroke**, welding process started by briefly pressing the torch switch and ended by pressing it again
  - **Spot**, tack welding with variable welding time
- Automatic back up of the most recent welding parameters



## Your Advantage / Benefit

- Perfect welding results without setting the wire feed speed
- Only the following parameters have to be set:
  - Wire type
  - Wire diameter
  - Welding power
- 4-roll wire feed

## Application

- Suitable for welding tasks in metal workshops and commercial vehicle workshops

### Technical Data

<b>Supply voltage:</b>	3~50/60 Hz	400 V
<b>Slow-blow fuse:</b>	Type C	16 A
<b>Power output 40 °C:</b>	30% duty cycle	250 A
	60% duty cycle	180 A
	100% duty cycle	140 A
<b>Welding current range:</b>		35 – 250 A
<b>No-load voltage:</b>		37 V
<b>Filler material Ø:</b>	Fe solid wire	0,8 – 1,2 mm
	SS	0,8 – 1,2 mm
	Al	0,8 – 1,2 mm
<b>Wire coil:</b>		200 / 300 mm
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		86 kg
<b>Dimensions (L x W x H):</b>		900 x 500 x 880 mm
<b>Standards:</b>		EN 60974-1:2012
		EN 50445:2008
		EN 60974-10:2014 / A1:2015
		EN 50581:2012

Article No.	Article Description	QTY
5460 3 250 4	WELDING TOOL POWERMIG-4 250A	1

### Delivery includes (no cable assembly):

- Earth cable 3.5 m, 25 mm<sup>2</sup>
- Set of steel feed rollers 0.8/1.0 mm
- Gas hose

### Suitable cable assemblies:

- Art.-No. 5458 25 300: Cable assembly SP25 3 m
- Art.-No. 5458 25 400: Cable assembly SP25 4 m
- Art.-No. 5458 25 500: Cable assembly SP25 5 m

# Accessoires Power MIG-4 200 / 250



5460 104



5458 15 300  
5458 15 400  
5458 15 500



5458 25 300  
5458 25 400  
5458 25 500



5460 37 9 1  
5460 37 9 2  
5460 37 9 3  
5460 37 9 2 1  
5460 37 9 3 1

Article No.	Article Description	QTY
5460 104	EARTHING CABLE PICOMIG 180	1
5458 15 300	HOSE PACKAGE SP15 3METRES	1
5458 15 400	HOSE PACKAGE SP15 4METRES	1
5458 15 500	HOSE PACKAGE SP15 5METRES	1
5458 25 300	HOSE PACKAGE SP25 3METRES	1
5458 25 400	HOSE PACKAGE SP25 4METRES	1

Article No.	Article Description	QTY
5458 25 500	HOSE PACKAGE SP25 5METRES	1
5460 37 9 1	SET(2)FEED ROLLERS FE 0.6/0.8	1
5460 37 9 2	SET(2)FEED ROLLERS FE 0.8/1.0	1
5460 37 9 3	SET(2)FEED ROLLERS FE 1.0/1.2	1
5460 37 9 2 1	SET(2)FEED ROLLERS AL 0.8/1.0	1
5460 37 9 3 1	SET(2)FEED ROLLERS AL 1.0/1.2	1

# HeavyMIG-4 400 welding tool

- Three phase, semi-synergistically controlled MIG/MAG welding system for welding steel, stainless steel and aluminium
- Twenty settings supported by synergistic operating mode
- Dynamic arc control for optimum stability and minimal spatter
- Four welding modes available:
  - **2-stroke**, torch switch stays pressed down until the end of the welding process
  - **4-stroke**, welding process started by briefly pressing the torch switch and ended by pressing it again
  - **Spot**, tack welding with variable welding time
  - **Delay**, intermittent welding with variable welding and pause times
- Automatic back up of the most recent welding parameters



## Your Advantage / Benefit

- Large duty cycle, especially well-suited to intensive welding tasks with wire diameters up to 1.2 mm
- Perfect welding results without setting the wire feed speed
- Only the following parameters have to be set:
  - Wire type
  - Wire diameter
  - Welding power
- 4-roll wire feed

## Application

- Suitable for welding tasks in metal workshops and industrial workshops

### Technical Data

<b>Supply voltage:</b>	3~50/60 Hz	400 V
<b>Slow-blow fuse:</b>	Type C	25 A
<b>Power output:</b>	50% duty cycle	350 A
	60% duty cycle	320 A
	100% duty cycle	260 A
<b>Welding current range:</b>		40 – 350 A
<b>No-load voltage:</b>		43 V
<b>Filler material Ø:</b>	Fe solid wire	0.8–1.2 mm
	SS	0.8–1.2 mm
	Al	0.8–1.2 mm
<b>Wire coil:</b>		200 / 300 mm
<b>Protection class:</b>		IP 23 S
<b>Weight:</b>		130 kg
<b>Dimensions (L x W x H):</b>		1050 x 500 x 980 mm
<b>Standards:</b>		EN 60974-1:2012
		EN 50445:2008
		EN 60974-10:2014 / A1:2015
		EN 50581:2012

Article No.	Article Description	QTY
5460 3 350 4	WELDING TOOL HEAVYMIG-4 400A	1

### Delivery includes (no cable assembly):

- Earth cable 4 m, 35 mm<sup>2</sup>
- Set of steel feed rollers 1.0/1.2 mm
- Gas hose

### Suitable cable assemblies:

- Art.-No. 5458 36 300: Cable assembly SP36 3 m
- Art.-No. 5458 36 400: Cable assembly SP36 4 m
- Art.-No. 5458 36 500: Cable assembly SP36 5 m

# HeavyMIG-4 WS500 welding tool

- Three phase, water-cooled, partly synergistically controlled MIG/MAG welding system combined with external wire feed device for welding steel, stainless steel and aluminium
- Thirty settings supported by synergistic operating mode
- Dynamic arc control for optimum stability and minimal spatter
- Four welding modes available:
  - **2-stroke**, torch switch stays pressed down until the end of the welding process
  - **4-stroke**, welding process started by briefly pressing the torch switch and ended by pressing it again
  - **Spot**, tack welding with variable welding time
  - **Delay**, intermittent welding with variable welding and pause times
- Automatic back up of the most recent welding parameters



## Your Advantage / Benefit

- Large duty cycle, especially well-suited to intensive welding tasks with wire diameters up to 1.6 mm
- Perfect welding results without setting the wire feed speed
- Only the following parameters have to be set:
  - Wire type
  - Wire diameter
  - Welding power
- 4-roll wire feed

## Application

- Suitable for welding tasks in metal workshops and industrial workshops

### Technical Data

<b>Supply voltage:</b>	3~50/60 Hz	400 V
<b>Slow-blow fuse:</b>	Type C	25 A
<b>Power output:</b>	50% duty cycle	450 A
	60% duty cycle	410 A
	100% duty cycle	320 A
<b>Welding current range:</b>		45 – 450 A
<b>No-load voltage:</b>		51 V
<b>Filler material Ø:</b>	Fe solid wire	0.8–1.6 mm
	SS	0.8–1.6 mm
	Al	0.8–1.6 mm
<b>Wire coil:</b>		200 / 300 mm
<b>Protection class:</b>		IP 23 S
<b>Welding tool (L x W x H):</b>		1050 x 500 x 980 mm
<b>Weight of welding tool:</b>		160 kg
<b>Wire feed case (L x W x H):</b>		590 x 250 x 560 mm
<b>Weight of wire feed case:</b>		17 kg
<b>Standards:</b>		EN 60974-1:2012
		EN 50445:2008
		EN 60974-10:2014 /
		A1:2015
		EN 50581:2012

Article No.	Article Description	QTY
5460 3 450 4	WELDING TOOL HEAVYMIG-4 WS500A	1

### Delivery includes (no cable assembly):

- Wire feed case
- Earth cable 4 m, 70 mm<sup>2</sup>
- Set of steel feed rollers 1.0/1.2 mm
- Interconnection cable assembly 5 m, 70 mm<sup>2</sup>, water-cooled
- Gas hose

### Suitable cable assemblies:

- Art.-No. 5458 50 400: Cable assembly SP50WK 4 m
- Art.-No. 5458 50 500: Cable assembly SP50WK 5 m



## Accessoires Heavy MIG-4 400 / WS500



5460 4 2

5458 36 300  
5458 36 400  
5458 36 5005460 37 19 2  
5460 37 19 3  
5460 37 19 2 1  
5460 37 19 3 1

Article No.	Article Description	QTY
5460 4 2	GROUND CABLE 35MM <sup>2</sup> 5M	1
5458 36 300	HOSE PACKAGE SP36 3METRES	1
5458 36 400	HOSE PACKAGE SP36 4METRES	1
5458 36 500	HOSE PACKAGE SP36 5METRES	1

Article No.	Article Description	QTY
5460 37 19 2	SET(2)FEED ROLLERS FE 0.8/1.0	1
5460 37 19 3	SET(2)FEED ROLLERS FE 1.0/1.2	1
5460 37 19 2 1	SET(2)FEED ROLLERS AL 0.8/1.0	1
5460 37 19 3 1	SET(2)FEED ROLLERS AL 1.0/1.2	1

## Accessoires HeavyMIG-4 WS 500

5458 50 500  
5458 50 400

5460 3 450 5

Article No.	Article Description	QTY
5458 50 500	HOSE PACKAGE SP50WK 5METRES	1
5458 50 400	HOSE PACKAGE SP50WK 4METRES	1
5460 3 450 5	INTERMED.HOSE PACKAGE 5M	1



# Welder Boots S3

- According to EN ISO 20345:2011 S3 and EN ISO 20349:2010
- Made from high-quality, heat-resistant cow leather
- Overlapping leather provides protection against flying sparks and welding beads
- With Velcro fastener for quick removal in an emergency
- With steel cap and non-metallic, puncture-resistant fabric insole
- Anti-slip PU/rubber sole, resistant to contact heat up to 300°C
- Colour: black
- Weight: 770 g per shoe in size 42

Article No.	Article Description	QTY
5406 443 39	SAFETY BOOT WELDER SZ.39	1
5406 443 40	SAFETY BOOT WELDER SZ.40	1
5406 443 41	SAFETY BOOT WELDER SZ.41	1
5406 443 42	SAFETY BOOT WELDER SZ.42	1
5406 443 43	SAFETY BOOT WELDER SZ.43	1
5406 443 44	SAFETY BOOT WELDER SZ.44	1
5406 443 45	SAFETY BOOT WELDER SZ.45	1
5406 443 46	SAFETY BOOT WELDER SZ.46	1
5406 443 47	SAFETY BOOT WELDER SZ.47	1





# Bionic Face Mask

## Art.-No. 5400 50 3:

- With head support without lens
- According to DIN EN 166, DIN EN 169 and DIN EN 170 personal eye protection
- Sits comfortably, even when wearing safety glasses or respiratory protection
- Further protection for the top of the head and chin
- Fully adjustable ratchet head support
- Adjustable head band
- All parts that come in to contact with the head are padded

## Art.-No. 5400 50 3 1:

- Clear acetate lens
- Ideal for use with chemicals

## Art.-No. 5400 50 3 2:

- Clear polycarbonate lens, anti-fog, scratch-proof

## Art.-No. 5400 50 3 3:

- Electrician's protective lens electrical arc tested (3-pin, 10 KA / 0.5 sec)

## Art.-No. 5400 50 3 4:

- welder-polycarbonate-lens IR5 green, clear
- for gas-welding (autogenic) and hard soldering with acetylene as well for flame cutting with oxygen

Article No.	Article Description	QTY
5400 50 3	BIONIC FACE MASK	1
5400 50 3 1	PROTEC.SHIELD BION.AC CLEAR	1
5400 50 3 2	PROTEC.SHIELD BION.PC CLEAR	1
5400 50 3 3	PROTEC.SHIELD BION.ELECTRICIAN	1
5400 50 3 4	PROTEC.SHIELD BION.PC CLEAR IR	1



5400 50 3



5400 50 3 1, 5400 50 3 2, 5400 50 3 3



5400 50 3 4