



General Catalog 2026

WELDING EQUIPMENT | WELDING TORCHES | ACCESSORIES



Table of Contents

1. Price list	6
2. MIG/MAG welding units	10
2.1. MIG/MAG welding units step controlled	11
2.1.1. RedMIG eco 2800 K	12
2.2. MIG/MAG welding units step controlled with synergic wire feed	15
2.2.1. OptiMIG eco 450 DW	16
2.2.2. Accessories for OptiMIG eco 450 DW	18
2.3. MIG/MAG welding units continuously controlled	21
2.3.1. MobiMIG 180 K	22
2.3.2. MobiMIG 280 K	26
2.3.3. MobiMIG 321 K	30
2.3.4. MobiMIG 322 K	34
2.3.5. MobiMIG 322 KW	36
2.3.6. Accessories for MobiMIG 322 K/KW	38
2.3.7. GreenMIG 400 KW	40
2.3.8. GreenMIG 500 KW	42
2.3.9. GreenMIG 400 DW	44
2.3.10. GreenMIG 500 DW	46
2.3.11. Accessories for GreenMIG 400/500 KW/DW	48
3. Synergic Pulse welding units	52
3.1. Synergic Pulse welding units - series HighPULSE touch	53
3.1.1. HighPULSE touch 350 K	54
3.1.2. Accessories for HighPULSE touch 350 K	56
3.1.3. Water cooling unit WK 300	59
3.1.4. HighPULSE touch 400 KW	60
3.1.5. HighPULSE touch 450 KW	62
3.1.6. HighPULSE touch 400 DW	64
3.1.7. HighPULSE touch 450 DW	66
3.1.8. Accessories for HighPULSE touch 400/450 KW/DW	68
3.2. Synergic Pulse welding units for hand welding - series HighPULSE	73
3.2.1. HighPULSE 354 K	74
3.2.2. Accessories for HighPULSE 354 K	76
3.2.3. Water cooling unit WK 300	79
3.2.4. HighPULSE 353 K	80

3.2.5. HighPULSE 454 KW	82
3.2.6. HighPULSE 554 KW	84
3.2.7. HighPULSE 354 DW	86
3.2.8. HighPULSE 454 DW	88
3.2.9. HighPULSE 554 DW	90
3.2.10. Accessories for HighPULSE 354/454/554 KW/DW	92
3.2.11. HighPULSE 354/454/554 DW TWIN	98
3.3. Synergic Pulse welding units for automation and robotics	102
3.3.1. HighPULSE 354 RS	103
3.3.2. HighPULSE 454 RS	104
3.3.3. HighPULSE 554 RS	105
4. MIG/MAG welding torches	112
4.1. Hand welding torches	113
4.1.1. SB/SBT 157 G.....	114
4.1.2. SB/SBT 307 G.....	118
4.1.3. SB/SBT 351 G.....	124
4.1.4. SB/SBT 352 W	128
4.1.5. SB/SBT 504 W	134
4.1.6. SB/SBT 603 W	142
4.1.7. HSB/HSBT 600 W	148
4.2. Fume extraction welding torches	153
4.2.1. RSB/RSBT 351 G	154
4.2.2. RSB/RSBT 504 W.....	160
4.3. Push-Pull welding torches	167
4.3.1. PP/PPT 307 G.....	168
4.3.2. PP/PPT 504 W	174
4.4. Machine and robot welding torches	181
4.4.1. MSB 401 W	182
4.4.2. MSB 603 W	188
4.4.3. ROB 505 W	194
5. TIG welding units	202
5.1. TIG DC welding units	203
5.1.1. LiteTIG 190 DC	204
5.1.2. LiteTIG 210 DC	208

5.1.3.	MobiTIG 304 DC	212
5.1.4.	HighTIG W 352 DC	216
5.1.5.	HighTIG 452 DC.....	220
5.1.6.	HighTIG 552 DC.....	224
5.1.7.	HighTIG 452/552 DC RS	228
5.2.	TIG AC/DC welding units	233
5.2.1.	LiteTIG 190 AC/DC	234
5.2.2.	LiteTIG 210 AC/DC	238
5.2.3.	LogiTIG 221 AC/DC.....	242
5.2.4.	Water cooling unit WK 210	246
5.2.5.	LogiTIG 240 AC/DC.....	248
5.2.6.	Water cooling unit WK 230	252
5.2.7.	LogiTIG 300 AC/DC.....	254
5.2.8.	Water cooling unit WK 300	258
5.2.9.	Insquare W 321 AC/DC	260
5.2.10.	Insquare W 421 AC/DC	264
5.2.11.	Insquare W 600 AC/DC	268
6.	TIG welding torches.....	272
6.1.	TH 202 G	274
6.2.	TH 452 W	280
6.3.	TH 600 W	286
6.4.	TM 450 W	290
6.5.	Cold Wire Feed System KDFZ.....	294
7.	MMA/stick electrode welding units	296
7.1.	LiteARC 160.....	298
7.2.	LiteARC 180.....	300
7.3.	MobiARC 284 cel	302
7.4.	MobiARC 284 cel ±	306
8.	Accessories	310
8.1.	Wire feed DV-21	311
8.2.	Wire feed DV-26	314
8.3.	Wire feed DV-31	318
8.4.	Water cooling units	322
8.5.	WeldFACTORY i4.0 (Q.MACS)	323

8.6. Software, Program updates, Calibration.....	324
8.7. Calibration unit MCU 1000	325
8.8. Accessories	327
8.9. Advertising articles	330
8.10. Leaflets and Catalogues	331

1. Price list

1. Price list

MIG/MAG WELDING UNITS

Model	without accessories	with accessories	with torch 3 m	with torch 4 m	torch model
RedMIG eco Series - step controlled, 4-roller wire feeder					
RedMIG eco 2800 K (DV-26)*	2,620.00	2,731.00	2,941.00	2,966.00	SB 307 G
OptiMIG eco Series - synergic step control, TEDAC system, 4-roller wire feeder					
OptiMIG eco 450 DW*	6,980.00	7,178.00	7,663.00	7,688.00	SBT 504 W
MobiMIG Series - synergic continuous control, TEDAC system, electrode					
MobiMIG 180 K	2,270.00	2,360.00	2,585.00	2,595.00	SBT 157 G
MobiMIG 280 K	3,900.00	4,011.00	4,306.00	4,331.00	SBT 307 G
MobiMIG 321 K	3,975.00	4,068.00	4,381.00	4,406.00	SBT 307 G
MobiMIG 321 K – with WK 300, TW 112	5,475.00	5,586.00	6,071.00	6,096.00	SBT 504 W
MobiMIG 322 K	4,200.00	4,311.00	4,606.00	4,631.00	SBT 307 G
MobiMIG 322 KW	4,850.00	4,961.00	5,446.00	5,471.00	SBT 504 W
GreenMIG Series - continuously controlled, TEDAC system, PULSEARC upgrade available					
GreenMIG 400 KW	6,150.00	6,348.00	6,833.00	6,858.00	SBT 504 W
GreenMIG 400 DW	7,700.00	7,898.00	8,383.00	8,408.00	SBT 504 W
GreenMIG 500 KW	6,980.00	7,179.00	7,663.00	7,688.00	SBT 504 W
GreenMIG 500 DW	8,530.00	8,728.00	9,213.00	9,238.00	SBT 504 W

SYNERGIC MIG PULSE-ARC WELDING MACHINES

Model	without accessories	with accessories	with torch 3 m	with torch 4 m	torch model
HighPULSE touch Series - with intuitive touch-display control					
HighPULSE touch 350 K	6,850.00	7,013.00	7,308.00	7,333.00	SBT 307 G
HighPULSE touch 350 K – with WK 301, TW 112	8,165.00	8,328.00	8,813.00	8,838.00	SBT 504 W
HighPULSE touch 400 KW	8,600.00	8,798.00	9,283.00	9,308.00	SBT 504 W
HighPULSE touch 450 KW	9,050.00	9,307.00	9,792.00	9,817.00	SBT 504 W
HighPULSE touch 400 DW	10,100.00	10,298.00	10,783.00	10,808.00	SBT 504 W
HighPULSE touch 450 DW	10,550.00	10,807.00	11,292.00	11,317.00	SBT 504 W
HighPULSE Series					
HighPULSE 354 K	7,400.00	7,563.00	7,858.00	7,883.00	SBT 307 G
HighPULSE 354 K – with WK 300, TW 112	8,715.00	8,878.00	9,363.00	9,388.00	SBT 504 W
HighPULSE 353 K			7,750.00	8,050.00	
HighPULSE 454 KW	10,450.00	10,707.00	11,192.00	11,217.00	SBT 504 W
HighPULSE 554 KW	10,950.00	11,207.00	11,692.00	11,717.00	SBT 504 W
HighPULSE 354 DW	10,050.00	10,248.00	10,733.00	10,758.00	SBT 504 W
HighPULSE 454 DW-26	11,950.00	12,182.00	12,692.00	12,717.00	SBT 504 W
HighPULSE 454 DW-31	12,600.00	12,857.00	13,342.00	13,367.00	SBT 504 W
HighPULSE 554 DW-26	12,450.00	12,707.00	13,192.00	13,217.00	SBT 504 W
HighPULSE 554 DW-31	13,100.00	13,357.00	13,842.00	13,867.00	SBT 504 W
HighPULSE 354 DW TWIN	14,350.00				
HighPULSE 454 DW TWIN	16,250.00				
HighPULSE 554 DW TWIN	16,740.00				
HighPULSE 354/454/554 RS	Robot- and automation power source, see data sheet/catalogue				

TIG WELDING UNITS

Model	without accessories	with accessories	with torch 4 m	with torch 8 m	torch model
TIG DC Series - portable DC TIG welding units					
LiteTIG 190 DC	1,820.00	1,906.00	2,256.00	2,386.00	TH 202 G
LiteTIG 210 DC	2,350.00	2,436.00	2,786.00	2,916.00	TH 202 G
MobiTIG 304 DC	3,750.00	3,861.00	4,211.00	4,341.00	TH 202 G
MobiTIG 304 DC with WK 210, TW 112	5,250.00	5,361.00	5,856.00	5,916.00	TH 452 W

TIG AC/DC Series - portable AC/DC TIG welding units					
LiteTIG 190 AC/DC	2,825.00	2,911.00	3,261.00	3,391.00	TH 202 G
LiteTIG 210 AC/DC	3,525.00	3,611.00	3,961.00	4,091.00	TH 202 G
LogiTIG 221 AC/DC	5,380.00	5,491.00	5,841.00	5,971.00	TH 202 G
LogiTIG 221 AC/DC with WK 210, TW 112	6,880.00	6,991.00	7,486.00	7,546.00	TH 452 W
LogiTIG 240 AC/DC	5,720.00	5,831.00	6,181.00	6,311.00	TH 202 G
LogiTIG 240 AC/DC with WK 230, TW 112	7,220.00	7,331.00	7,826.00	7,886.00	TH 452 W
LogiTIG 300 AC/DC	8,344.00	8,507.00	8,857.00	8,987.00	TH 202 G
LogiTIG 300 AC/DC with WK 300, TW 112	9,659.00	9,822.00	10,317.00	10,377.00	TH 452 W

HighTIG Series (DC)					
HighTIG W 352 DC	8,165.00	8,328.00	8,853.00	8,913.00	TH 452 W
HighTIG 452 DC	9,922.00				
HighTIG 452 DC with WK 350, TW 114	12,027.00			12,810.00	TH 452 W
HighTIG 552 DC	10,213.00				
HighTIG 552 DC with WK 350, TW 114	12,318.00			13,320.00	TH 600 W
HighTIG 452 DC RS	7,527.00	plus combination			
HighTIG 552 DC RS	7,818.00	plus combination			

INSQUARE Series (AC/DC) - TIG welding units with integrated water cooler					
Insquare W 321 AC/DC	12,822.00	12,985.00	13,510.00	13,570.00	TH 452 W
Insquare W 421 AC/DC	13,477.00	13,675.00	14,200.00	14,260.00	TH 452 W
Insquare W 600 AC/DC	25,134.00	25,435.00		26,180.00	TH 600 W

WATER COOLING UNITS - TROLLEYS

Model	
Water cooling unit WK 210	980.00
Water cooling unit WK 230	980.00
Water cooling unit WK 300	980.00
Water cooling unit WK 350	1,680.00
Trolley model TW 112	335.00
Drawer option for TW 112	350.00
Trolley model TW 114	425.00

MMA/STICK ELECTRODE WELDING UNITS

Model	without accessories	with accessories
LiteARC 160	642.00	725.00
LiteARC 180	905.00	988.00
MobiARC 284 cel	3,060.00	3,196.00
MobiARC 284 cel ±	4,470.00	4,606.00

MIG/MAG WELDING TORCHES

Model	standard - SB			TEDAC - SBT			
	3 m	4 m	5 m	3 m	4 m	5 m	
SB/SBT 157 G	140.00	150.00	-	225.00	235.00	-	gas cooled
SB/SBT 307 G	210.00	235.00	260.00	285.00	320.00	345.00	gas cooled
SB/SBT 351 G	210.00	235.00	260.00	295.00	320.00	345.00	gas cooled
SB/SBT 352 W	400.00	425.00	-	485.00	510.00	-	water cooled
SB/SBT 504 W short version	400.00	425.00	450.00	485.00	510.00	535.00	water cooled
SB/SBT 504 W long version	415.00	440.00	465.00	500.00	525.00	550.00	water cooled
SB/SBT 603 W	520.00	545.00	-	605.00	630.00	-	water cooled
HSB/HSBT 600 W	595.00	620.00	-	680.00	705.00	-	water cooled
R 351 G fume extraction	630.00	660.00	-	750.00	780.00	810.00	gas cooled
R 504 W fume extraction	795.00	875.00	-	915.00	995.00		water cooled
MSB 401 W machine welding torch				see data sheet/catalogue			water cooled
ROB 505 W robot and machine welding torch				see data sheet/catalogue			water cooled
MSB 504 W machine welding torch				see data sheet/catalogue			water cooled
MSB 603 W machine welding torch				see data sheet/catalogue			water cooled

PUSH PULL TORCHES

Model	standard PP, 8 m	TEDAC PPT, 8 m	
307 G - 22°	2,450.00	2,700.00	gas cooled
307 G - 45°	2,450.00	2,700.00	gas cooled
504 W - straight	2,600.00	2,850.00	water cooled
504 W - bent	2,600.00	2,850.00	water cooled

TIG WELDING TORCHES

Model	Standard		Potentiometer		torch connector
	4 m	8 m	4 m	8 m	
TH 202 G gas cooled	350.00	480.00	-	580.00	MERKLE TCG-Connector
TH 452 W water cooled	495.00	555.00	595.00	655.00	MERKLE TCG-Connector
TH 600 W water cooled		745.00	765.00	845.00	MERKLE TCG-Connector
TM 450 W water cooled	see data sheet/catalogue				machine torch

2. MIG/MAG welding units

2. MIG/MAG welding units

2.1 Welding units step controlled **RedMIG eco 2800 K**

2.2 Welding units step controlled with synergic wire feed **OptiMIG eco 450 DW**

2.3 Welding units continuously controlled **MobiMIG 180/280/321/322 K/KW** **GreenMIG 400/500 KW** **GreenMIG 400/500 DW**

2.1. MIG/MAG welding units step controlled



2.1.1. RedMIG eco 2800 K

Primary:

Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	4.8 kVA
Contin. current:	7.9 A
Max. current:	15 A
Efficiency:	85%

Secondary:

Open circuit voltage:	17-36 V
Welding voltage:	15.3 - 28 V
Welding current:	25 - 250 A
Duty cycle 30 % (10 min.):	280 A (40 °C)
Duty cycle 60 % (10 min.):	210 A (40 °C)
Duty cycle 100 %:	180 A (40 °C)



Protection class:	IP 21
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time:	potentiometer
Intermission time:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas
Gas bottle holder:	10 - 20 l cylinders
Mains supply cable:	4 x 1.5 mm ² , 5 m long with plug 3 x 400 V / 16 A
Gas hose:	2 m long
Socket 50 mm ² :	for earth lead
Weight:	97 kg
Dimensions l x w x h:	800 x 460 x 655 mm

Wire feeder: compact mounted, model DV-26

Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7-25 m/min
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit RedMIG eco 2800 K						
	A	MIG/MAG welding unit RedMIG eco 2800 K with 4-roller-drive DV-26		69	165998	2.620,00
	AB	MIG/MAG welding unit RedMIG eco 2800 K with 4-roller-drive DV-26 and accessories		69	SET166000	2.731,00
	ABC1	MIG/MAG welding unit RedMIG eco 2800 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 3 m		69	SET166002	2.941,00
	ABC2	MIG/MAG welding unit RedMIG eco 2800 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 4 m		69	SET166004	2.966,00
B Standard accessories:						
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	MIG/MAG hand welding torch model SB 307 G, 3 m		06	02210758	210,00
	C2	MIG/MAG hand welding torch model SB 307 G, 4 m		06	02210759	235,00
D Accessories:						
	D1	Adapter for wire spool		46	02900104	23,50
	D2	Front carriage extension for RedMIG and CompactMIG 280 K for using 50 l gas cylinders		46	157750	108,00
E Additional wire equipment for DV-26:						
	E1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	E2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	E3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	E4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	E5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	E6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50

1



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2.1

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2.2. MIG/MAG welding units step controlled with synergic wire feed



2.2.1. OptiMIG eco 450 DW

Primary:

Voltage:	3 x 400 V
Frequency:	50 Hz
Continuous power:	14.2 kVA
Continuous current:	20.5 A
Max. current:	24.1 A
Efficiency:	85%

Secondary:

Open circuit voltage:	16 - 48.5 V
Welding voltage:	15.5 - 34 V
Welding current:	30 - 400 A
Duty cycle 80 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	370 A (40 °C)



Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3 phase
Voltage control:	28 steps 4-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m long
Choke:	100%, option: 60%
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces (option)
Push pull torch:	connector (option)
Weight:	240 kg
Dimensions l x w x h:	990 x 510 x 1135 mm incl. gas bottle holder

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	Wire feed speed
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 50 mm² water
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions:	610 x 400 x 180 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG welding unit OptiMIG eco 450 DW with wire feeder and 1.6 m interconnection cable:					

With DV-26 wire feeder:


AB1	MIG/MAG welding unit OptiMIG eco 450 DW		01	SET168857	6.980,00
AB1C	MIG/MAG welding unit OptiMIG eco 450 DW with accessories		01	SET168859	7.178,00
AB1CD1	MIG/MAG welding unit OptiMIG eco 450 DW with accessories and hand welding torch SBT 504 W, 3 m		01	SET168860	7.663,00
AB1CD2	MIG/MAG welding unit OptiMIG eco 450 DW with accessories and hand welding torch SBT 504 W, 4 m		01	SET168862	7.688,00

A Power source (without wire feeder):

A	MIG/MAG welding unit OptiMIG eco 450 DW (power source)		01	168848	5.250,00
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B Wire feeder:


B1	Wire feeder DV-26 for OptiMIG 351/451/551/eco 450 DW		46	149922	1.400,00
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! Use wire feeder DV-31 for wire > 1.2 mm:


B2	Wire feeder DV-31 (OT) für OptiMIG 351/451/551/eco 450 DW		46	149924	2.050,00
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C Standard accessories:


C1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
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C2	Regulator argon/CO2, single stage		46	01200300	75,00
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D Welding torches:


D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

2.2.2. Accessories for OptiMIG eco 450 DW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Accessories:					
	1.1	Adapter for wire spool		46	02900104	23,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	1.4	Filter frame incl. filter for OptiMIG reduced duty cycle		46	109524	135,00
	1.5	Filter for OptiMIG	10 pcs	46	109528	4,60
	1.6	Metal filter insert for OptiMIG		46	156682	240,00
	1.7	Push-Pull kit installed inside the welding unit		46	02110403	785,00
	1.8	Connection for automated welding welding ON, arc OK, emergency STOP for MAG 30 controller		46	114668	315,00
	1.9	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	1.10b	Price reduction: no integrated water cooling unit (D version)		46	01903611	-510,00
	1.11	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	1.12	Optional choke socket 60 % for series OptiMIG and CompactMIG		46	144610	105,00
2	Accessories for wire feeder:					
	2.1	Rotatable device for wire feeder including screw set		46	137436	189,00
	2.2	4 wheels mounted on the wire feeder		46	00102109	75,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	2.3	Suspension device for wire feeder electrically isolated		46	00502878	105,00
	2.4	Option for wire feeder DV-31 (OT) 0.5 - 30 m/min. incl. wire straightener and motor without tachometer when not using DV-26		46	01910011	
	2.5	Balancer G4 for rotatable device 137.436		05	158714	1.150,00
	2.6	Wheelbase widening set for OptiMIG DW		46	117548	135,00
	2.7	Connection for wire feed liner inside the wire feeder box		46	110454	85,00

3 Connection cable to wire feeder:

	3.1	Connection cable 5 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	138844	595,00
	3.2	Connection cable 10 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	138846	890,00
	3.3	Connection cable 15 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	153218	1.150,00
	3.4	Connection cable 20 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	153220	1.505,00
	3.5	Connection cable 30 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	154388	1.730,00

Price reduction, when not taken:

3.6	Connection cable 1.6 m 70 mm ² , w.c. HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	138842	330,00
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4 Additional wire equipment for DV-26 and DV-31:

	4.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	4.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	4.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	78,50
	4.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	4.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	4.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
	4.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	4.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
	4.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	99,50

Pos.	Description	Pu	PrGrp	Part No.	Price/€
4.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	103,70
4.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	103,70

2.3. MIG/MAG welding units continuously controlled



2.3.1. MobiMIG 180 K

Primary:

Power supply: 1 x 230 V
Frequency: 50 / 60 Hz

MIG/MAG operation:

Open circuit voltage: 64 V
Welding voltage: 15 - 23 V
Welding current: 25 - 180 A
Duty cycle 20 % (10 min.): 180 A (40 °C)
Duty cycle 60 % (10 min.): 110 A (40 °C)
Duty cycle 100 %: 90 A (40 °C)
Prim. contin. power: 3.7 kVA
Prim. contin. current: 16 A
Prim. max. current: 26 A



Protection class: IP 23
Insulation class: H
Cooling: AF
Arc length: synergic operation, automatic energy control
Programs: MIG/MAG, MMA/stick electrode, TIG DC (LiftTIG), ColdMIG
Program selection: material, wire diameter and gas at the display
Operation modes: 2-stroke, 4-stroke, stitch, spot welding
Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment: at the machine, at the TEDAC torch
Adjustable parameters: choke inductance, wire burn back, soft start
Power source: inverter
Sockets 50 mm²: earth lead and electrode cable
Torch cooling: gas
Mains supply cable: 3 x 2.5 mm², 2.5 m long with plug
Gas hose: 2 m
Handle: on top of the machine
Norm: EN 60974-1 "S" / CE
Weight: 17 kg
Dimensions l x w x h: 450 x 210 x 480 mm

TIG operation:

Open circuit voltage: 64 V
Welding voltage: 10 - 17.2 V
Welding current: 10 - 180 A
Duty cycle 20 % (10 min.): 180 A (40 °C)
Duty cycle 60 % (10 min.): 110 A (40 °C)
Duty cycle 100 %: 90 A (40 °C)
Prim. contin. power: 2.8 kVA
Prim. contin. current: 12 A
Prim. max. current: 23 A

MMA/stick electrode operation:

Open circuit voltage: 64 V
Welding voltage: 20.6 - 26.4 V
Welding current: 25 - 160 A
Duty cycle 30 % (10 min.): 150 A (40 °C)
Duty cycle 60 % (10 min.): 90 A (40 °C)
Duty cycle 100 %: 80 A (40 °C)
Prim. contin. power: 3.7 kVA
Prim. contin. current: 16 A
Prim. max. current: 26 A

Wire feeder: compact mounted, Model DV-21

Supply: 26 V-DC
Wire feed motor: DC motor with worm gear drive 0.5 - 20 m/min.
Wire feed system: 2-roller-drive DV-21
Reel hub assembly: D 200/5
Torch connection: EURO connector
Standard wire equipment: mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit MobiMIG 180 K						
	A	MIG/MAG welding unit MobiMIG 180 K		20	122354	2.270,00
	AB	MIG/MAG welding unit MobiMIG 180 K with accessories		20	SET122356	2.360,00
	ABC1	MIG/MAG welding unit MobiMIG 180 K with accessories and TEDAC hand welding torch SBT 157 G, 3 m		20	SET122358	2.585,00
	ABC2	MIG/MAG welding unit MobiMIG 180 K with accessories and TEDAC hand welding torch SBT 157 G, 4 m		20	SET122360	2.595,00
! Software ColdMIG included for free (Worth: 630,00 €).						
B Standard accessories:						
	B1	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	47,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, model SBT 157 G, 3 m		06	118704	225,00
	C2	MIG/MAG hand welding torch TEDAC, model SBT 157 G, 4 m		06	118706	235,00
D Accessories:						
	D1	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/rubber hose assembly		10	133632	350,00
	D2	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/rubber hose assembly		10	129532	480,00
	D3	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	D4	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D5	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D6	Adapter for centering of small wire spool		46	133070	37,02
	D7	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	40,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
D8	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Software (for free):


E1	Software for ColdMIG process for MobiMIG 180 K		17	122352	630,00
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F Additional wire equipment for DV-21:


F1	Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)		46	01200387	55,00
F2	Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200388	55,00
F3	Kit for mild steel 1.0 mm (DV-21,20/2) (without contact tips)		46	01200389	55,00
F4	Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200390	76,00
F5	Kit for stainless steel 1.0 mm (DV-21,20/2) (without contact tips)		46	01200391	76,00
F6	Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)		46	01200392	76,00

2.3.2. MobiMIG 280 K

Primary:

Power supply:	3 x 400 V
	3 x 220 - 440 V*
	1 x 220 - 440 V*
Frequency:	50 / 60 Hz

Data at supply voltage:	3 x 400 V	1 x 230 V*
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MIG/MAG operation:

Open circuit voltage:	90 V	103 V*
Welding voltage:	15 - 28 V	15 - 23 V*
Welding current:	25 - 280 A	25 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 50 % (10 min.):	280 A (20 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	9 kVA	3.7 kVA*
Prim. contin. current:	13 A	16 A*
Prim. max. current:	20 A	26 A*



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	synergic operation, automatic energy control
Programs:	MIG/MAG, MMA/stick electrode, TIG DC (LiftTIG), ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, stitch, spot welding
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start
Power source:	inverter
Sockets 50 mm ² :	earth lead and electrode cable
Torch cooling:	gas
Mains supply cable:	4 x 2.5 mm ² , 5 m long with plug 400 V / 16 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	27 kg
Dimensions l x w x h:	470 x 255 x 545 mm

Data at supply voltage:	3 x 400 V	1 x 230 V*
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TIG operation:

Open circuit voltage:	90 V	103 V*
Welding voltage:	10 - 21.2 V	10 - 17.2 V*
Welding current:	10 - 280 A	10 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 50 % (10 min.):	280 A (20 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	8.3 kVA	2.8 kVA*
Prim. contin. current:	12 A	12 A*
Prim. max. current:	16 A	23 A*

MMA/stick electrode operation:

Open circuit voltage:	90 V	103 V*
Welding voltage:	20.6 - 31.2 V	20.6 - 31.2 V
Welding current:	20 - 280 A	25 - 160 A*
Duty cycle 35 % (10 min.):	280 A (40 °C)	150 A (20 °C)*
Duty cycle 50 % (10 min.):	250 A (40 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	90 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)*
Prim. contin. power:	8.3 kVA	3.7 kVA*
Prim. contin. current:	14 A	16 A*
Prim. max. current:	21 A	26 A*

Wire feeder: compact mounted, Model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 200/5
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

*: BiPowerPLUS: Multi voltage supply system: automatic switching between 1 and 3 phase in the range 220 – 440 V (option)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit MobiMIG 280 K						
	A	MIG/MAG welding unit MobiMIG 280 K		20	128432	3.900,00
	AB	MIG/MAG welding unit MobiMIG 280 K with accessories		20	SET128434	4.011,00
	ABC1	MIG/MAG welding unit MobiMIG 280 K with accessories and TEDAC hand welding torch SBT 307 G, 3 m		20	SET128436	4.306,00
	ABC2	MIG/MAG welding unit MobiMIG 280 K with accessories and TEDAC hand welding torch SBT 307 G, 4 m		20	SET128438	4.331,00
! Software ColdMIG included for free (Worth: 630,00 €).						
B Standard accessories:						
	B1	Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210401	68,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
	C2	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00
	C3	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 5 m		06	154994	345,00
D Accessories:						
	D1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	214,00
	D2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	52,00
	D3a	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/rubber hose assembly		10	133632	350,00
	D3b	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/rubber hose assembly		10	129532	480,00
	D4	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	D5a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D5b	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D6	Adapter for centering of small wire spool		46	133070	37,02
	D7	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

2.3
E Software (for free):


E1	Software for ColdMIG process for MobiMIG 280/320/321/322	17	128430	630,00
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F Additional wire equipment for DV-26:


F1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113846	78,50
F2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113848	78,50
F3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113852	97,00
F4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113854	97,00
F5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113858	99,50
F6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113860	99,50

2.3.3. MobiMIG 321 K

Primary:

Power supply:	3 x 400 V 3 x 220 - 440 V* 1 x 220 - 440 V*
Frequency:	50 / 60 Hz

Data at supply voltage: **3 x 400 V** | **1 x 230 V***

MIG/MAG operation:

Open circuit voltage:	90 V	103 V*
Welding voltage:	15 - 30 V	15 - 23 V*
Welding current:	25 - 320 A	25 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 30 % (10 min.):	320 A (40 °C)	
Duty cycle 35 % (10 min.):	300 A (40 °C)	
Duty cycle 60 % (10 min.):	260 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	240 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	11.1 kVA	3.7 kVA*
Prim. contin. current:	16 A	16 A*
Prim. max. current:	23 A	26 A*



Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	synergic operation, automatic energy control
Programs:	MIG/MAG, MMA/stick electrode, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, stitch, spot welding
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start
Power source:	inverter
Sockets 50 mm ² :	earth lead and electrode cable
Torch cooling:	gas, option: water
Mains supply cable:	4 x 2.5 mm ² , 5 m long with plug 400 V / 32 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	32 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Data at supply voltage: **3 x 400 V** | **1 x 230 V***

Option MMA/stick electrode operation:

Open circuit voltage:	90 V	103 V*
Welding voltage:	20.8 - 32 V	20.8 - 26.4 V*
Welding current:	20 - 300 A	20 - 160 A*
Duty cycle 20 % (10 min.):		160 A (40 °C)*
Duty cycle 30 % (10 min.):	300 A (40 °C)	
Duty cycle 60 % (10 min.):	250 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	230 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	12.5 kVA	3.7 kVA*
Prim. contin. current:	18 A	16 A*
Prim. max. current:	24 A	26 A*

Wire feeder: compact mounted, Model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

*: BiPowerPLUS: Multi voltage supply system:
automatic switching between 1 and 3 phase in the range 220 – 440 V
(option, not in combination with socket for water cooler)

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit MobiMIG 321 K					
A	MIG/MAG welding unit MobiMIG 321 K		01	156556	3.975,00
AB	MIG/MAG welding unit MobiMIG 321 K with accessories		01	SET156558	4.068,00
ABC1	MIG/MAG welding unit MobiMIG 321 K with accessories and TEDAC hand welding torch SBT 307 G, 3 m		01	SET156560	4.381,00
ABC2	MIG/MAG welding unit MobiMIG 321 K with accessories and TEDAC hand welding torch SBT 307 G, 4 m		01	SET156562	4.406,00



! **Software ColdMIG included for free (Worth: 630,00 €).**

With water cooler and trolley TW 112:

	MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112		01	SET156564	5.475,00
	MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112 incl. accessories		01	SET156566	5.586,00
	MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112, incl. accessories and TEDAC torch SBT 504 W, 3 m		01	SET156568	6.071,00
	MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112, incl. accessories and TEDAC torch SBT 504 W, 4 m		01	SET156570	6.096,00
	Option Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00

B Standard accessories:

	B1 Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210401	68,00
	B2 Regulator argon/CO2 standard version		46	107018	43,00

C Welding torches:

	C1 MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
	C2 MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00
	C3 MIG/MAG hand welding torch TEDAC, model SBT 307 G, 5 m		06	154994	345,00

D Accessories:

	D1 BiPowerPLUS for MobiMIG 321/322 not in combination with socket for water cooling unit		46	131446	235,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D2	Adapter: Schuko plug 230 V to CEE connector 32 A/400 V for MobiMIG 321/322		46	143244	60,00
	D3	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	D4a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D4b	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D5	Cover for operation panel for MobiMIG 320/321 K		46	155918	173,55
	D6	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	180,00
	D7	Filter frame incl. filter for MobiMIG 321 K, reduced duty cycle		46	160090	138,84
	D8	Filter 130x320x34 mm MobiMIG 321 K (min. 10 pieces)		46	160084	4,05
	D9	Connection for automated welding for MobiTIG 284/304 DC, MobiMIG 321/322 - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	123166	480,00
	D9a	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00
E Accessories for water cooler:						
	E1	Water cooling unit model WK 300		46	02610143	980,00
	E2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321		46	124858	185,00
	E3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	E4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	485,00
	E5	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	510,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	E7	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00

F Software (for free):


F1	Software for ColdMIG process for MobiMIG 280/320/321/322	17	128430	630,00
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G Additional wire equipment for DV-26:


G1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113846	78,50
G2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113848	78,50
G3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113852	97,00
G4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113854	97,00
G5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113858	99,50
G6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113860	99,50

2.3.4. MobiMIG 322 K

Primary:

Power supply: 3 x 400 V
 Frequency: 50 / 60 Hz

MIG/MAG operation:

Open circuit voltage: 90 V
 Welding voltage: 15 - 30 V
 Welding current: 25 - 320 A
 Duty cycle 20 % (10 min.):
 Duty cycle 30 % (10 min.): 320 A (40 °C)
 Duty cycle 35 % (10 min.): 300 A (40 °C)
 Duty cycle 60 % (10 min.): 270 A (40 °C)
 Duty cycle 100%: 250 A (40 °C)
 Prim. contin. power: 11,1 kVA
 Prim. contin. current: 16 A
 Prim. max. current: 23 A



Protection class: IP 23
 Insulation class: H
 Cooling: AF
 Arc length: synergic operation, automatic energy control
 Programs: MIG/MAG, MMA/stick electrode, ColdMIG
 Program selection: material, wire diameter and gas at the display
 Operation modes: 2-stroke, 4-stroke, stitch, spot welding
 Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function

Energy adjustment: at the machine,
 at the TEDAC torch
 Adjustable parameters: choke inductance, wire burn back, soft start
 Power source: inverter
 Sockets 50 mm²: earth lead and electrode cable
 Torch cooling: gas
 Mains supply cable: 4 x 2.5 mm², 5 m long with plug 400 V / 32 A
 Gas hpse: 2 m
 Handle: EN 60971-1 "S" / CE
 Weight: 52 kg
 Dimensions l x w x h.: 760 x 420 x 920 mm

Option MMA/stick electrode operation:

Open circuit voltage: 90 V
 Welding voltage: 20.8 - 32 V
 Welding current: 20 - 300 A
 Duty cycle 20 % (10 min.):
 Duty cycle 30 % (10 min.): 300 A (40 °C)
 Duty cycle 60 % (10 min.): 250 A (40 °C)
 Duty cycle 100%: 230 A (40 °C)
 Prim. contin. power: 12.5 kVA
 Prim. contin. current: 18 A
 Prim. max. current: 24 A

Wire feeder: compact mounted, Model DV-26

Supply: 26 V-DC
 Wire feed motor: DC motor with worm gear drive 0.5 - 25 m/min.
 Wire feed system: 4-roller-drive DV-26
 Reel hub assembly: D 300/15 DIN 8559
 Torch connection: EURO connector
 Standard wire equipment: mild steel 0,8 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit MobiMIG 322 K					
	A	MIG/MAG welding unit MobiMIG 322 K	01	166934	4.200,00
	AB	MIG/MAG welding unit MobiMIG 322 K with accessories	01	SET166936	4.311,00
	ABC1	MIG/MAG welding unit MobiMIG 322 K with accessories and TEDAC hand welding torch SBT 307 G, 3 m	01	SET166938	4.606,00
	ABC2	MIG/MAG welding unit MobiMIG 322 K with accessories and TEDAC hand welding torch SBT 307 G, 4 m	01	SET166940	4.631,00
B Standard accessories:					
	B1	Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp	46	02210401	68,00
	B2	Regulator argon/CO2 standard version	46	107018	43,00
C Welding torches:					
	C1	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m	06	02210858	295,00
	C2	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m	06	02210859	320,00
	C3	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 5 m	06	154994	345,00

2.3.5. MobiMIG 322 KW

Primary:

Power supply: 3 x 400 V
 Frequency: 50 Hz

MIG/MAG operation:

Open circuit voltage: 90 V
 Welding voltage: 15 - 30 V
 Welding current: 25 - 320 A
 Duty cycle 20 % (10 min.):
 Duty cycle 30 % (10 min.): 320 A (40 °C)
 Duty cycle 35 % (10 min.): 300 A (40 °C)
 Duty cycle 60 % (10 min.): 270 A (40 °C)
 Duty cycle 100%: 250 A (40 °C)
 Prim. contin. power: 11.1 kVA
 Prim. contin. current: 16 A
 Prim. max. current: 23 A



Protection class: IP 23
 Insulation class: H
 Cooling: AF
 Arc length: synergic operation, automatic energy control
 Programs: MIG/MAG, MMA/stick electrode, ColdMIG
 Program selection: material, wire diameter and gas at the display
 Operation modes: 2-stroke, 4-stroke, stitch, spot welding
 Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
 Energy adjustment: at the machine, at the TEDAC torch
 Adjustable parameters: choke inductance, wire burn back, soft start
 Power source: inverter
 Sockets 50 mm²: earth lead and electrode cable
 Torch cooling: integrated water cooler
 Mains supply cable: 4 x 2.5 mm², 5 m long with plug 400 V / 32 A
 Gas hpse: 2 m
 Handle: EN 60971-1 "S" / CE
 Weight: 63 kg
 Dimensions l x w x h.: 760 x 420 x 920 mm

Option MMA/stick electrode operation:

Open circuit voltage: 90 V
 Welding voltage: 20.8 - 32 V
 Welding current: 20 - 300 A
 Duty cycle 20 % (10 min.):
 Duty cycle 30 % (10 min.): 300 A (40 °C)
 Duty cycle 60 % (10 min.): 250 A (40 °C)
 Duty cycle 100%: 230 A (40 °C)
 Prim. contin. power: 12.5 kVA
 Prim. contin. current: 18 A
 Prim. max. current: 24 A

Wire feeder: compact mounted, Model DV-26

Supply: 26 V-DC
 Wire feed motor: DC motor with worm gear drive 0.5 - 25 m/min.
 Wire feed system: 4-roller-drive DV-26
 Reel hub assembly: D 300/15 DIN 8559
 Torch connection: EURO connector
 Standard wire equipment: mild steel 0,8 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit MobiMIG 322 KW					
A	MIG/MAG welding unit MobiMIG 322 KW		01	166164	4.850,00
AB	MIG/MAG welding unit MobiMIG 322 KW with accessories		01	SET166166	4.961,00
ABC1	MIG/MAG welding unit MobiMIG 322 KW with accessories and TEDAC hand welding torch SBT 504 W, 3 m		01	SET166168	5.446,00
ABC2	MIG/MAG welding unit MobiMIG 322 KW with accessories and TEDAC hand welding torch SBT 504 W, 4 m		01	SET166170	5.471,00



! Software ColdMIG included for free (Worth: 630,00 €).

B Standard accessories:



B1	Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp	46	02210401	68,00
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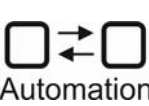
B2	Regulator argon/CO2 standard version	46	107018	43,00
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C Welding torches:



C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06	142482	485,00
C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06	142484	510,00
C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06	142660	535,00

2.3.6. Accessories for MobiMIG 322 K/KW

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:					
	1.1. BiPowerPLUS for MobiMIG 321/322 not in combination with socket for water cooling unit		46	131446	235,00
	1.2. Adapter: Schuko plug 230 V to CEE connector 32 A/400 V for MobiMIG 321/322		46	143244	60,00
	1.3. Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.4. Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	1.5. Connection for automated welding for MobiTIG 284/304 DC, MobiMIG 321/322 - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	123166	480,00
	1.6. Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	1.7. Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00
2 Software (for free):					
	2.1. Software for ColdMIG process for MobiMIG 280/320/321/322		17	128430	630,00
3 Additional wire equipment for DV-26:					
	3.1. Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	3.2. Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	3.3. Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	3.4. Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	3.5. Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
	3.6. Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	3.7. Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50

2.3.7. GreenMIG 400 KW

Primary:

Power supply: 3 x 400 V
 Frequency: 50 Hz
 Contin. power: 13.8 kVA
 Contin. current: 20 A
 Max. current: 25 A

Secondary:

Open circuit voltage: 70 V
 Welding voltage: 15.5 - 34 V
 Welding current: 30 - 400 A
 Duty cycle 60 % (10 min.): 400 A (40 °C)
 Duty cycle 100 %: 360 A (40 °C)



Protection class: IP 23
 Insulation class: F
 Cooling: AF
 Arc length: automatic energy control
 Programs: MIG/MAG, MIG brazing, PulseARC (option), MMA/stick electrode, DeepARC, ColdMIG
 Program selection: material, wire diameter and gas at the display
 Operation modes: 2-stroke, 4-stroke, 4-stroke with start current, (stitch, spot welding)
 Gas check: button with hold function and automatic switch off
 Button: Wire inching
 Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
 Energy adjustment: at the machine, at the TEDAC torch
 Adjustable parameters: choke inductance, wire burn back, soft start (programmable)
 Jobs: 100 jobs
 Control: via touch display and/or rotary encoder with push button
 Rotary encoder: energy, arc length
 Power source: inverter
 Sockets 95 mm²: earth lead and electrode cable
 Torch cooling: integrated water cooler
 Mains supply cable: 4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
 Gas hose: 2 m
 Gas bottle holder: for 10, 20 and 50 l cylinders
 Stabilization: ± 10 % power mains fluctuation
 Air filter: as a standard
 Norm: EN 60974-1 "S" / CE
 Weight: 109 kg
 Dimensions l x w x h: 1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply: 26 V-DC/42 V-AC
 Wire feed motor: DC motor with worm gear drive 0.5 - 25 m/min.
 Gear: 4-roller-drive DV-26
 Reel hub assembly: D 300/15 DIN 8559
 Torch connection: Euro connector
 Standard wire equipment: mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit GreenMIG 400 KW						
	A	Synergic MIG welding unit GreenMIG 400 KW		01	163730	6.150,00
	AB	Synergic MIG welding unit GreenMIG 400 KW with accessories		01	SET163732	6.348,00
	ABC1	Synergic MIG welding unit GreenMIG 400 KW with accessories and TEDAC torch SBT 504 W, 3 m		01	SET163734	6.833,00
	ABC2	Synergic MIG welding unit GreenMIG 400 KW with accessories and TEDAC torch SBT 504 W, 4 m		01	SET163736	6.858,00
B Standard accessories:						
	B1	Earth lead 70 mm ² , 4 m long with plug and earth clamp		46	02210408	123,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00
D Software upgrade:						
	D1	Upgrade GreenMIG 400/500 to PulseARC welding incl. Interpulse (NOTE: Can only be installed starting from Rev. Inv. ME-I6 1.4A and ME-ISD1.2A)		17	168876	1.200,00
	D2	Upgrade for GreenMIG 400/500 aluminium programs		17	168878	290,00
	D3	Upgrade for GreenMIG 400/500 stainless steel programs		17	168882	290,00

2.3.8. GreenMIG 500 KW

Primary:

Power supply:	3 x 400 V
Frequency:	50 Hz
Contin. power:	14.8 kVA
Contin. current:	26 A
Max. current:	38 A

Secondary:

Open circuit voltage:	70 V
Welding voltage:	15.5 - 39 V
Welding current:	30 - 500 A
Duty cycle 40 % (10 min.):	500 A (40 °C)
Duty cycle 60 % (10 min.):	440 A (40 °C)
Duty cycle 100 %:	390 A (40 °C)



Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, MIG brazing, PulseARC (option), MMA/stick electrode, DeepARC, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, (stitch, spot welding)
Gas check:	button with hold function and automatic switch off
Button:	Wire inching
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start (programmable)
Jobs:	100 jobs
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	for earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	109 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MIG/MAG welding unit GreenMIG 500 KW						
	A	Synergic MIG welding unit GreenMIG 500 KW		01	164800	6.980,00
	AB	Synergic MIG welding unit GreenMIG 500 KW with accessories		01	SET164802	7.179,00
	ABC1	Synergic MIG welding unit GreenMIG 500 KW with accessories and TEDAC torch SBT 504 W, 3 m		01	SET164804	7.663,00
	ABC2	Synergic MIG welding unit GreenMIG 500 KW with accessories and TEDAC torch SBT 504 W, 4 m		01	SET164806	7.688,00
B Standard accessories:						
	B1	Earth lead 70 mm ² , 4 m long with plug and earth clamp		46	02210408	123,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00
D Software upgrade:						
	D1	Upgrade GreenMIG 400/500 to PulseARC welding incl. Interpulse (NOTE: Can only be installed starting from Rev. Inv. ME-I6 1.4A and ME-ISD1.2A)		17	168876	1.200,00
	D2	Upgrade for GreenMIG 400/500 aluminium programs		17	168878	290,00
	D3	Upgrade for GreenMIG 400/500 stainless steel programs		17	168882	290,00

2.3.9. GreenMIG 400 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	25 A

Secondary:

Open circuit voltage:	70 V
Welding voltage:	15.5 - 34 V
Welding current:	30 - 400 A
Duty cycle 60 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)



Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, MIG brazing, PulseARC (option), MMA/stick electrode, DeepARC, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start (programmable)
Jobs:	100 jobs
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	130 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG welding unit GreenMIG 400 DW with wire feeder and 1.6 m interconnection cable:						
With DV-26 wire feeder:						
	AB1	Synergic MIG welding unit GreenMIG 400 DW (DV-26)		01	SET163650	7.700,00
	AB1C	Synergic MIG welding unit GreenMIG 400 DW (DV-26) with accessories		01	SET163652	7.898,00
	AB1CD1	Synergic MIG welding unit GreenMIG 400 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m		01	SET163654	8.383,00
	AB1CD2	Synergic MIG welding unit GreenMIG 400 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		01	SET163656	8.408,00
A Power source (without wire feeder):						
	A	Synergic MIG welding unit (power source) GreenMIG 400 DW, without wire feeder		01	163650	5.580,00
B Wire feeder:						
	B1	Wire feeder DV-26 for GreenMIG, SpeedMIG touch incl. control panel		46	155550	1.740,00
! Use wire feeder DV-31 for wire > 1.2 mm:						
	B2	Wire feeder DV-31 (OT) for GreenMIG, SpeedMIG touch incl. control panel		46	155551	2.390,00
C Standard accessories:						
	C1	Earth lead 70 mm ² , 4 m long with plug and earth clamp		46	02210408	123,00
	C2	Regulator argon/CO ₂ , single stage		46	01200300	75,00
D Welding torches:						
	D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00
E Software upgrade:						
	E1	Upgrade GreenMIG 400/500 to PulseARC welding incl. Interpulse (NOTE: Can only be installed starting from Rev. Inv. ME-I6 1.4A and ME-ISD1.2A)		17	168876	1.200,00
	E2	Upgrade for GreenMIG 400/500 aluminium programs		17	168878	290,00
	E3	Upgrade for GreenMIG 400/500 stainless steel programs		17	168882	290,00

2.3.10. GreenMIG 500 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 Hz
Contin. power:	14.8 kVA
Contin. current:	26 A
Max. current:	38 A

Secondary:

Open circuit voltage:	70 V
Welding voltage:	15.5 - 39 V
Welding current:	30 - 500 A
Duty cycle 40 % (10 min.):	500 A (40°C)
Duty cycle 60 % (10 min.):	440 A (40 °C)
Duty cycle 100 %:	390 A (40 °C)



Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, MIG brazing, PulseARC (option), MMA/stick electrode, DeepARC, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start (programmable)
Jobs:	100 jobs
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	130 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG welding unit GreenMIG 500 DW with wire feeder and 1.6 m interconnection cable:					

With DV-26 wire feeder:


AB1	Synergic MIG welding unit GreenMIG 500 DW (DV-26)		01	SET164700	8.530,00
AB1C	Synergic MIG welding unit GreenMIG 500 DW (DV-26) with accessories		01	SET164702	8.728,00
AB1CD1	Synergic MIG welding unit GreenMIG 500 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m		01	SET164704	9.213,00
AB1CD2	Synergic MIG welding unit GreenMIG 500 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		01	SET164706	9.238,00

A Power source (without wire feeder):

A	Synergic MIG welding unit (power source) GreenMIG 500 DW, without wire feeder		01	164700	6.410,00
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B Wire feeder:


B1	Wire feeder DV-26 for GreenMIG, SpeedMIG touch incl. control panel		46	155550	1.740,00
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! Use wire feeder DV-31 for wire > 1.2 mm:


B2	Wire feeder DV-31 (OT) for GreenMIG, SpeedMIG touch incl. control panel		46	155551	2.390,00
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C Standard accessories:


C1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
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C2	Regulator argon/CO2, single stage		46	01200300	75,00
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D Welding torches:


D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

E Software upgrade:


E1	Upgrade GreenMIG 400/500 to PulseARC welding incl. Interpulse (NOTE: Can only be installed starting from Rev. Inv. ME-I6 1.4A and ME-ISD1.2A)		17	168876	1.200,00
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E2	Upgrade for GreenMIG 400/500 aluminium programs		17	168878	290,00
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E3	Upgrade for GreenMIG 400/500 stainless steel programs		17	168882	290,00
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2.3.11. Accessories for GreenMIG 400/500 KW/DW

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:					
	1.1 Adapter for wire spool		46	02900104	23,50
	1.2 Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3 Connection for remote control incl. socket 10-pol for SpeedMIG touch, GreenMIG KW		46	155850	135,00
	1.4 Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	1.5 Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	1.6 Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	1.7 Filter 340 x 190 mm for HighPULSE touch, GreenMIG 400/450/500 (minimum 10 pieces)	10 pcs	46	155848	4,60
	1.8a Price reduction: no integrated water cooling unit (K version)		46	111832	-490,00
	1.8b Price reduction: no integrated water cooling unit (D version)		46	01903611	-510,00
	1.9 Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	1.10a MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	485,00
	1.10b MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	510,00
	1.12 Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00
2 Accessories for wire feeder:					
	2.1 Rotatable device for wire feeder including screw set		46	137436	189,00
	2.2 4 wheels mounted on the wire feeder		46	00102109	75,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	2.3a	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch, GreenMIG		46	137546	195,00
	2.3b	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and GreenMIG		46	137547	170,00
	2.4	Control 'end of welding wire', installed in the wire feeder box		46	103365	280,00
	2.5	Suspension device for wire feeder electrically isolated		46	00502878	105,00
	2.6	Connection for wire feed liner inside the wire feeder box		46	110454	85,00

3 Connection cable for controller in wire feeder:

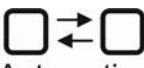
	3.1	Connection cable 5 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138518	655,00
	3.2	Connection cable 10 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138520	1.030,00
	3.3	Connection cable 15 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138522	1.455,00
	3.4	Connection cable 20 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138524	1.760,00
	3.5	Connection cable 30 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 incl. control cable for controller in wire feeder		46	145740	1.950,00

Price reduction, when not taken:

	3.6	Connection cable 1.6 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138516	380,00
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4 Software:

	4.1	Upgrade GreenMIG 400/500 to PulseARC welding incl. Interpulse (NOTE: Can only be installed starting from Rev. Inv. ME-I6 1.4A and ME-ISD1.2A)		17	168876	1.200,00
	4.2	Upgrade for GreenMIG 400/500 aluminium programs		17	168878	290,00
	4.3	Upgrade for GreenMIG 400/500 stainless steel programs		17	168882	290,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
5 Automation accessories:					
 Automation	5.1	Connection automated welding GreenMIG, SMT emerg. STOP, welding ON, arc OK - socket 6 pol.	46	155852	380,00
	5.2	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
6 Additional wire equipment for DV-26 and DV-31:					
	6.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113846	78,50
	6.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113848	78,50
	6.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)	46	113850	78,50
	6.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113852	97,00
	6.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113854	97,00
	6.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)	46	113856	97,00
	6.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)	46	113858	99,50
	6.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113860	99,50
	6.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)	46	113862	99,50
	6.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)	46	113864	103,70
	6.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)	46	113866	103,70
	6.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)	46	113868	279,00
	6.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)	46	113870	279,00
	6.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)	46	113872	279,00

3. Synergic Pulse welding units

3. Synergic Pulse welding units

3.1 Synergic Pulse welding units with touch control

HighPULSE touch 280/350 K

HighPULSE touch 400/450 KW

HighPULSE touch 400/450 DW

3.2 Synergic Pulse welding units

HighPULSE 284/354/353 K

HighPULSE 454/554 KW

HighPULSE 354/454/554 DW

3.3 Synergic Pulse welding units for automation and robotics

HighPULSE 354/454/554 RS

3.1. Synergic Pulse welding units - Series HighPULSE touch



3.1.1. HighPULSE touch 350 K

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

Synergic pulse / MIG operation:

Open circuit voltage: 57 V
Welding voltage: 15 - 31.5 V
Welding current: 25 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 60 % (10 min.): 280 A (40 °C) | 330 A (20 °C)
Duty cycle 100 %: 250 A (40 °C) | 280 A (20 °C)
Prim. contin. power: 12.5 kVA
Prim. contin. current: 18 A
Prim. max. current: 25 A



Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.



3.1

Protection class: IP 23
Insulation class: H
Cooling: AF
Arc length: automatic energy control
Programs: MIG/MAG, PulseARC, Interpulse, MMA, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection: material, wire diameter and gas at the display
Operation modes: 2-stroke, 4-stroke, 4-stroke with start current
Gas check: button with hold function and automatic switch off
Wire inching: button and wire inching automatic
Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment: at the machine, at the TEDAC torch,
Adjustable parameters: choke inductance, wire burn back, pulse shape
Control: via touch display and/or rotary encoder with push button
Rotary encoder: energy, arc length
Job mode: 2000 Jobs programmable
Cover: transparent, to protect the control panel
Power source: inverter
Sockets 50 mm²: earth lead and electrode cable
Torch cooling: gas (option: water)
Socket water cooling unit: 6 pol.
Mains supply cable: 4 x 2,5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose: 2 m
Handle: on top of the machine
Norm: EN 60974-1 "S" / CE
Weight: 36.5 kg
Dimensions l x w x h: 600 x 300 x 565 mm

Option MMA/stick electrode operation:

Open circuit voltage: 57 V
Welding voltage: 20 - 34 V
Welding current: 20 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 100 %: 250 A (40 °C)
Prim. contin. power: 13.1 kVA
Prim. contin. current: 19 A
Prim. max. current: 27 A

Wire feeder: compact mounted, Model DV-26

Supply: 26 V-DC
Wire feed motor: DC motor with worm gear drive
0.5 - 25 m/min.
Wire feed system: 4-roller-drive DV-26
Reel hub assembly: D 300/15 DIN 8559
Torch connection: EURO connector
Standard wire equipment: mild steel 1.2 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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A Portable Synergic Pulse welding unit HighPULSE touch 350 K



A	Synergic MIG Pulse welding unit HighPULSE touch 350 K		30	158988	6.850,00
AB	Synergic Pulse welding unit HighPULSE touch 350 K with accessories		30	SET158522	7.013,00
ABC1	Synergic Pulse welding unit HighPULSE touch 350 K with accessories and TEDAC torch SBT 307 G, 3 m		30	SET158524	7.308,00
ABC2	Synergic MIG Pulse welding unit HighPULSE touch 350 K with accessories and TEDAC torch SBT 307 W, 4 m		30	SET158526	7.333,00

With water cooler and trolley TW 112:



	Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 300, trolley TW 112		30	SET158620	8.165,00
	Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 300, trolley TW 112, accessories		30	SET158622	8.328,00
	Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 3 m		30	SET158624	8.813,00
	Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 4 m		30	SET158626	8.838,00



Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
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! Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)

B Standard accessories:



B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
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B2	Regulator argon/CO2, single stage		46	01200300	75,00
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C Welding torches:



C1	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
C2	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00

3.1.2. Accessories for HighPULSE touch 350 K

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Accessories:					
	1.1	Adapter for wire spool		46	02900104	23,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	1.3b	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	1.4	Push-Pull kit incl. socket 10-pol and switches for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107706	790,00
	1.5	Connection for remote control incl. socket for HighPULSE, SpeedMIG, OptiMIG in K version		46	155486	75,00
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	1.7	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	1.8	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	395,00
	1.9	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	180,00
	1.10	Filter frame incl. filter for HighPULSE 282, 284, 352, 354 K and HighPULSE touch 280/350 K reduced duty cycle		46	108424	133,00
	1.11	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	4,60
	1.12	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	138,00
	1.13	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
2 Accessories for water cooler:						
	2.1	Water cooling unit model WK 300		46	02610143	980,00
	2.2	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	2.3	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	485,00
	2.4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	510,00
	2.5	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	2.6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
3 Software (for free):						
	3.1	Software for DeepARC process for series HighPULSE/GreenMIG		17	120488	880,00
	3.2	Software for ColdMIG process for series HighPULSE/GreenMIG		17	118064	880,00
	3.3	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00
4 Software:						
	4.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	233,00
	4.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
	4.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
	4.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00
5 Automation accessories:						
	5.1	Connection for automated welding for hand welding unit HighPULSE, SpeedMIG, HighTIG - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	390,00
	5.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
6	Additional wire equipment for DV-26:				
6.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
6.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
6.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
6.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
6.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
6.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50



3.1.3. Water cooling unit WK 300

Power supply:	230 V
Frequency:	50 Hz
Mains current:	1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
Electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Water cooling unit:					
	Water cooling unit model WK 300		46	02610143	980,00
B Accessories:					
	B1 Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	185,00
	B2 Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

3.1.4. HighPULSE touch 400 KW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	25 A

Secondary:

Open circuit voltage:	67 V
Welding voltage:	15 - 34 V
Welding current:	20 - 400 A
Duty cycle 80 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)



3.1

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA, Interpulse, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	112 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Synergic Pulse welding unit HighPULSE touch 400 KW						
	A	Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26)		30	158992	8.600,00
	AB	Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories		30	SET158722	8.798,00
	ABC1	Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m		30	SET158724	9.283,00
	ABC2	Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		30	SET158726	9.308,00
B Standard accessories:						
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

3.1.5. HighPULSE touch 450 KW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A

Secondary:

Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)



3.1

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA, Interpulse, MIG blazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	112 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Synergic Pulse welding unit HighPULSE touch 450 KW						
	A	Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26)		30	158994	9.050,00
	AB	Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access.		30	SET158996	9.307,00
	ABC1	Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m		30	SET158998	9.792,00
	ABC2	Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m		30	SET159000	9.817,00
B Standard accessories:						
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

3.1.6. HighPULSE touch 400 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	25 A

Secondary:

Open circuit voltage:	67 V
Welding voltage:	15 - 34 V
Welding current:	20 - 400 A
Duty cycle 80 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)



3.1

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA, Interpulse, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	133 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Synergic Pulse welding unit HighPULSE touch 400 DW incl. DV-26 and 1.6 m interconnection cable:					
AB1	Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26)	30		SET158986	10.100,00
AB1C	Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access.	30		SET158988	10.298,00
AB1CD1	Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m	30		SET158990	10.783,00
AB1CD2	Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m	30		SET158992	10.808,00
A Power source (without wire feeder):					
A	Synergic MIG Pulse welding unit HighPULSE touch 400 DW Power source (without wire feeder)	30		158986	8.370,00
B Wire feeder:					
B1	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG	46		137652	1.400,00
! Use wire feeder DV-31 for wire > 1.2 mm:					
B2	Wire feeder DV-31 (OT) for HighPULSE, HighPULSE touch, SpeedMIG	46		137650	2.050,00
C Standard accessories:					
C1	Earth lead 70 mm ² , 4 m long with plug and earth clamp	46		02210408	123,00
C2	Regulator argon/CO ₂ , single stage	46		01200300	75,00
D Welding torches:					
D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06		142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06		142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06		142660	535,00

3.1.7. HighPULSE touch 450 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A

Secondary:

Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)



3.1

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA, Interpulse, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	133 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Synergic Pulse welding unit HighPULSE touch 450 DW incl. DV-26 and 1.6 m interconnection cable:					
AB1	Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26)	30		SET158710	10.550,00
AB1C	Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access.	30		SET158712	10.807,00
AB1CD1	Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m	30		SET158714	11.292,00
AB1CD2	Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m	30		SET158716	11.317,00
A Power source (without wire feeder):					
A	Synergic MIG Pulse welding unit HighPULSE touch 450 DW Power source (without wire feeder)	30		158710	8.820,00
B Wire feeder:					
B1	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG	46		137652	1.400,00
! Use wire feeder DV-31 for wire > 1.2 mm:					
B2	Wire feeder DV-31 (OT) for HighPULSE, HighPULSE touch, SpeedMIG	46		137650	2.050,00
C Standard accessories:					
C1	Earth lead 95 mm ² , 4 m long with plug and earth clamp	46		02210403	182,00
C2	Regulator argon/CO ₂ , single stage	46		01200300	75,00
D Welding torches:					
D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06		142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06		142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06		142660	535,00

3.1.8. Accessoires for HighPULSE touch 400/450 KW/DW

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:					
	1.1 Adapter for wire spool		46	02900104	23,50
	1.2 Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3a Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG KW		46	138290	790,00
	1.3b Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG DW		46	138286	790,00
	1.4a Connection for remote control incl. socket for HP, SM in KW version		46	155484	75,00
	1.4b Connection for remote control incl. switch and socket for HighPULSE, SpeedMIG, OptiMIG in DW version		46	02110427	75,00
	1.5 Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	1.6 Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	1.7 Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	1.8 Filter 340 x 190 mm for HighPULSE touch, GreenMIG 400/450/500 (minimum 10 pieces)	10 pcs	46	155848	4,60
	1.9a Price reduction: no integrated water cooling unit (K version)		46	111832	-490,00
	1.9b Price reduction: no integrated water cooling unit (D version)		46	01903611	-510,00
	1.10 Lifting eye screw, galvanized	4 pcs	46	09002001	4,75

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.11a	Cover WITH lock, transparent, for power source HighPULSE touch, GreenMIG Version KW and DW		46	158746	160,00
	1.11b	Cover WITHOUT lock, transparent, for power source HighPULSE touch, GreenMIG Version KW and DW		46	159398	150,00
	1.12	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

2 Accessories for wire feeder:



2.1	Rotatable device for wire feeder including screw set	46	137436	189,00
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2.2	4 wheels mounted on the wire feeder	46	00102109	75,00
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2.3	Standard operation panel inside wire feeder for series HighPULSE, HighPULSE touch and SpeedMIG (only with special interconnection cable)	46	138526	175,00
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2.4	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and GreenMIG	46	137547	170,00
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2.5	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch, GreenMIG	46	137546	195,00
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2.6	Control 'end of welding wire', installed in the wire feeder box	46	103365	280,00
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2.7	Suspension device for wire feeder electrically isolated	46	00502878	105,00
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2.8	Balancer G4 for rotatable device 137.436	05	158714	1.150,00
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2.9	Wider wheel base (front) for HighPULSE touch, SpeedMIG touch DW	46	160188	115,00
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2.10	Connection for wire feed liner inside the wire feeder box	46	110454	85,00
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Pos.	Description	Pu	PrGrp	Part No.	Price/€
3	Connection cable to wire feeder for controller in machine:				
3.1	Connection cable 5 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	138844	595,00
3.2	Connection cable 10 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	138846	890,00
3.3	Connection cable 15 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	153218	1.150,00
3.4	Connection cable 20 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	153220	1.505,00
3.5	Connection cable 30 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		46	154388	1.730,00

Price reduction, when not taken:

3.6	Connection cable 1.6 m 70 mm ² , w.c. HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	138842	330,00
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4 Connection cable for controller in wire feeder:

4.1	Connection cable 1.6 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder	46	138516	380,00
4.2	Connection cable 5 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder	46	138518	655,00
4.3	Connection cable 10 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder	46	138520	1.030,00
4.4	Connection cable 15 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder	46	138522	1.455,00
4.5	Connection cable 20 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder	46	138524	1.760,00
4.6	Connection cable 30 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 incl. control cable for controller in wire feeder	46	145740	1.950,00

5 Software (for free):


5.1	Software for DeepARC process for series HighPULSE/GreenMIG	17	120488	880,00
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5.2	Software for ColdMIG process for series HighPULSE/GreenMIG	17	118064	880,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	5.3	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00

6 Software:



6.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	233,00
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6.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
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6.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
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6.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00
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7 Automation accessories:



7.1	Connection for automated welding for hand welding unit HighPULSE, SpeedMIG, HighTIG - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	390,00
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7.1a	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
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7.2	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage OUTPUT 0 - 10 V - socket 10 pol.		46	158270	1.450,00
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7.2a	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00
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7.3	Bus interface "Universal" for hand welding units HighPULSE, ProfiNet, EtherCAT, EtherNet/IP, Modbus TCP u. RTU incl. serial-to-serial converter and 10 pole socket (please specify the required bus version)		17	167062	2.760,00
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7.4	Digital interface for job operation (6 bit - 63 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	1.230,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	7.4a	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	167,00

8 Additional wire equipment for DV-26 and DV-31:

	8.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	8.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	8.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	78,50
	8.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	8.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	8.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
	8.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	8.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
	8.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	99,50
	8.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	103,70
	8.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	103,70
	8.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	279,00
	8.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	279,00
	8.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	279,00

3.2. Synergic Pulse welding units for hand welding - Series HighPULSE



3.2.1. HighPULSE 354 K

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

Synergic pulse / MIG operation:

Open circuit voltage: 57 V
Welding voltage: 15 - 31.5 V
Welding current: 25 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 60 % (10 min.): 280 A (40 °C) | 330 A (20 °C)
Duty cycle 100 %: 250 A (40 °C) | 280 A (20 °C)
Prim. contin. power: 12.5 kVA
Prim. contin. current: 18 A
Prim. max. current: 25 A



Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.



3.2

Protection class: IP 23
Insulation class: H
Cooling: AF
Arc length: automatic energy control
Program capacity: 256 programs
Schweißverfahren: MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, TIG DC, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection: material, wire diameter and gas at the display
Operation modes: 2-stroke, 4-stroke, 4-stroke with start current, stitch, spot welding
Gas check: button with hold function and automatic switch off
Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment: at the machine, at the TEDAC torch, job mode
LEDs: Mains, failure, temp. protection, hold function
Adjustable parameters: choke inductance, pulse shape
Automated functions: wire burn back, soft start (programmable)
Job mode: 2000 Jobs programmable
Cover: transparent, to protect the control panel
Power source: inverter
Sockets 50 mm²: earth lead and electrode cable
Torch cooling: gas (option: water)
Socket water cooling unit: 6 pol.
Mains supply cable: 4 x 2,5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose: 2 m
Handle: on top of the machine
Norm: EN 60974-1 "S" / CE
Weight: 36.5 kg
Dimensions l x w x h: 600 x 300 x 565 mm

Option TIG operation:

Open circuit voltage: 57 V
Welding voltage: 10 - 24 V
Welding current: 10 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 60 % (10 min.): 280 A (40 °C)
Duty cycle 100 %: 250 A (40 °C)
Prim. contin. power: 11.1 kVA
Prim. contin. current: 16 A
Prim. max. current: 23 A

Option MMA/stick electrode operation:

Open circuit voltage: 57 V
Welding voltage: 20 - 34 V
Welding current: 20 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 100 %: 250 A (40 °C)
Prim. contin. power: 13.1 kVA
Prim. contin. current: 19 A
Prim. max. current: 27 A

Wire feeder: compact mounted, Model DV-26

Supply: 26 V-DC
Wire feed motor: DC motor with worm gear drive
0.5 - 25 m/min.
Wire feed system: 4-roller-drive DV-26
Reel hub assembly: D 300/15 DIN 8559
Torch connection: EURO connector
Standard wire equipment: mild steel 1.2 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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A Portable Synergic Pulse welding unit HighPULSE 354 K



A	Synergic MIG Pulse welding unit HighPULSE 354 K		30	154136	7.400,00
AB	Synergic Pulse welding unit HighPULSE 354 K with accessories		30	SET154144	7.563,00
ABC1	Synergic Pulse welding unit HighPULSE 354 K with accessories and TEDAC torch SBT 307 G, 3 m		30	SET154146	7.858,00
ABC2	Synergic Pulse welding unit HighPULSE 354 K with accessories and TEDAC torch SBT 307 G, 4 m		30	SET154148	7.883,00

With water cooler and trolley TW 112:



	Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112		30	SET154150	8.715,00
	Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories		30	SET154152	8.878,00
	Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 3 m		30	SET154154	9.363,00
	Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 4 m		30	SET154156	9.388,00



Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
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B Standard accessories:



B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
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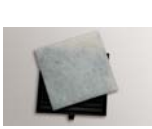
B2	Regulator argon/CO2, single stage		46	01200300	75,00
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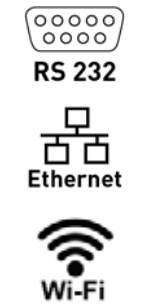
C Welding torches:



C1	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
C2	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00

3.2.2. Accessories for HighPULSE 354 K

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Accessories:					
	1.1	Adapter for wire spool		46	02900104	23,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	1.3b	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	1.4	Push-Pull kit incl. socket 10-pol and switches for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107706	790,00
	1.5	Connection for remote control incl. socket for HighPULSE, SpeedMIG, OptiMIG in K version		46	155486	75,00
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	1.7	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	1.8	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	395,00
	1.9	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	180,00
	1.10	Filter frame incl. filter for HighPULSE 282, 284, 352, 354 K and HighPULSE touch 280/350 K reduced duty cycle		46	108424	133,00
	1.11	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	4,60
	1.12	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	138,00
	1.13	Key switch for locking the system in job mode for HighPULSE and HighTIG series		46	148246	129,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
2 Accessories for TIG operation:						
	2.1a	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/rubber hose assembly		10	133632	350,00
	2.1b	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/rubber hose assembly		10	129532	480,00
	2.2	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/rubber hose assembly		10	145092	555,00
3 Accessories for water cooler:						
	3.1	Water cooling unit model WK 300		46	02610143	980,00
	3.2	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	3.3	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	485,00
	3.4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	510,00
	3.5	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	3.6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
4 Interface power source <-> computer:						
	4.1	RS 232 Interface for series HighPULSE standard equipment		17	126540	0,00
	4.2	Ethernet interface for HighPULSE		17	126506	1.190,00
	4.3	Option Wifi equipment only in combination with 126.506 or 159.190		17	144106	225,00
5 Software (for free):						
	5.1	Software for DeepARC process for series HighPULSE/GreenMIG		17	120488	880,00
	5.2	Software for ColdMIG process for series HighPULSE/GreenMIG		17	118064	880,00
	5.3	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00
	5.4	Software for Interpulse process for series HighPULSE		17	120490	280,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
6 Software:						
   	6.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	233,00
	6.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
	6.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
	6.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00
7 Robot and automation accessories:						
 Automation  Automation  Automation 	7.1	Connection for automated welding for hand welding unit HighPULSE, SpeedMIG, HighTIG - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	390,00
	7.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	7.3	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage OUTPUT 0 - 10 V - socket 10 pol.		46	158270	1.450,00
	7.4	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00
8 Additional wire equipment for DV-26:						
	8.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	8.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	8.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	8.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	8.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	8.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50

3.2.3. Water cooling unit WK 300

Power supply:	1 x 400 V / 230 V
Frequency:	50 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm



	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Water cooling unit:						
	A	Water cooling unit model WK 300		46	02610143	980,00
B Accessories:						
	B1	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	185,00
	B2	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

3.2.4. HighPULSE 353 K

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

Synergic pulse/MIG operation:

Open circuit voltage: 57 V
Welding voltage: 15 - 31.5 V
Welding current: 25 - 350 A
Duty cycle 40 % (10 min.): 350 A (40 °C)
Duty cycle 60 % (10 min.): 280 A (40 °C) | 330 A (20 °C)
Duty cycle 100 %: 250 A (40 °C) | 280 A (20 °C)
Prim. contin. power: 12.5 kVA
Prim. contin. current: 18 A
Prim. max. current: 25 A



3.2

Protection class: IP 20
Insulation class: H
Cooling: AF
Arc length: automatic energy control
Program capacity: 512 programs
Programs: MIG/MAG, PulseARC, InterPULSE, DeepARC, ColdMIG, HighUP
Adjustable parameters: choke inductance, pulse shape wire burn back
Automated functions: soft start (programmable)
Power source: inverter
Socket 50 mm²: earth lead
Torch cooling: gas
Mains supply cable: 4 x 4 mm², 5 m long with plug 3 x 400 V / 32 A
Gas hose: 2 m
Suspension device: on top of the machine
Norm: EN 60974-1 "S" / CE
Weight: 49.6 kg
Dimensions l x w x h: 720 x 170 x 630 mm

With JOB operation panel:



Job mode: 4 Jobs, selectable at the TEDAC torch
Potentiometer: trim (arc length or wire feed speed)
Job display: 4 big display modules
Buttons: gas check and wire inching
Socket: connection of external operation panel

With standard operation panel:



Program selection: material, wire diameter and gas at the display
Operation modes: 2-stroke, 4-stroke, 4-stroke with start current, stitch, spot welding
LEDs: Mains, failure, temp. protection, hold function
Energy adjustment: at the machine, at the TEDAC torch, job mode
Job mode: 999 jobs programmable
Digital display: current, voltage, wire feed speed and material thickness with pre-display and hold function
Potentiometers: energy and arc trim
Buttons: gas check and wire inching

Wire feeder compact mounted: Model DV-26

Supply: 26 V-DC / 42 V-AC
Wire feed motor: DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system: 4-roller-drive DV-26
Reel hub assembly: D 300/15 DIN 8559
Torch connection: EURO connector
Standard wire equipment: mild steel 1.2 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A With standard operation panel:					
	A Synergic MIG Pulse welding unit HighPULSE 353 K, slim version incl. standard operation panel		30	SET131919	8.050,00
B With JOB operation panel:					
	B Synergic MIG Pulse welding unit HighPULSE 353 K, slim version incl. operation panel with 4 jobs		30	SET131918	7.750,00
C Accessories:					
	C1 Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
	C2 Regulator argon/CO2, single stage		46	01200300	75,00
	C3 Adapter for wire spool		46	02900104	23,50
	C4 MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.670,00
	C5 Torch holder for HighPULSE 351/353 K bent, for SB/ST torches		46	129972	105,00
	C6 Torch holder for HighPULSE 351/353 K bent, for RSB/T torches		46	129976	95,00
D Welding torches:					
	D1 MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
	D2 MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00
	D3 MIG/MAG hand welding torch TEDAC, model SBT 351 G, 3 m		06	112938	295,00
	D4 MIG/MAG hand welding torch TEDAC, model SBT 351 G, 4 m		06	112940	320,00
	D5 Fume extraction torch TEDAC, model RSBT 351 G, 3 m		06	129276	750,00
	D6 Fume extraction torch TEDAC, model RSBT 351 G, 4 m		06	129278	780,00

3.2.5. HighPULSE 454 KW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	15.9 kVA
Contin. current:	23 A
Max. current:	34 A

Secondary:

Open circuit voltage:	72 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 50 % (10 min.):	450 A (40 °C)
Duty cycle 60 % (10 min.):	450 A (25 °C) 400 A (40 °C)
Duty cycle 100 %:	400 A (25 °C) 330 A (40 °C)



3.2

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Weight:	115 kg
Dimensions l x w x h:	1100 x 490 x 895 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Synergic Pulse welding unit HighPULSE 454 KW						
	A	Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26)		30	SET154198	10.450,00
	AB	Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories		30	SET154200	10.707,00
	ABC1	Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m		30	SET154202	11.192,00
	ABC2	Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		30	SET154204	11.217,00
B Standard accessories:						
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

3.2.6. HighPULSE 554 KW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	19.4 kVA
Contin. current:	28 A
Max. current:	45 A

Secondary:

Open circuit voltage:	72 V
Welding voltage:	15 - 41.5 V
Welding current:	20 - 550 A
Duty cycle 40 % (10 min.):	550 A (40 °C)
Duty cycle 50 % (10 min.):	500 A (40 °C)
Duty cycle 60 % (10 min.):	550 A (20 °C) 470 A (40 °C)
Duty cycle 100 %:	500 A (20 °C) 420 A (40 °C)



3.2

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Weight:	120 kg
Dimensions l x w x h:	1100 x 490 x 895 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Synergic Pulse welding unit HighPULSE 554 KW						
	A	Pulse-Arc welding unit HighPULSE 554 KW (DV-26)		30	155582	10.950,00
	AB	Synergic MIG Pulse welding unit HighPULSE 554 KW (DV-26) with accessories		30	SET135794	11.207,00
	ABC1	Synergic MIG Pulse welding unit HighPULSE 554 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m		30	SET135796	11.692,00
	ABC2	Synergic MIG Pulse welding unit HighPULSE 554 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		30	SET135798	11.717,00
B Standard accessories:						
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00

3.2.7. HighPULSE 354 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	14.5 kVA
Contin. current:	21 A
Max. current:	25 A

Secondary:

Open circuit voltage:	57 V
Welding voltage:	15 - 31.5 V
Welding current:	25 - 350 A
Duty cycle 50 % (10 min.):	350 A (40 °C)
Duty cycle 60 % (10 min.):	350 A (20 °C) 330 A (40 °C)
Duty cycle 100 %:	300 A (20 °C) 280 A (40 °C)



3.2

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	256 programs
Programs:	MIG/MAG, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 4,0 mm ² , 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	130 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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Synergic Pulse welding unit HighPULSE 354 DW incl. wire feeder and 1.6 m interconnection cable:

With DV-26 wire feeder:



AB1	Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26)	30		SET154158	10.050,00
AB1C	Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access.	30		SET154160	10.248,00
AB1CD1	Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m	30		SET154162	10.733,00
AB1CD2	Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m	30		SET154164	10.758,00

A Power source (without wire feeder):

A	Synergic MIG Pulse welding unit (power source) HighPULSE 354 DW, without wire feeder	30		154138	8.320,00
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B Wire feeder DV-26:



B1	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG	46		137652	1.400,00
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! Use wire feeder DV-31 for wire > 1.2 mm:



B2	Wire feeder DV-31 (OT) for HighPULSE, HighPULSE touch, SpeedMIG	46		137650	2.050,00
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C Standard accessories:



C1	Earth lead 70 mm², 4 m long with plug and earth clamp	46		02210408	123,00
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C2	Regulator argon/CO2, single stage	46		01200300	75,00
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D Welding torches:



D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06		142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06		142484	510,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06		142660	535,00

3.2.8. HighPULSE 454 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	15.9 kVA
Contin. current:	23 A
Max. current:	34 A

Secondary:

Open circuit voltage:	72 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 50 % (10 min.):	450 A (40 °C)
Duty cycle 60 % (10 min.):	450 A (20 °C) 400 A (40 °C)
Duty cycle 100 %:	400 A (20 °C) 330 A (40 °C)



3.2

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6,0 mm ² , 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	140 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply:	42 V-DC/42 V-AC
Wire feed motor:	4-roller drive 0.5 - 30 m/min. with wire straightener and tachometer
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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Synergic Pulse welding unit HighPULSE 454 DW incl. wire feeder and 1.6 m interconnection cable:

With DV-26 wire feeder:



AB1	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26)	30	SET154166	11.950,00
AB1C	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access.	30	SET154168	12.182,00
AB1CD1	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m	30	SET154170	12.692,00
AB1CD2	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m	30	SET154172	12.717,00

With DV-31 wire feeder:



AB2	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31)	30	SET154174	12.600,00
AB2C	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access.	30	SET154176	12.857,00
AB2CD1	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access. and TEDAC torch SBT 504 W, 3 m	30	SET154178	13.342,00
AB2CD2	Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access. and TEDAC torch SBT 504 W, 4 m	30	SET154180	13.367,00

A Power source (without wire feeder):

A	Synergic MIG Pulse welding unit (power source) HighPULSE 454 DW, without wire feeder	30	154142	10.220,00
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B Wire feeder:



B1	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG	46	137652	1.400,00
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B2	Wire feeder DV-31 (OT) for HighPULSE, HighPULSE touch, SpeedMIG	46	137650	2.050,00
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C Standard accessories:



C1	Earth lead 95 mm², 4 m long with plug and earth clamp	46	02210403	182,00
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C2	Regulator argon/CO2, single stage	46	01200300	75,00
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D Welding torches:



D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06	142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06	142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06	142660	535,00

3.2.9. HighPULSE 554 DW

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	19.4 kVA
Contin. current:	28 A
Max. current:	45 A

Secondary:

Open circuit voltage:	72 V
Welding voltage:	15 - 41.5 V
Welding current:	20 - 550 A
Duty cycle 40 % (10 min.):	550 A (40 °C)
Duty cycle 50 % (10 min.):	500 A (40 °C)
Duty cycle 60 % (10 min.):	550 A (20 °C) 470 A (40 °C)
Duty cycle 100 %:	500 A (20 °C) 420 A (40 °C)



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	145 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-DC/42 V-AC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm ² , water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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Synergic Pulse welding unit HighPULSE 554 DW incl. wire feeder and 1.6 m interconnection cable:

With DV-26 wire feeder:



AB1	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26)	30	SET154182	12.450,00
AB1C	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26) with access.	30	SET154184	12.707,00
AB1CD1	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m	30	SET154186	13.192,00
AB1CD2	Synergic MIG PULSE welding unit HighPULSE 554 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m	30	SET154188	13.217,00

With DV-31 wire feeder:



AB2	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31)	30	SET154190	13.100,00
AB2C	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31) with access.	30	SET154192	13.357,00
AB2CD1	Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31) with access. and TEDAC torch SBT 504 W, 3 m	30	SET154194	13.842,00
AB2CD2	Synergic MIG PULSE welding unit HighPULSE 554 DW (DV-31) with access. and TEDAC torch SBT 504 W, 4 m	30	SET154196	13.867,00

A Power source (without wire feeder):

A	Synergic MIG Pulse welding unit (power source) HighPULSE 554 DW, without wire feeder	30	154152	10.710,00
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B Wire feeder:



B1	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG	46	137652	1.400,00
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B2	Wire feeder DV-31 (OT) for HighPULSE, HighPULSE touch, SpeedMIG	46	137650	2.050,00
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C Standard accessories:



C1	Earth lead 95 mm², 4 m long with plug and earth clamp	46	02210403	182,00
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C2	Regulator argon/CO2, single stage	46	01200300	75,00
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D Welding torches:



D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06	142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06	142484	510,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06	142660	535,00

3.2.10. Accessories for HighPULSE 354/454/554 DW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Accessories:					
	1.1	Adapter for wire spool		46	02900104	23,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	1.3a	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG KW		46	138290	790,00
	1.3b	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG DW		46	138286	790,00
	1.4a	Connection for remote control incl. socket for HP, SM in KW version		46	155484	75,00
	1.4b	Connection for remote control incl. switch and socket for HighPULSE, SpeedMIG, OptiMIG in DW version		46	02110427	75,00
	1.5	Connection for buttons inching and gas test for ROB torch, mounted in wire feeder with 10 pol. socket		46	158422	79,83
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	1.7	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	1.8	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	1.9a	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	4,60
	1.9b	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	138,00
	1.10a	Price reduction: no integrated water cooling unit (K version)		46	111832	-490,00
	1.10b	Price reduction: no integrated water cooling unit (D version)		46	01903611	-510,00
	1.11	Polarity change and TIG (DC) welding for series HighPULSE and SpeedMIG version DW (LiftTIG), MAG torch connector		46	138276	393,38

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.12	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/rubber hose assembly		10	145092	555,00
	1.13	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	1.14a	MAG Remote Control MRC-50 for HighPULSE und SpeedMIG in steel casing with handgrip and magnet, incl. 5 m supply cable		46	154578	1.150,00
	1.14b	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.670,00
	1.14c	Kit for connection of MRC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	190,00
	1.14d	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	55,00
	1.15	Cover with lock, transparent, for power source HighPULSE, SpeedMIG and HighTIG version KW and DW		46	138238	190,00
	1.16	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	274,09
	1.17	Front panel for 4 jobs incl. trim potentiometer and buttons for gas test and wire inching for series HighPULSE when not using standard operation panel		46	137158	1.966,90
	1.18	Front panel MC-40 for series HighPULSE 8 job version with digital displays and rotary switches incl. digital process controller ME-MTC32 when not using standard operation panel		07	145766	2.170,00
	1.21	Bus connection for operation of TEDAC Digital torches at HighPULSE x54 DW and HighPULSE touch (only with special interconnection cable)		46	156414	402,64
	1.22a	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		06	154244	585,00
	1.22b	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		06	154248	610,00
	1.22c	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 5 m, short vers.		06	154252	635,00
	1.23	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

2 Accessories for wire feeder:

	2.1	Rotatable device for wire feeder including screw set		46	137436	189,00
	2.2	4 wheels mounted on the wire feeder		46	00102109	75,00
	2.3	Standard operation panel inside wire feeder for series HighPULSE, HighPULSE touch and SpeedMIG (only with special interconnection cable)		46	138526	175,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	2.4a	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch, GreenMIG		46	137546	195,00
	2.4b	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and GreenMIG		46	137547	170,00
	2.5	Control 'end of welding wire', installed in the wire feeder box		46	103365	280,00
	2.6	Suspension device for wire feeder electrically isolated		46	00502878	105,00
	2.7	Balancer G4 for rotatable device 137.436		05	158714	1.150,00
	2.8	Wheelbase widening set for HighPULSE and SpeedMIG DW		46	117546	115,00
	2.9	Connection for wire feed liner inside the wire feeder box		46	110454	85,00

3 Connection cable to wire feeder for HighPULSE 354/454 DW:

	3.1	Connection cable 5 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	138844	595,00
	3.2	Connection cable 10 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	138846	890,00
	3.3	Connection cable 15 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	153218	1.150,00
	3.4	Connection cable 20 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	153220	1.505,00
	3.5	Connection cable 30 m 70 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	154388	1.730,00

Price reduction, when not taken:

3.6	Connection cable 1.6 m 70 mm ² , w.c. HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW	46	138842	330,00
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4 Connection cable to wire feeder for HighPULSE 554 DW:

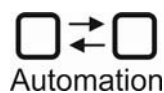
	4.1	Connection cable 5 m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551	46	137638	630,00
	4.2	Connection cable 10 m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551	46	137642	995,00
	4.3	Connection cable 15 m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551	46	137644	1.250,00
	4.4	Connection cable 20 m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551	46	137646	1.650,00
	4.5	Connection cable 30 m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551	46	154386	1.880,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Price reduction, when not taken:					
4.6	Connection cable 1.6m 95 mm ² , HighPULSE, SpeedMIG 552, OptiMIG 551		46	137634	340,00
5 Connection cable for controller in wire feeder:					
5.1	Connection cable 1.6 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138516	380,00
5.2	Connection cable 5 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138518	655,00
5.3	Connection cable 10 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138520	1.030,00
5.4	Connection cable 15 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138522	1.455,00
5.5	Connection cable 20 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 for operation panel inside wire feeder		46	138524	1.760,00
5.6	Connection cable 30 m 95 mm ² , HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450, GreenMIG 400/500 incl. control cable for controller in wire feeder		46	145740	1.950,00
6 Interface power source <-> computer:					
 RS 232	6.1	RS 232 Interface for series HighPULSE standard equipment	17	126540	0,00
 Ethernet	6.2	Ethernet interface for HighPULSE	17	126506	1.190,00
 Wi-Fi	6.3	Option Wifi equipment only in combination with 126.506 or 159.190	17	144106	225,00
7 Software (for free):					
 DeepARC	7.1	Software for DeepARC process for series HighPULSE/GreenMIG	17	120488	880,00
 ColdMIG	7.2	Software for ColdMIG process for series HighPULSE/GreenMIG	17	118064	880,00
 HighUP	7.3	Software for HighUP process for series HighPULSE/GreenMIG	17	134392	880,00
 InterPULSE	7.4	Software for Interpulse process for series HighPULSE	17	120490	280,00
8 Software:					
	8.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit	17	135636	233,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	8.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
	8.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
	8.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00

9 WeldFACTORY (Q.MACS): control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)

10 Automation accessories:



Automation

10.1	Connection for automated welding for hand welding unit HighPULSE, SpeedMIG, HighTIG - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	138296	390,00
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10.1a	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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Automation

10.2	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage OUTPUT 0 - 10 V - socket 10 pol.	46	158270	1.450,00
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10.2a	Connection cable 10-pol. 5m welding unit - automated system	46	01903556	133,00
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10.3	Bus interface "Universal" for hand welding units HighPULSE, ProfiNet, EtherCAT, EtherNet/IP, Modbus TCP u. RTU incl. serial-to-serial converter and 10 pole socket (please specify the required bus version)	17	167062	2.760,00
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10.3a	Connection cable 10-pol. 5m welding unit - automated system	46	01903556	133,00
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010110
64 jobs

10.4	Digital interface for job operation (6 bit - 63 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs	17	159202	1.230,00
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10.4a	Connection cable 24-pin., 5 m welding unit - robot	46	01903557	167,00
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Pos.	Description	Pu	PrGrp	Part No.	Price/€
11 Additional wire equipment for DV-26 and DV-31:					
12.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
12.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
12.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	78,50
12.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
12.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
12.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
12.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
12.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
12.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	99,50
12.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	103,70
12.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	103,70
12.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	279,00
12.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	279,00
12.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	279,00



3.2.11. HighPULSE 354/454/554 DW TWIN

Model HighPULSE	HP 354 DW	HP 454 DW	HP 554 DW
Primary:			
Power supply:	3 x 400 V	3 x 400 V	3 x 400 V
Frequency:	50 / 60 Hz	50 / 60 Hz	50 / 60 Hz
Contin. power:	14.5 kVA	15.9 kVA	19.4 kVA
Contin. current:	21 A	23 A	28 A
Max. current:	25 A	34 A	45 A
Secondary:			
Open circuit voltage:	57 V	72 V	72 V
Welding voltage:	15 - 31.5 V	15 - 36.5 V	15 - 41.5 V
Welding current:	20 - 350 A	20 - 450 A	20 - 550 A
Duty cycle 40 % (40°C):			550 A
Duty cycle 50 % (40°C):	350 A	450 A	500 A
Duty cycle 60 % (40°C):	330 A	400 A	470 A
Duty cycle 100 % (40°C):	280 A	330 A	420 A



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE, option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 4.0 mm² 4 x 6.0 mm² 4 x 6.0 mm² with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	155 kg 165 kg 170 kg (incl. wire feeder and connection cable)
Dimensions l x w x h:	1100 x 700 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-32 TWIN

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	2 units 4-roller drive 0.5 - 30 m/min. with tachometer
Standard wire equipment:	mild steel 1.2 mm
LED:	2 x selection of wire feeder
Reel hub assembly:	2 x D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Weight:	42 kg
Dimensions l x w x h:	662 x 440 x 424 mm

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Synergic Pulse welding units HighPULSE DW TWIN incl. DV-32 and 1.6 m interconnection cable:					
	A1B Synergic MIG Pulse welding unit ighPULSE 354 DW TWIN with twin wire feeder DV-32 TWIN		30	SET132279	14.350,00
	A2B Synergic MIG Pulse welding unit ighPULSE 454 DW TWIN with twin wire feeder DV-32 TWIN		30	SET132280	16.250,00
	A3B Synergic MIG Pulse welding unit HighPULSE 554 DW TWIN with twin wire feeder DV-32 TWIN		30	SET132282	16.740,00

! Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)

A Power source (without wire feeder):

A1	Synergic MIG Pulse welding unit (power source) HighPULSE 354 DW, without wire feeder	30	154138	8.320,00
A2	Synergic MIG Pulse welding unit (power source) HighPULSE 454 DW, without wire feeder	30	154142	10.220,00
A3	Synergic MIG Pulse welding unit (power source) HighPULSE 554 DW, without wire feeder	30	154152	10.710,00

B Wire feeder DV-32 TWIN:



B	Wire feeder DV-32 TWIN incl. suspension device	46	147922	4.845,00
B	Kit for connection of DV-31/32 TWIN for HighPULSE x52/x54 DW inkl. gas bottle holder for 2 cylinders and wider trolley	46	138264	450,00

C Accessories:



C1	Earth lead 95 mm², 4 m long with plug and earth clamp	46	02210403	182,00
C2	Regulator argon/CO2, single stage	46	01200300	75,00

D Welding torches:



D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.	06	142482	485,00
D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.	06	142484	510,00
D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.	06	142660	535,00
D4	MIG/MAG hand welding torch TEDAC, SBT 504 W-Alu, 3 m, long vers. special equipment for aluminium welding	06	142672	525,00

E Accessories:



E1	Adapter for wire spool	46	02900104	23,50
E2	Torch holder D27 for mounting at the handle or handle tube	46	157598	49,50

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E3	Electrode welding cable 70 mm ² , 5 m incl. plug and electrode holder		46	02210449	190,00
	E4	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	E5a	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	4,60
	E5b	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	138,00
	E6	Switch-off of the open circuit voltage of the non activated torch for TWIN wire feeder		46	156928	771,72
	E7	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

F Accessories for wire feeder:

	F1	4 wheels mounted on the wire feeder		46	00102109	75,00
	F2	Rotatable device for wire feeder including screw set		46	137436	189,00
	F3	Wire straightener - 360° without wire sensor 4-roller-drive DV-32		46	146452	352,89

G Connection cable to wire feeder:

	G1	Connection cable 5 m 95 mm ² TWIN HighPULSE 352/452/552 DW		46	138256	1.050,00
	G2	Connection cable 10 m 95 mm ² TWIN HighPULSE 352/452/552 DW		46	138258	1.520,00
	G3	Connection cable 15 m 95 mm ² TWIN HighPULSE 352/452/552 DW		46	138260	2.050,00
	G4	Connection cable 20 m 95 mm ² TWIN HighPULSE 352/452/552 DW		46	138262	2.510,00

Price reduction, when not taken:

G5	Connection cable 1.6 m 95 mm ² TWIN HighPULSE 352/452/552 DW		46	138254	735,00
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H Software (for free):

	H1	Software for DeepARC process for series HighPULSE/GreenMIG		17	120488	880,00
	H2	Software for ColdMIG process for series HighPULSE/GreenMIG		17	118064	880,00
	H3	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00
	H4	Software for Interpulse process for series HighPULSE		17	120490	280,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
I Software:						
	I1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	233,00
J Additional wire equipment for DV-32:						
	J1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	J2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	J3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	78,50
	J4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	J5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	J6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
	J7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	J8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
	J9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	99,50
	J10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	103,70
	J11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	103,70
	J12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	279,00
	J13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	279,00
	J14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	279,00



3.3. Synergic Pulse welding units for automation and robotics



3.3.1. HighPULSE 352 RS

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	12 kVA
Contin. current:	17 A
Max. current:	25 A

Secondary:

Open circuit voltage:	57 V
Welding voltage:	15 - 31.5 V
Welding current:	20 - 350 A
Duty cycle 60% (10 min.):	350 A (40 °C)
Duty cycle 100%:	300 A (40 °C)



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	51 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

3.3.2. HighPULSE 452 RS

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	14.4 kVA
Contin. current:	25 A
Max. current:	34 A

Secondary:

Open circuit voltage:	72 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 50% (10 min.):	450 A (40 °C)
Duty cycle 60% (10 min.):	400 A (40 °C)
Duty cycle 100%:	330 A (40 °C)



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	62 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

3.3.3. HighPULSE 552 RS

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	19.4 kVA
Contin. current:	28 A
Max. current:	45 A

Secondary:

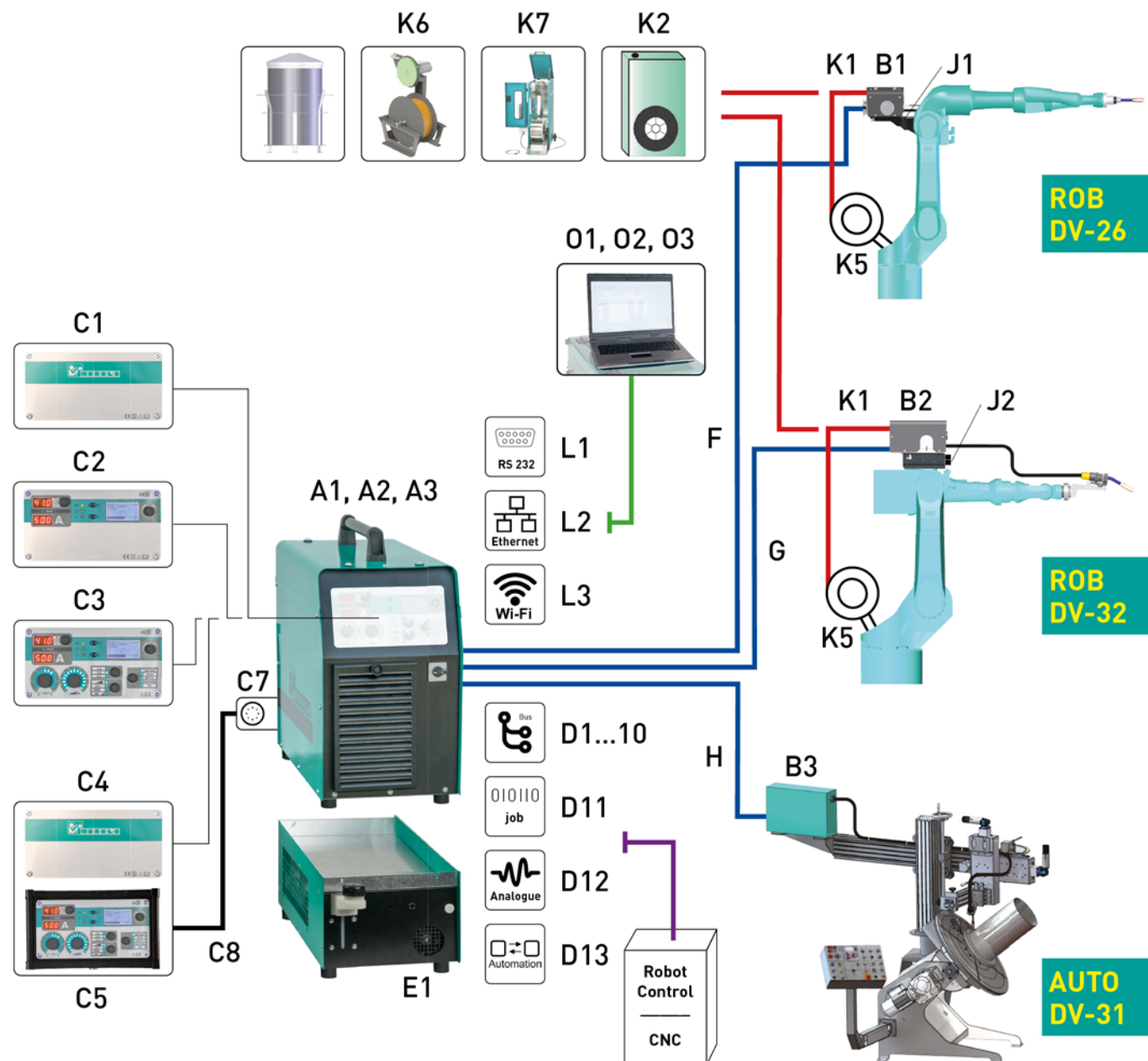
Open circuit voltage:	72 V
Welding voltage:	15 - 41.5 V
Welding current:	20 - 550 A
Duty cycle 40% (10 min.):	550 A (40 °C)
Duty cycle 50% (10 min.):	500 A (40 °C)
Duty cycle 60% (10 min.):	550 A (20 °C) 470 A (40 °C)
Duty cycle 100%:	500 A (20 °C) 420 A (40 °C)



Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm ² :	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm ² , 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	64 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

3.3.4. Robot Synergic Pulse welding units



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Robot Synergic Pulse welding units:					
A1	Robot MIG Pulse Welding Unit Model HighPULSE 354 RS (without front, interface and motor controller)	30		144020	6.220,00
A2	Robot MIG Pulse Welding Unit Model HighPULSE 454 RS (without front, interface and motor controller)	30		144022	7.420,00
A3	Robot MIG Pulse Welding Unit Model HighPULSE 554 RS (without front, interface and motor controller)	30		144024	7.920,00

! Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
B Wire feeder and motor controller (please select):						
	B1	Robot wire feeder ROB DV-26 weight 7 kg		46	118458	2.190,00
	B1.1	Motor controller for ROB DV-26		46	118626	1.390,00
	B2	Robot wire feeding unit model ROB DV-32 (connection wire feeding liner) incl. tacho motor, robot gear, wire straightener, button gas test and wire inching, blow-out device 0.5 - 30 m/min, 9.7 kg		46	143660	3.150,00
	B2.1	Motor controller for ROB DV-31/32 for series HighPULSE RS		46	118628	445,00
	B3	Robot wire feeder box AUTO DV-31 with GN tacho motor, robot gear		46	01910031	2.250,00
	B3.1	Motor controller for ROB DV-31/32 for series HighPULSE RS		46	118628	445,00
C Operation panel/front (please select one):						
	C1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller ME-MTC32		07	117440	1.345,00
	C2	Front panel MC-30 with MTC32 for series HighPULSE with digital display (V, m/min, mm, %) and multi-function display with process controller		07	154424	1.955,00
	C3	Front panel MC-20 with MTC32 for series HighPULSE with digital display and multifunctional display incl. process controller +++ Machine type or serial number +++		46	153838	1.870,00
External operation panel:						
	C4	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller ME-MTC32		07	117440	1.345,00
	C5	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.670,00
	C6	MAG Remote Control MRC-21 mounted in ext. controller incl. displays for series HighPULSE with 5 m cable (only with 117.440)		46	113809	1.670,00
	C7	Kit for connection of MRC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	190,00
	C8	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	55,00
D Interface connection (please select one):						
	D1	Bus interface RS series "Universal" ProfiNet, EtherCAT, EtherNet/IP, Modbus TCP u. RTU incl. serial-to-serial converter and wiring and 10-pol socket emergency stop (please specify the required bus version)		17	167058	3.245,00
	D2	Interface RS series "CANopen" incl. wiring for welding unit and 10-pol socket emergency stop		17	117428	3.245,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D3	Bus interface RS series RS 485 incl. wiring for welding unit and 10-pol socket emergency stop		17	139818	2.425,00
	D1-3a	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00
	D4	Digital interface for job operation (6 bit - 63 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	1.230,00
	D4a	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	167,00
	D5	Analogue interface for RS series 8 IO, 24pol.		17	164184	3.095,00
	D5a	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	167,00
	D6	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	700,00
	D6a	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	D7	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage OUTPUT 0 - 10 V - socket 10 pol.		46	158270	1.450,00
	D8	Connection for automated welding HP, HPt, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage INPUT 0 - 10 V - socket 10 pol.		46	158271	1.450,00
	D7-8a	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00

E Water cooling:



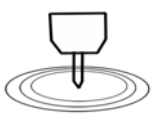
E1	Water cooling unit model WK 350	46	144008	1.680,00
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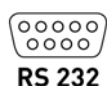
E2	Water flow control device mounted in the water cooler	46	02610156	340,00
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E3	Coolant ME-KM 22 eco, 10 l for welding units	07	169376	68,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
F Connection cables for ROB DV-26:						
	F1	Connection cable, 5 m, 95 mm ² , w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		46	118620	1.150,00
	F2	Connection cable, 10 m, 95 mm ² , w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		46	118624	1.735,00
	F3	Connection cable, 15 m, 95 mm ² , w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		46	143614	2.390,00
	F4	Connection cable, 20 m, 95 mm ² , w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		46	142432	3.020,00
G Connection cables for ROB DV-32:						
	G1	Connection cable, 5 m, 95 mm ² , w. power source - ROB DV-32 wire feeder high flex., incl. water hoses		46	144088	870,00
	G2	Connection cable, 10 m, 95 mm ² , w. power source - ROB DV-32 wire feeder high flex., incl. water hoses		46	144090	1.310,00
	G3	Connection cable, 15 m, 95 mm ² , w. power source - ROB DV-32 wire feeder high flex., incl. water hoses		46	144092	2.130,00
	G4	Connection cable, 20 m, 95 mm ² , w. power source - ROB DV-32 wire feeder high flex., incl. water hoses		46	144094	2.480,00
H Connection cables for AUTO DV-31:						
	H1	Connection cable, 5 m, 95 mm ² robot - wire feeder box incl. water hoses		46	02010928	670,00
	H2	Connection cable, 10 m, 95 mm ² , robot - wire feeder box incl. water hoses		46	02010930	995,00
	H3	Connection cable, 15 m, 95 mm ² , robot - wire feeder box incl. water hoses		46	144922	1.350,00
	H4	Connection cable, 20 m, 95 mm ² , robot - wire feeder box incl. water hoses		46	144924	1.670,00
J Assembly plates for wire feeders:						
	J1	Assembly plate for ROB DV-26 (HW system) on hollow wrist robot (please specify the robot model)		51	161202	327,90
	J2	Assembly plate for mounting of ROB DV-32 on 3rd axis of robot (please specify the robot model)		05	144056	365,77
K Options and accessories:						
	K1	Wire feeding liner from unspool device to wire feeder, 4 m		46	02200340	119,00
	K2	Box for wire spool incl. connection for wire feeding liner		46	101464	735,00
	K3	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	395,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	K4	Suspension device for wire feeder electrically isolated		46	00502878	105,00
	K5	Mounting device for wire spool (K300) incl. housing for KUKA robot		46	118474	240,00
	K6	Reel-Off Device ASV 300 for non-returnable large spools 300 kg		05	02900100	5.514,60
	K7	Reel-Off Device ASV 40 for aluminium wire spools, heated incl. wire end recognition		05	110130	9.391,20
	K8	Push-Pull kit installed inside the welding unit		46	02110403	785,00
	K9	Filter 205 x 314 mm for ighTIG / HighPULSE x52 RS		46	156804	4,60
	K10	Regulator argon/CO2, single stage		46	01200300	75,00
	K11	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
	K12	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	195,00
	K13	Protective gas control		46	01903578	150,00
	K14	Touch Sensor for HighPULSE, HighTIG for welding wire or gas nozzle (HighPULSE) or TIG electrode (HighTIG) (depending on welding torch)		46	106894	480,16
	K15	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	425,00

L Interface power source <-> computer:

RS 232

Ethernet

Wi-Fi

L1	RS 232 Interface for series HighPULSE standard equipment	17	126540	0,00
L2	Ethernet interface for HighPULSE	17	126506	1.190,00
L3	Option Wifi equipment only in combination with 126.506 or 159.190	17	144106	225,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
M Welding software (free of charge):						
	M1	Software for DeepARC process for series HighPULSE/GreenMIG		17	120488	880,00
	M2	Software for ColdMIG process for series HighPULSE/GreenMIG		17	118064	880,00
	M3	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00
InterPULSE	M4	Software for Interpulse process for series HighPULSE		17	120490	280,00
N TANDEM welding:						
	N1	Synchronisation for TANDEM welding of one synergic pulse welding unit		46	102417	2.545,40
	N2	Synchronisation cable for TANDEM welding, 4 m long		46	102418	155,00
O Software:						
	O1	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00
	O2	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
	O3	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
P WeldFACTORY (Q.MACS): control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)						

4. MIG/MAG welding torches

4. MIG/MAG welding torches

4.1 Hand welding torches

SB/SBT 157/307/351 G

SB/SBT 352/504/603 W

HSB/HSBT 600 W

4.2 Fume extraction welding torches

RSB/RSBT 351 G

RSB/RSBT 504 W

4.3 Push-Pull welding torches

PP/PPT 307 G

PP/PPT 504 W

4.4 Machine and Robot welding torches

MSB 401/603 W

ROB 505 W

4.1. Hand welding torches



4.1.1. SB/GBT 157 G

MIG/MAG hand welding torch SB/GBT 157 G

gas cooled



VERSIONS:



Standard



TEDAC

TECHNICAL DATA:

Cooling:	gas cooled
Mixed gas:	150 A 60% duty cycle
CO ₂ :	180 A 60% duty cycle
Solid wire:	0.6 - 0.8 mm [
Aluminium wire:	0.8 - 1.0 mm [
Weight:	approx. 930 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/GBT 157 G					
	MIG/MAG hand welding torch model SB 157 G, 3 m		06	118700	140,00
	MIG/MAG hand welding torch model SB 157 G, 4 m		06	118702	150,00
	MIG/MAG hand welding torch TEDAC, model SBT 157 G, 3 m		06	118704	225,00
	MIG/MAG hand welding torch TEDAC, model SBT 157 G, 4 m		06	118706	235,00
Standard wire equipment: mild steel 0.8 mm					
Spare parts and consumables:					
	1 Torch neck SB/GBT 157 G		22	152216	41,65
	2 Tip adapter SB/GBT 157 G	10 pcs	22	152218	7,87
	3.1 Contact tip 0.6 mm SB/GBT 157 G M6 x 0.75 ECU	20 pcs	22	152181	1,78
	3.2 Contact tip 0.8 mm SB/GBT 157 G M6 x 0.75 ECU	20 pcs	22	152180	1,78
	3.3 Contact tip 1.0 mm SB/GBT 157 G M6 x 0.75 ECU	20 pcs	22	152182	1,78
	4 Gas nozzle SB/GBT 154/157 G		22	02210095	5,69
	5 Spot welding gas nozzle SB/GBT 154/157 G	10 pcs	22	02210096	6,99
	10 Handle MIG, complete with trigger and cover cap		22	105016	43,97
	13 Kinking protection spring for gas cooled MIG torches		22	113068	6,59
	14 Trigger for MIG/MAG torch (red)		22	02210796	11,63
	15 Micro switch for torch trigger		22	113638	11,92
	16 Spring for switch	10 pcs	22	02210131	1,16
Only for SBT 157 G:					
	17 TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	152,72
	18 Nut for KOAX connector-V		22	142370	2,08

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	19.1	Complete cable assembly SB/GBT 154/157 G 3 m, with Euro connector, without torch, without liner		22	02210316	90,87
	19.2	Complete cable assembly SB/GBT 154/157 G 4 m, with Euro connector, without torch, without liner		22	02210317	100,23
	20	Central connector MAG, gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	52,07
	21	Brass body central connector MAG gas cooled		22	02511401	27,77
	22	Sleeve nut black		22	02510300	13,07
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	9,83
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	27	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
Only for SB 157 G:						
	30	Cover cap for TEDAC handle		22	02210604	5,21

4.1.2. SB/GBT 307 G

MIG/MAG hand welding torch SB/GBT 307 G gas cooled



VERSIONS:



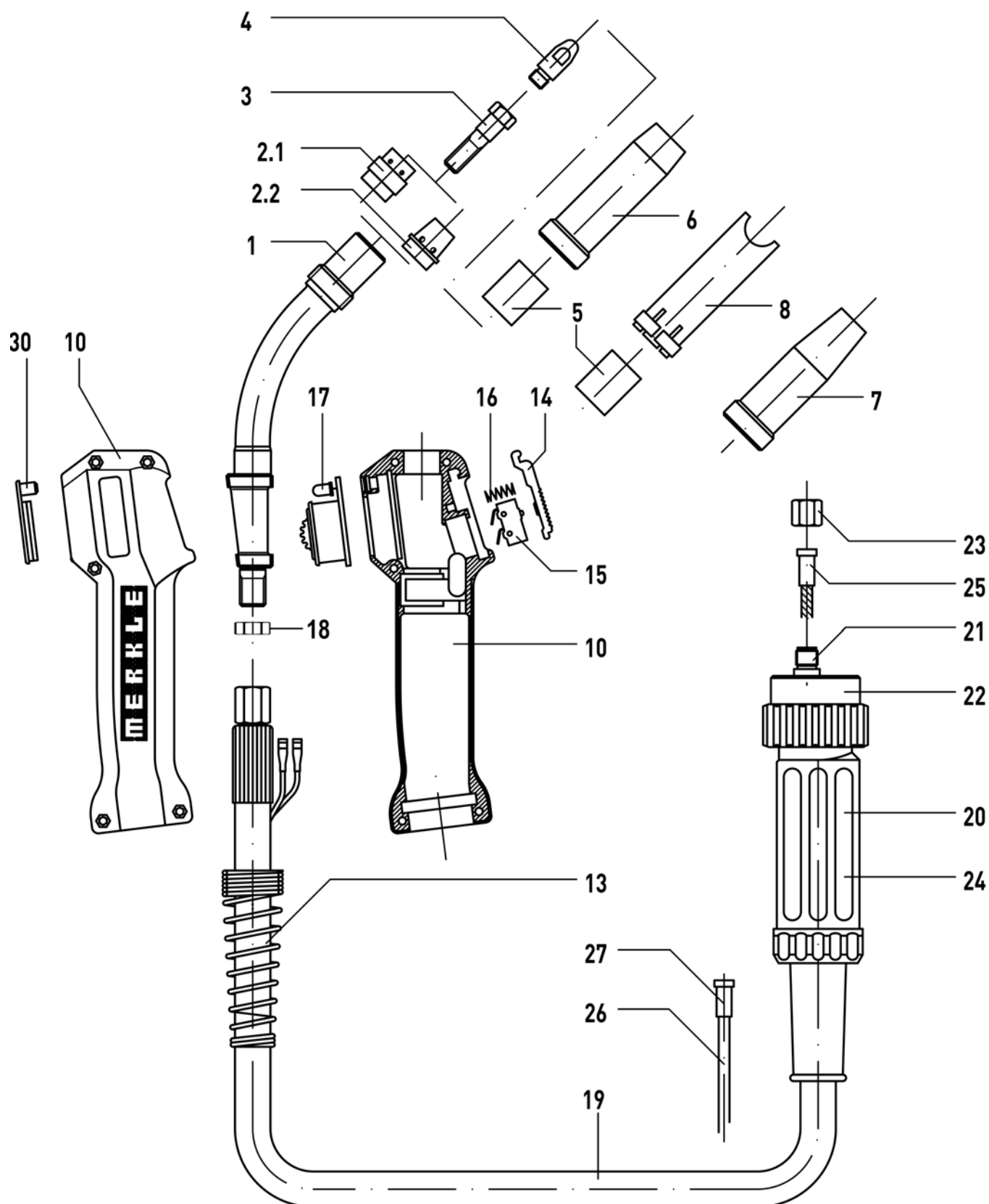
Standard



TEDAC

TECHNICAL DATA:

Cooling:	gas cooled
Mixed gas:	280 A 60% duty cycle
CO ₂ :	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm [
Aluminium wire:	0.8 - 1.0 - 1.2 mm [
Weight:	approx. 1100 g/1 m H
The data are corresponding to (U = 14 + 0.05 x l)	



MIG/MAG hand welding torch SB/GBT 307 G

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	MIG/MAG hand welding torch model SB 307 G, 3 m		06	02210758	210,00
	MIG/MAG hand welding torch model SB 307 G, 4 m		06	02210759	235,00
	MIG/MAG hand welding torch model SB 307 G, 5 m		06	154992	260,00
	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		06	02210858	295,00
	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		06	02210859	320,00
	MIG/MAG hand welding torch TEDAC, model SBT 307 G, 5 m		06	154994	345,00

Standard wire equipment: mild steel 1.0 mm
Spare parts and consumables:

	1	Torch body SB/GBT 307 G		22	02210757	78,68
	2.1a	Gas diffuser SB/GBT 307 G ceramic spatter resistant	10 pcs	22	02210219	6,90
	2.1b	Gas diffuser SB/T 307 G plastic, black, for gas nozzle 022.1.0267, 022.1.0310	10 pcs	22	02210222	6,90
	2.2	Gas diffuser SB/T 307 G, plastic for gas nozzle 111.462	10 pcs	22	111938	15,62
	3.1	Tip adapter, SB 307 G, 38 mm	10 pcs	22	02210217	5,21
	3.2	Tip adapter SB 307, 38 mm for aluminium, inner diameter 4. 8 mm	10 pcs	22	02210215	10,02
	3.3	Tip adapter SB 307, 36 mm version DB	10 pcs	22	114756	6,10
	4.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	4.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	4.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	4.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	4.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	4.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	5	Insulation ring SB 300/307	20 pcs	22	02210369	3,30
	6	Gas nozzle SB/GBT 300/307, with thread		22	02210267	8,85

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	7	Gas nozzle 12 mm screw fixing (only with gas diffuser 111.938)	10 pcs	22	111462	24,60
	8	Spot welding gas nozzle 300/307 with fastening ring		22	02210310	9,83
	10	Handle MIG, complete with trigger and cover cap		22	105016	43,97
	13	Kinking protection spring for gas cooled MIG torches		22	113068	6,59
	14	Trigger for MIG/MAG torch (red)		22	02210796	11,63
	15	Micro switch for torch trigger		22	113638	11,92
	16	Spring for switch	10 pcs	22	02210131	1,16

Only for SBT 307 G:

	17	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	152,72
	18	Nut for KOAX connector-V		22	142370	2,08
	19.1	Complete cable assembly 35mm² 3 m, with Euro connector, without torch, without liner		22	02210296	129,62
	19.2	Complete cable assembly 35mm² 4 m, with Euro connector, without torch, without liner		22	02210297	169,71
	20	Central connector MAG, gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	52,07
	21	Brass body central connector MAG gas cooled		22	02511401	27,77
	22	Sleeve nut black		22	02510300	13,07
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	9,83
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	25.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	25.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	27	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88

Only for SB 307 G:

	30	Cover cap for TEDAC handle		22	02210604	5,21
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Max. length of torch lead for alu: 3 m.

4.1.3. SB/SBT 351 G

MIG/MAG hand welding torch SB/SBT 351 G gas cooled



VERSIONS:



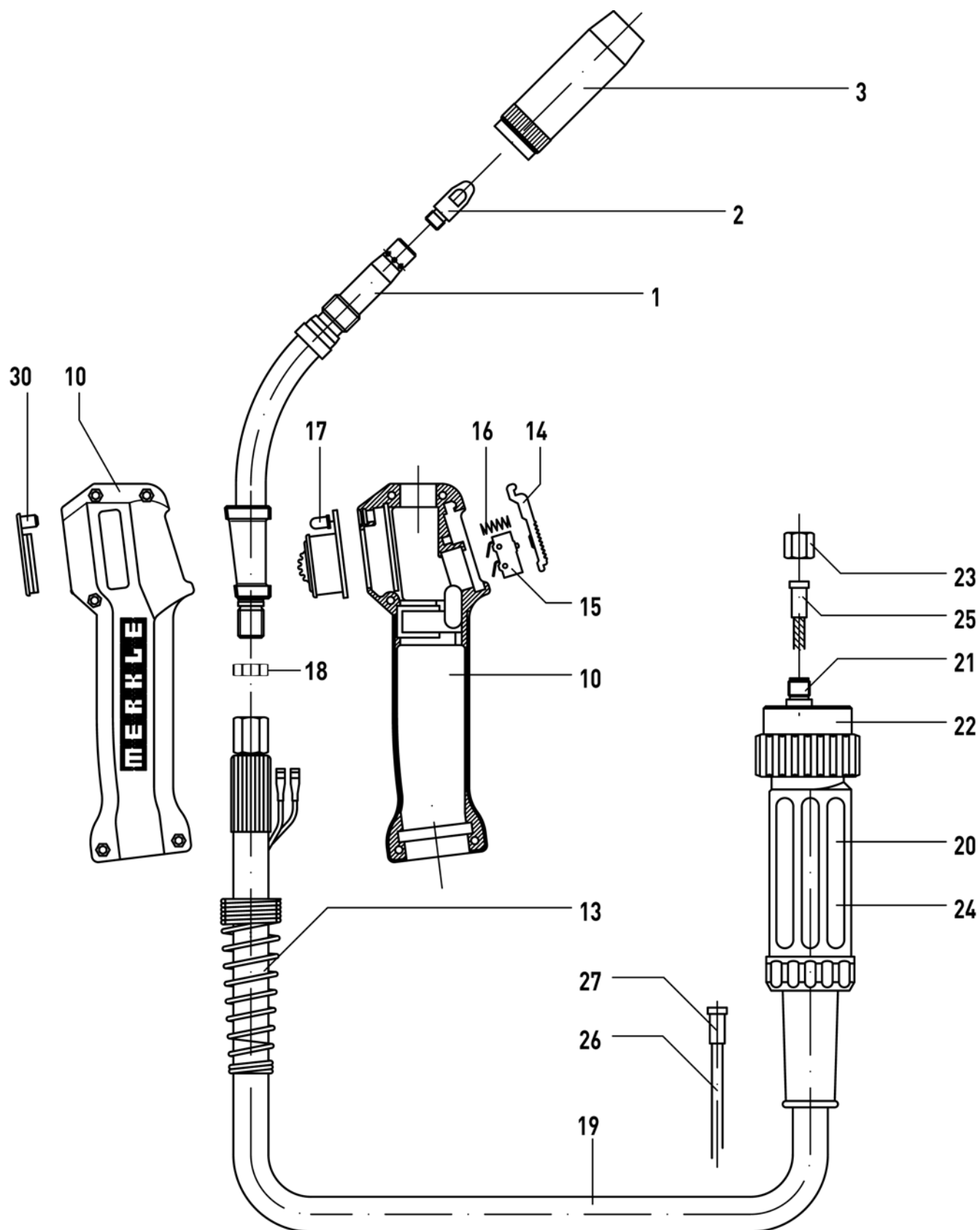
Standard



TEDAC

TECHNICAL DATA:

Cooling:	gas cooled
Mixed gas:	250 A 60% duty cycle
CO ₂ :	280 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm [
Aluminium wire:	0.8 - 1.0 - 1.2 mm [
Weight:	approx. 1350 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/ST 351 G					
	MIG/MAG hand welding torch model SB 351 G, 3 m		06	112934	210,00
	MIG/MAG hand welding torch model SB 351 G, 4 m		06	112936	235,00
	MIG/MAG hand welding torch model SB 351 G, 5 m		06	112376	260,00
	MIG/MAG hand welding torch TEDAC, model SBT 351 G, 3 m		06	112938	295,00
	MIG/MAG hand welding torch TEDAC, model SBT 351 G, 4 m		06	112940	320,00
	MIG/MAG hand welding torch TEDAC, model SBT 351 G, 5 m		06	118520	345,00
Standard wire equipment: mild steel 1.0 mm					
Spare parts and consumables:					
	1 Torch neck SB/ST 351 G		22	110628	79,83
	2.1 Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	2.2 Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	2.3 Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	2.4 Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	2.5 Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	2.6 Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	2.7 Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89
	3 Gas nozzle 15 mm SB/T, RSB/T 351 G with thread and insulation		22	104170	10,91
	10 Handle MIG, complete with trigger and cover cap		22	105016	43,97
	13 Kinking protection spring for gas cooled MIG torches		22	113068	6,59
	14 Trigger for MIG/MAG torch (red)		22	02210796	11,63
	15 Micro switch for torch trigger		22	113638	11,92
	16 Spring for switch	10 pcs	22	02210131	1,16
Only for SBT 351 G:					
	17 TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	152,72
	18 Nut for KOAX connector-V		22	142370	2,08

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	19.1	Complete cable assembly, 3 m with Euro connector, without torch, without liner		22	02210323	142,99
	19.2	Complete cable assembly, 4 m with Euro connector, without torch, without liner		22	02210324	169,71
	20	Central connector MAG, gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	52,07
	21	Brass body central connector MAG gas cooled		22	02511401	27,77
	22	Sleeve nut black		22	02510300	13,07
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	9,83
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	25.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	25.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	26.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	26.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	27.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	27.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36

Only for SB 351 G:

	30	Cover cap for TEDAC handle		22	02210604	5,21
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Max. length of torch lead for alu: 3 m.

4.1.4. SB/ST 352 W

MIG/MAG hand welding torch SB/ST 352 W

water cooled



VERSIONS:



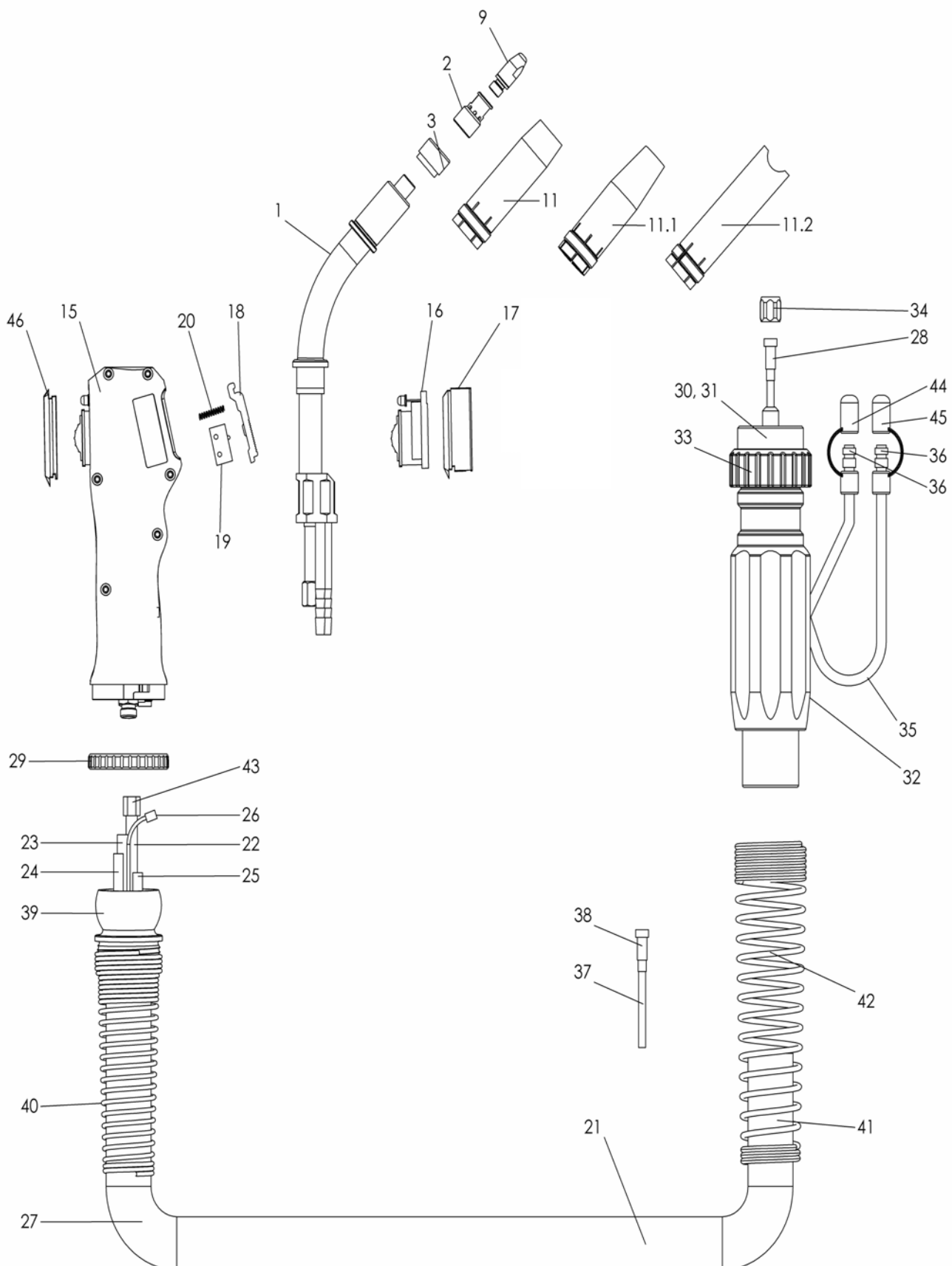
Standard



TEDAC®

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm [
Aluminium wire:	1.0 - 1.2 mm [
Weight:	approx. 1350 g/1 m H
The data are corresponding to $(U = 14 + 0.05 \times I)$	



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/GBT 603 W					
	MIG/MAG hand welding torch model SB 352 W, 4 m		06	142550	425,00
	MIG/MAG hand welding torch model SB 352 W, 3 m		06	142544	400,00
	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	485,00
	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	510,00

Standard wire equipment: mild steel 1.0 mm

Spare parts and consumables:

	1	Torch body SB/GBT 352 W 45° bent		22	142540	138,84
	2	Tip adapter SB/GBT 351/352 W		22	138292	8,68
	3	Insulation nut SB/GBT 300/351/352 W	10 pcs	22	138812	1,62
	9.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	9.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	9.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	9.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	9.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	9.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	9.7	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89
	11	Gas nozzle 15 mm SB/GBT 351/352 W		22	138270	5,11
	11.1	Gas nozzle 12 mm SB/GBT 351/352 W		22	138352	5,30
	15	Handle for MIG/MAG torch with ball joint complete set left and right incl. screws (without ball joint)		22	131272	46,28

Only for SBT 352 W:

	16	TEDAC pc-board ME-BE-2.1 incl. slide switch and micro switch		22	02210830	152,72
	17	Frame for TEDAC left and right for torches with ball joint		22	134478	10,56

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	18	Trigger for MIG/MAG torch (red)		22	02210796	11,63
	19	Micro switch for torch trigger		22	113638	11,92
	20	Spring for switch	10 pcs	22	02210131	1,16
	21.1	Hose assembly 3 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142520	181,74
	21.2	Hose assembly 4 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142522	197,85
	21.3	Hose assembly 5 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142650	222,14
	22.1	Water-power-cable 3.0 m long for SB/T 352/504 W		22	142524	92,56
	22.2	Water-power-cable 4.0 m long for SB/T 352/504 W		22	142526	109,92
	22.3	Water power cable 5.0 m long for SB/T 352/504 W		22	142656	123,80
	23.1	Wire feeding hose complete 3.0 m long only for SB/T 504 W		22	134498	42,09
	23.2	Wire feeding hose complete 4.0 m long only for SB/T 504 W		22	134500	43,43
	23.3	Wire feeding hose complete 5.0 m long only for SB/T 504 W		22	134502	45,44
	23.4	Wire feeding hose 28 red, 5.5 x 1.75 per m		22	134438	3,21
		Nippel for wire feeding hose M8 x 1 / Ø8		22	142412	3,34
		Nippel for wire feeding hose M10 x 1 / Ø8		22	114114	2,94
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	26.1	Cable H07V-K 1.5 mm, black per m		22	00800200	0,66
	26.2	Cable H07V-K 1.5 mm red per m		22	00800204	0,64
	27.1	Protection hose 3 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134490	52,12
	27.2	Protection hose 4 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134492	60,14
	27.3	Protection hose 5 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134494	66,82
	27.4	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	28.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	28.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	28.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	28.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	28.5	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 5 m long		22	113512	8,21
	29	Bayonet ring for all torches with ball joint		22	131788	10,41
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	31	Brass neck for Euro-connection water cooled		22	02510200	38,76
	32	Kinking protection, intake water cooled		22	02510100	18,98
	33	Sleeve nut black		22	02510300	13,07
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	36	Coupling nipple for water	10 pcs	22	02510400	2,41
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	38.2	Collet for teflon liner 2.3 x 4.7	10 pcs	22	133140	3,36
	39	Ball joint connector V4		22	142302	7,88
	40	Spring for kinking protection for MIG/MAG torch watercooled		22	142286	13,07
	41	Kinking protection for MIG torches water cooled		22	02211580	13,07
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	43	Connection nipple M8x1 RH AG, for water-current-cable, torch side		22	141508	14,03
	44	Blue cap for torch water connector	10 pcs	22	130959	2,43
	45	Red cap for water torch connector	10 pcs	22	130958	2,43
Only for SB 352 W:						
	46	Cover cap for torches with ball joint		22	134496	10,30

Max. length of torch lead for alu: 3 m.

4.1.5. SB/SBT 504 W

MIG/MAG hand welding torch SB/SBT 504 W

water cooled



VERSIONS:



Standard

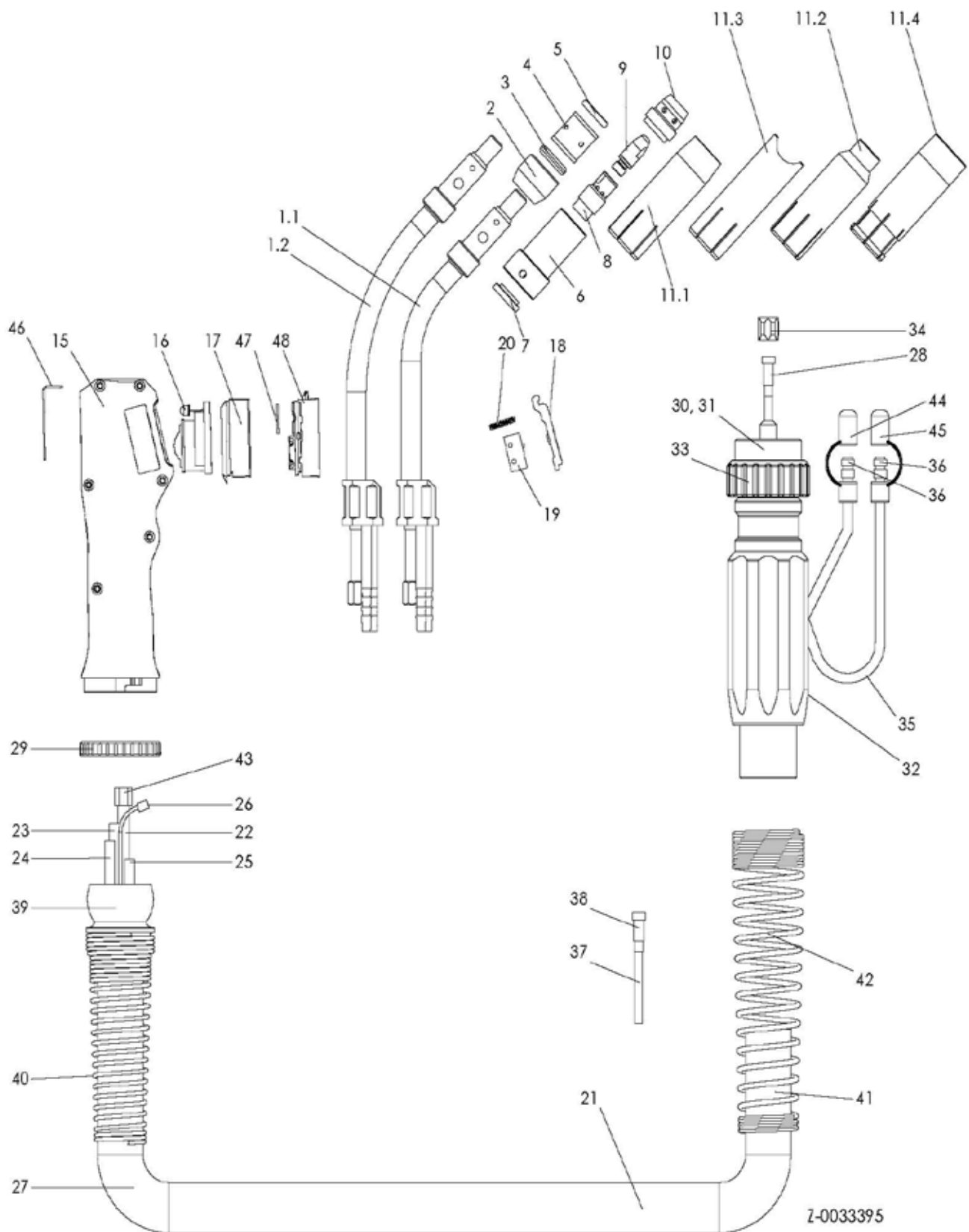


TEDAC®

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO ₂ :	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm [
Aluminium wire:	1.0 - 1.2 - 1.6 mm [
Weight:	approx. 1400 g/1 m H

The data are corresponding to $(U = 14 + 0.05 \times I)$



	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	Standard version, short torch neck:					
	A1	MIG/MAG hand welding torch model SB 504 W, 3 m, short version		06	142494	400,00
	A2	MIG/MAG hand welding torch model SB 504 W, 4 m, short version		06	142496	425,00
	A3	MIG/MAG hand welding torch model SB 504 W, 5 m, short version		06	142666	450,00
B	Standard version, long torch neck:					
	B1	MIG/MAG hand welding torch model SB 504 W, 3 m, long version		06	142492	415,00
	B2	MIG/MAG hand welding torch model SB 504 W, 4 m, long version		06	142490	440,00
	B3	MIG/MAG hand welding torch model SB 504 W, 5 m, long version		06	142664	465,00
	B4	MIG/MAG hand welding torch model SB 504 W-Alu, 3 m, long version special equipment for aluminium welding		06	142670	440,00
C	With TEDAC system, short torch neck:					
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	485,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	510,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	535,00
D	With TEDAC system, long torch neck:					
	D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, long vers.		06	142486	500,00
	D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, long vers.		06	142488	525,00
	D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, long vers.		06	142662	550,00
	D4	MIG/MAG hand welding torch TEDAC, SBT 504 W-Alu, 3 m, long vers. special equipment for aluminium welding		06	142672	525,00
E	TEDAC DIGITAL, short torch neck:					
	E1	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		06	154244	585,00
	E2	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		06	154248	610,00
	E3	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 5 m, short vers.		06	154252	635,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
F TEDAC DIGITAL, long torch neck:					
	F1 MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, long vers.		06	154254	600,00
	F2 MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, long vers.		06	154260	625,00
	F3 MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 5 m, long vers.		06	154262	650,00

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:

	1.1 Torch body complete, short version SB/GBT 504 W		22	142498	138,00
	1.2 Torch body complete, long version SB/GBT 504 W		22	142500	161,00
	2 Thread piece 503/504 W for water coat 131.280		22	131276	10,50
	3 O-ring 14 x 4	10 pcs	22	02210077	2,37
	4 Pressure bushing SB/GBT 502/503/504 W double wall	10 pcs	22	02211424	13,88
	5 O-ring 12 x 4	10 pcs	22	02210076	2,37
	6 Water coat SB503/504 W for thread piece 131.276		22	131280	14,20
	7 Isolator 503/504 W for water coat 131.280		22	131278	3,12
	8 Tip adapter SB/GBT 300/502/503/504 W	10 pcs	22	02211578	6,95
	9.1 Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	9.2 Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	9.3 Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	9.4 Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
	9.5 Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	22	04511817	2,17
	9.6 Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	9.7 Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	9.8 Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	9.9 Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89
	10.1 Gas diffuser 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	9,94

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	10.2	Gas diffuser 455/502/503/504 W, plastic	10 pcs	22	02211568	9,94
	11.1	Gas nozzle 17 mm with fastening ring	10 pcs	22	04514300	6,87
	11.2	Gas nozzle 14 mm with fastening ring	10 pcs	22	04514301	11,90
	11.3	Spot welding gas nozzle with fastening ring	10 pcs	22	04514304	25,40
	11.4	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	22	04514305	37,20
	15	Handle for MIG/MAG torch with ball joint complete set left and right incl. screws (without ball joint)		22	131272	46,28
Only for TEDAC torch:						
	16	TEDAC pc-board ME-BE-2.1 incl. slide switch and micro switch		22	02210830	152,72
	17	Frame for TEDAC left and right for torches with ball joint		22	134478	10,56
	18	Trigger for MIG/MAG torch (red)		22	02210796	11,63
	19	Micro switch for torch trigger		22	113638	11,92
	20	Spring for switch	10 pcs	22	02210131	1,16
	21.1	Hose assembly 3 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142520	181,74
	21.2	Hose assembly 4 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142522	197,85
	21.3	Hose assembly 5 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142650	222,14
	22.1	Water-power-cable 3.0 m long for SB/T 352/504 W		22	142524	92,56
	22.2	Water-power-cable 4.0 m long for SB/T 352/504 W		22	142526	109,92
	22.3	Water power cable 5.0 m long for SB/T 352/504 W		22	142656	123,80
	23.1	Wire feeding hose complete 3.0 m long only for SB/T 504 W		22	134498	42,09
	23.2	Wire feeding hose complete 4.0 m long only for SB/T 504 W		22	134500	43,43

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	23.3	Wire feeding hose complete 5.0 m long only for SB/T 504 W		22	134502	45,44
	23.4	Wire feeding hose 28 red, 5.5 x 1.75 per m		22	134438	3,21
		Nippel for wire feeding hose M8 x 1 / Ø8		22	142412	3,34
		Nippel for wire feeding hose M10 x 1 / Ø8		22	114114	2,94
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	26.1	Cable H07V-K 1.5 mm, black per m		22	00800200	0,66
	26.2	Cable H07V-K 1.5 mm red per m		22	00800204	0,64
	27.1	Protection hose 3 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134490	52,12
	27.2	Protection hose 4 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134492	60,14
	27.3	Protection hose 5 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134494	66,82
	27.4	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	28.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	28.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	28.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	28.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	28.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	28.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	29	Bayonet ring for all torches with ball joint		22	131788	10,41
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	31	Brass neck for Euro-connection water cooled		22	02510200	38,76
	32	Kinking protection, intake water cooled		22	02510100	18,98
	33	Sleeve nut black		22	02510300	13,07

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	36	Coupling nipple for water	10 pcs	22	02510400	2,41
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	37.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	37.6	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	38.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	39	Ball joint connector V4		22	142302	7,88
	40	Spring for kinking protection for MIG/MAG torch watercooled		22	142286	13,07
	41	Kinking protection for MIG torches water cooled		22	02211580	13,07
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	43	Connection nipple M8x1 RH AG, for water-current-cable, torch side		22	141508	14,03
	44	Blue cap for torch water connector	10 pcs	22	130959	2,43
	45	Red cap for water torch connector	10 pcs	22	130958	2,43
Only for SB 504 W:						
	46	Cover cap for torches with ball joint		22	134496	10,30

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Only for TEDAC DIGITAL:					
47	Protective plastic glas for handle TEDAC DIGITAL torch		22	153900	10,41
48	TEDAC DIGITAL module complete with display and control button		22	154048	278,84

4.1.6. SB/GBT 603 W

MIG/MAG hand welding torch SB/GBT 603 W

water cooled



VERSIONS:



Standard

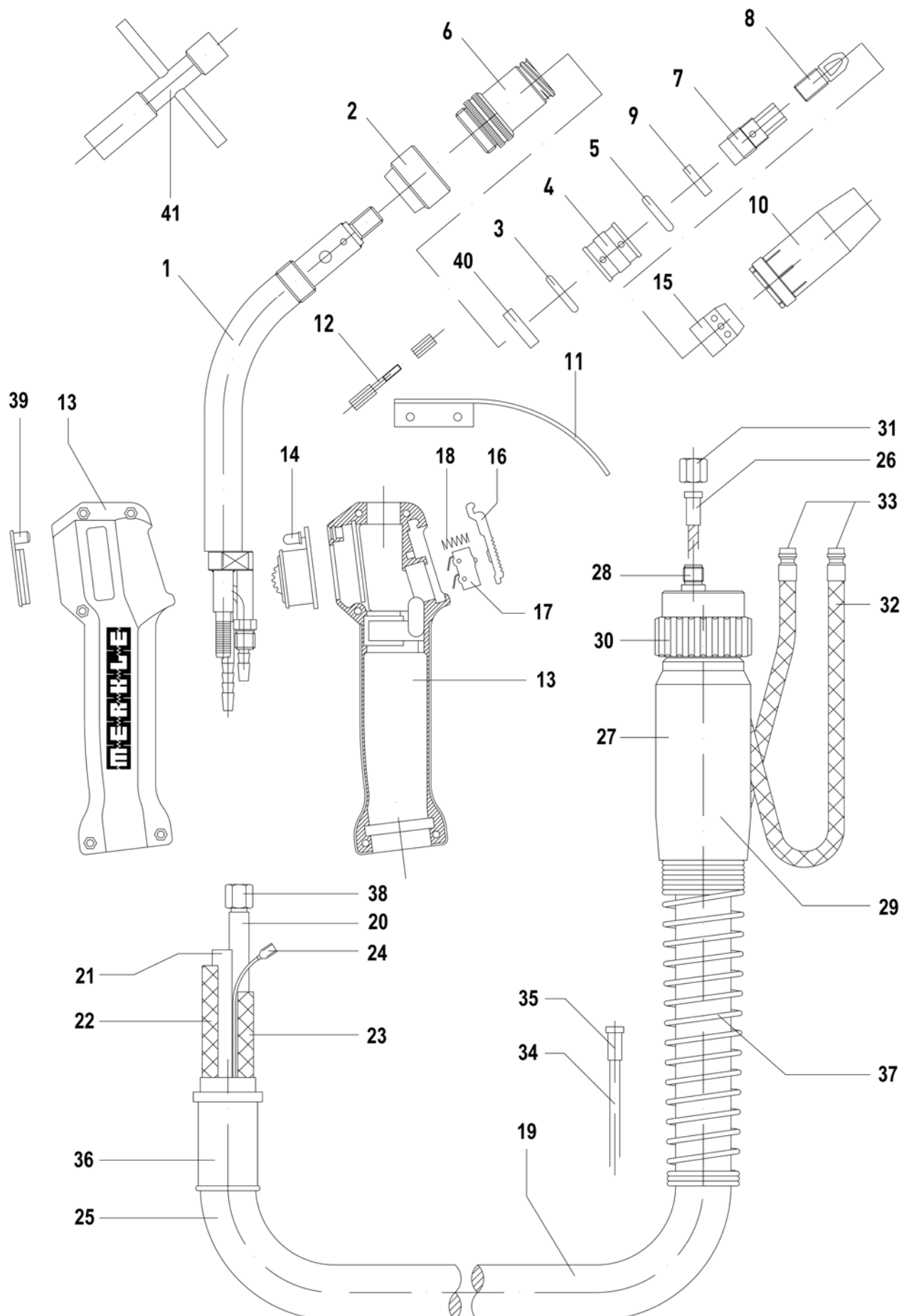


TEDAC

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO ₂ :	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1.6 mm [
Aluminium wire:	1.6 - 2.0 - 2.4 mm [
Weight:	approx. 1480 g/1 m H

The data are corresponding to (U = 14 + 0.05 x I)



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/ST 603 W					
	MIG/MAG hand welding torch model SB 603 W, 3 m		06	02211790	520,00
	MIG/MAG hand welding torch model SB 603 W, 4 m		06	02211791	545,00
	MIG/MAG hand welding torch TEDAC, model SBT 603 W, 3 m		06	02211792	605,00
	MIG/MAG hand welding torch TEDAC, model SBT 603 W, 4 m		06	02211793	630,00
Standard wire equipment: mild steel 1.2 mm					
Spare parts and consumables:					
1	Torch neck for SB 603 W, HSB 600 W		22	02211740	187,09
2	Thread ring for ROB 504, SB/MSB 603 W		22	111982	13,10
3	O-ring 16 x 3.5	10 pcs	22	02211777	1,83
4	Internal sleeve 600/603 W	2 pcs	22	02211753	14,03
5	O-ring 14 x 4	10 pcs	22	101059	6,94
6	Water coat ROB 504, SB/MSB 603 W for gas nozzle 110.136		22	110138	27,88
7	Tip holder 504/603 W	2 pcs	22	108258	11,51
8.1	High performance contact tip 1.0 mm for SB/MSB 600/603 W	20 pcs	22	02211758	3,56
8.2	High performance contact tip 1.2 mm for SB/MSB 600/603 W	20 pcs	22	02211759	3,56
8.3	High performance contact tip 1.6 mm for SB/MSB 600/603 W	20 pcs	22	02211761	3,56
8.4	High performance contact tip 1.0 mm alu for SB/MSB 600/603 W	20 pcs	22	107894	4,34
8.5	High performance contact tip 1.2 mm alu for SB/MSB 600/603 W	20 pcs	22	107896	4,34
8.6	High performance contact tip 1.6 mm alu for SB/MSB 600/603 W	20 pcs	22	107898	4,34
9	Ceramic ring 504/603 W	2 pcs	22	02210340	3,59
10	Gas nozzle d = 17 mm, l = 67 mm standard B/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	110136	14,66
11	Hand protection shield		22	02210850	27,77
12	Kit for mounting hand protection		22	02210851	14,70
	13	Handle MIG, complete with trigger and cover cap	22	105016	43,97
Only for SBT 603 W:					
	14	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch	22	02210800	152,72
	15	Gas diffuser SB 300/603 W ceramic	5 pcs	107966	6,01
	16	Trigger for MIG/MAG torch (red)	22	02210796	11,63

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	17	Micro switch for torch trigger		22	113638	11,92
	18	Spring for switch	10 pcs	22	02210131	1,16
	19.1	Complete cable assembly, 3 m, w.c. without Euro-connector, without torch, without liner		22	130012	172,39
	19.2	Complete cable assembly, 4 m, w.c. without Euro-connector, without torch, without liner		22	130014	185,75
	20.1	Water-power-cable 3.0 m long SB 502/603/455/450/350		22	02210281	78,68
	20.2	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	95,45
	21.1	Wire feeding hose cpl. 3.0 m long		22	02211662	42,09
	21.2	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	46,77
	22	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	23	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	24.1	Switch-cable, 3 m long		22	02210148	27,77
	24.2	Switch-cable, 4 m long		22	02210149	30,08
	25	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	26.1	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	26.2	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	26.3	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	26.4	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	27	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	28	Brass neck for Euro-connection water cooled		22	02510200	38,76
	29	Kinking protection, intake water cooled		22	02510100	18,98
	30	Sleeve nut black		22	02510300	13,07
	31	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	32	PVC hose 5 x 1.5, red per m		22	00600206	1,74

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	33	Coupling nipple for water	10 pcs	22	02510400	2,41
	34.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	34.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	34.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	34.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	34.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	34.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	35.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	35.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	36	Kinking protection for MIG torches water cooled		22	02211580	13,07
	37	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	38	Connection nipple for water-current-cable, torch side		22	04510201	12,00

Only for SB 603 W:

	39	Cover cap for TEDAC handle		22	02210604	5,21
	40	Distance ring 21,8 x 5,5 504/603 W		22	02211815	2,87
	41	Key for 504/600/603 W		22	01370043	28,93

Max. length of torch lead for alu: 3 m.

4.1.7. HSB/HSBT 600 W

MIG/MAG hand welding torch HSB/HSBT 600 W

water cooled, high performance gas nozzle



VERSIONS:



Standard



TEDAC

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO ₂ :	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1.6 mm [
Weight:	approx. 1480 g/1 m H
The data are corresponding to (U = 14 + 0.05 x l)	



MIG/MAG hand welding torch HSB/HSBT 600 W


High performance MIG/MAG hand torch
model HSB 600 W, 3 m, long version
with high performance gas nozzle

06

02211731

595,00



High performance MIG/MAG hand torch
model HSB 600 W, 4 m, long version
with high performance gas nozzle

06

02211732

620,00

High performance MIG/MAG hand torch
TEDAC, HSBT 600 W, 3 m, long vers.
with high performance gas nozzle

06

02211734

680,00

High performance MIG/MAG hand torch
TEDAC, HSBT 600 W, 4 m, long vers.
with high performance gas nozzle

06

02211735

705,00

Standard wire equipment: mild steel 1.2 mm
Spare parts and consumables:

1	Torch neck for SB 603 W, HSB 600 W		22	02211740	187,09
2	Fastening ring for HSB/HSBT 600 W		22	02211752	10,53
3	O-ring 16 x 3.5	10 pcs	22	02211777	1,83
4	Internal sleeve 600/603 W	2 pcs	22	02211753	14,03
5	O-ring 14 x 4	10 pcs	22	101059	6,94
7	Tip holder HSB 600 W (and 603 old)	2 pcs	22	02211755	11,51
8.1	High performance contact tip 1.0 mm for SB/MSB 600/603 W	20 pcs	22	02211758	3,56
8.2	High performance contact tip 1.2 mm for SB/MSB 600/603 W	20 pcs	22	02211759	3,56
8.3	High performance contact tip 1.6 mm for SB/MSB 600/603 W	20 pcs	22	02211761	3,56
9	Insulation sleeve HSB 600	2 pcs	22	02211763	15,39
10.1	Gas nozzle 17 mm (short 85 mm) HSB 600, high performance vers.	3 pcs	22	02211765	86,00
10.2	Gas nozzle 17 mm (long 90 mm) HSB 600, high performance vers.		22	02211769	69,42
11	Hand protection shield		22	02210850	27,77
12	Kit for mounting hand protection		22	02210851	14,70
15	Handle MIG, complete with trigger and cover cap		22	105016	43,97


Only for HSBT 600 W:


16 TEDAC pc-board ME-BE-10.0
incl. slide switch and micro switch

22

02210800

152,72



18 Trigger for MIG/MAG torch (red)

22

02210796

11,63



19 Micro switch for torch trigger

22

113638

11,92



20 Spring for switch

10 pcs

22

02210131

1,16

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	21.1	Complete cable assembly, 3 m, w.c. without Euro-connector, without torch, without liner		22	130012	172,39
	21.2	Complete cable assembly, 4 m, w.c. without Euro-connector, without torch, without liner		22	130014	185,75
	22.1	Water-power-cable 3.0 m long SB 502/603/455/450/350		22	02210281	78,68
	22.2	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	95,45
	23.1	Wire feeding hose cpl. 3.0 m long		22	02211662	42,09
	23.2	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	46,77
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	26.1	Switch-cable, 3 m long		22	02210148	27,77
	26.2	Switch-cable, 4 m long		22	02210149	30,08
	27	Protective hose 28 x 1,5 black		22	00600405	11,90
	28.1	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	28.2	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	28.3	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	28.4	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	31	Brass neck for Euro-connection water cooled		22	02510200	38,76
	32	Kinking protection, intake water cooled		22	02510100	18,98
	33	Sleeve nut black		22	02510300	13,07
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	36	Coupling nipple for water	10 pcs	22	02510400	2,41
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	37.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	37.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	38.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	41	Kinking protection for MIG torches water cooled		22	02211580	13,07
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	43	Connection nipple for water-current-cable, torch side		22	04510201	12,00
Only for HSB 600 W:						
	45	Cover cap for TEDAC handle		22	02210604	5,21
	51	Key for 504/600/603 W		22	01370043	28,93

4.2. Fume extraction welding torches



4.2.1. RSB/RSBT 351 G

MIG/MAG fume extraction torch RSB/RSBT 351 G

gas cooled



VERSIONS:



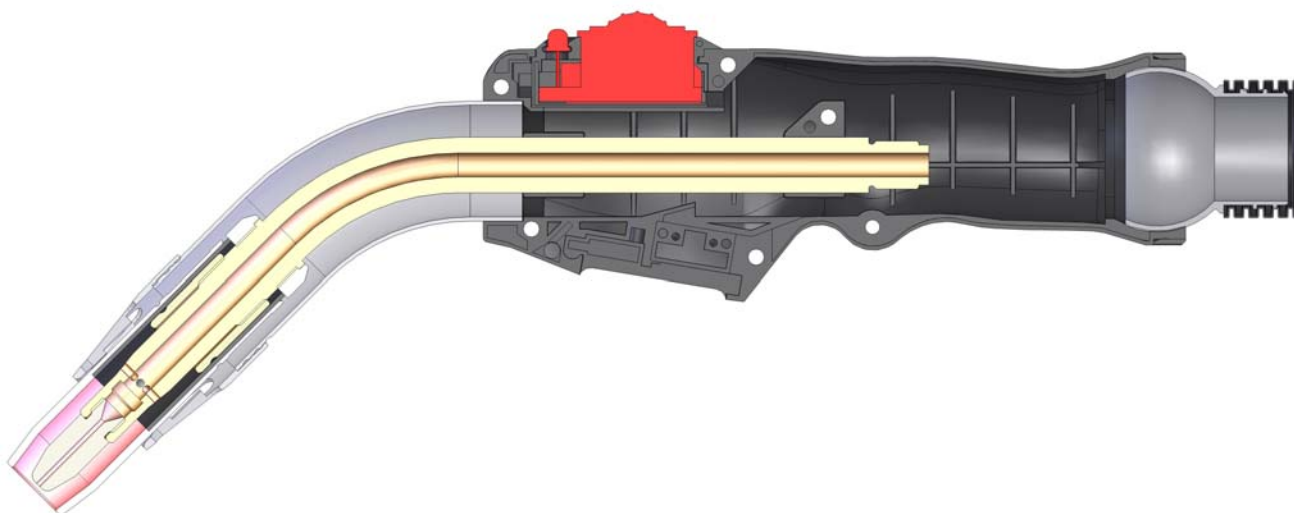
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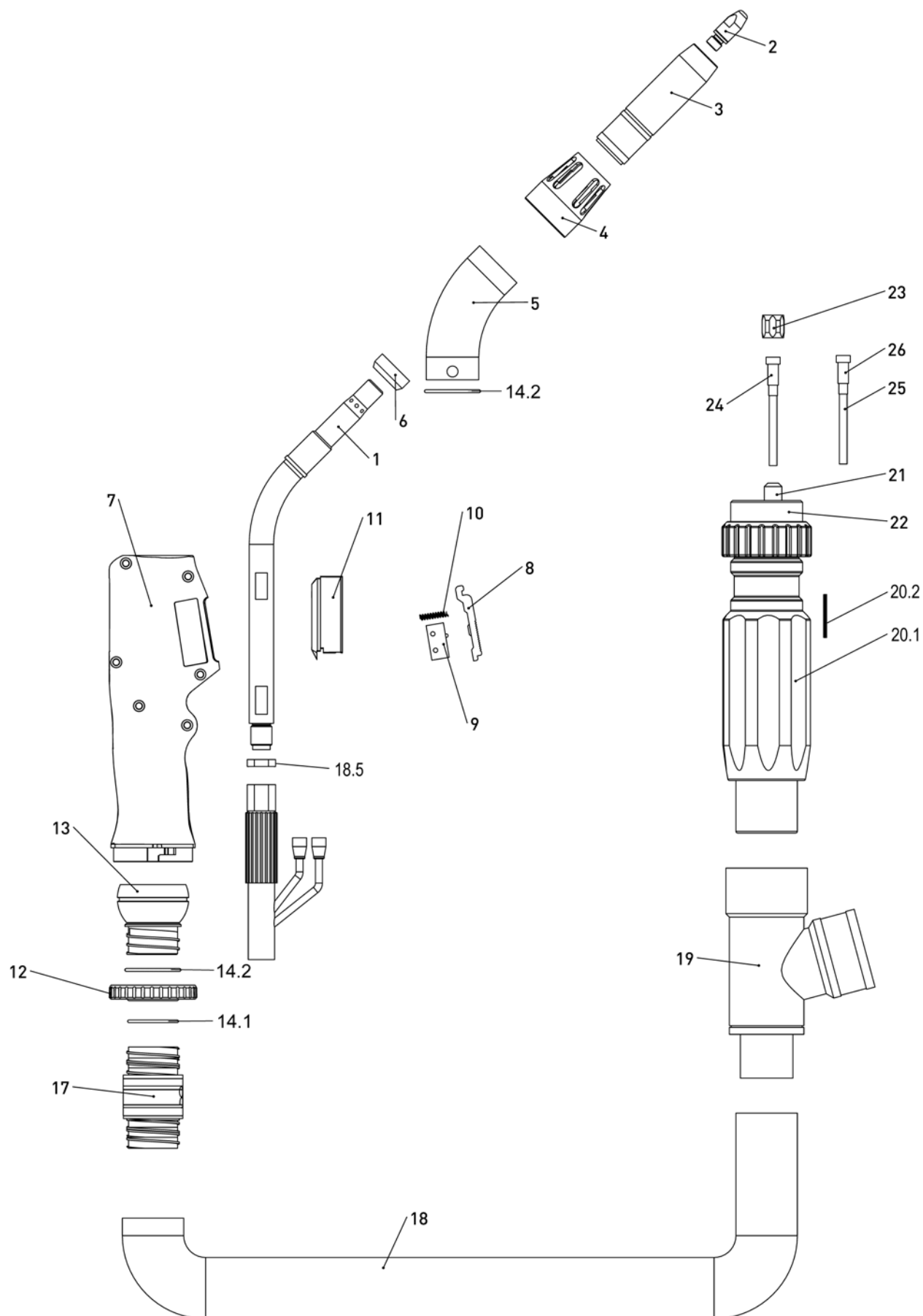
TEDAC®

TECHNICAL DATA:

Cooling:	gas cooled
Mixed gas:	250 A 60% duty cycle
CO ₂ :	280 A 100% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm [
Aluminium wire:	0.8 - 1.0 - 1.2 mm [
The data are corresponding to (U = 14 + 0.05 x l)	



- Integrated TEDAC system for remote control and display
- Extremely slim torch body: outer tube only 30 mm, fume nozzle only 32 mm diameter
- High fume extraction performance
- Same spare parts and consumables as SB/GBT 351 G
- TEDAC slide switch mounted in totally closed area
- High flexibility of the hose package due to ball joint
- Bypass control for adjustment of the vacuum



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG fume extraction torch RSB/RSBT 351 G					
	Fume extraction torch model RSB 351 G, 3 m		06	129270	630,00
	Fume extraction torch model RSB 351 G, 4 m		06	129272	660,00
	Fume extraction torch TEDAC, model RSBT 351 G, 3 m		06	129276	750,00
	Fume extraction torch TEDAC, model RSBT 351 G, 4 m		06	129278	780,00
Spare parts and consumables:					
	1 Torch neck RSB/T 351 G		22	130322	146,92
	2.1 Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	2.2 Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	2.2 Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	2.3 Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
	2.4 Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	2.5 Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	2.6 Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	2.7 Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89
	3 Gas nozzle 15 mm SB/T, RSB/T 351 G with thread and insulation		22	104170	10,91
	4 Fume extraction nozzle RSB/T 351 G		22	129074	42,20
	5 Fume extraction tube FT RSB/T 351 G		22	129094	106,28
	6 Isolation piece RSB/T 351 G		22	129080	9,38
	7 Handle fume extraction torch left and right		22	130320	201,62
	8 Trigger for MIG/MAG torch (red)		22	02210796	11,63
	9 Micro switch for torch trigger		22	113638	11,92
	10 Spring for switch	10 pcs	22	02210131	1,16
Only for RSBT 351 G:					
	11 TEDAC pcb incl. slide switch and frame for RSBT 351/503		22	131274	208,66

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	12	Bayonet ring for all torches with ball joint		22	131788	10,41
	13	Ball joint connection RSB/T 351 G		22	129638	24,38
	14.1	O-Ring 26 x 1,5		22	131292	2,90
	14.2	O ring 28 x 2		24	05011542	1,86
Only for RSB 351 G:						
	15	Cover cap for RSB torches with ball joint		22	131996	16,10
	16	Closing ring RSB/T 351 G		22	129650	17,66
	17.1	Bypass piece complete RSB/T 351 G		22	132594	85,96
	17.2	Bypass piece for RSB/T 351 G		22	130962	70,33
	17.3	Bypass controller ring RSB/T 351 G		22	130964	35,79
	18.1	Fume extraction hose D=29 mm (per m)		22	129626	70,33
	18.2	Coax cable, 3 m, 35 mm², for RSB/T 351 G		22	130968	127,27
	18.3	Coax cable, 4 m, 35 mm², for RSB/T 351 G		22	130982	144,63
	18.4	Coax cable, 5 m, 35 mm², for RSB/T 351 G		22	131560	161,98
	18.5	Nut for KOAX connector-V		22	142370	2,08
	19	T-connector RSB/RSBT D=29 mm		22	129564	81,27
	20.1	Kinking protection, intake water cooled		22	02510100	18,98
	20.2	Cover cap on water outlets for handle, water cooled		22	117508	1,56
	21	Brass body central connector MAG gas cooled		22	02511401	27,77

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	22	Sleeve nut black		22	02510300	13,07
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	24.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	24.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	24.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	24.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	25.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	25.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	25.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	25.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	26.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	26.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36

4.2.2. RSB/RSBT 504 W

MIG/MAG fume extraction torch RSB/RSBT 504 W water cooled



VERSIONS:



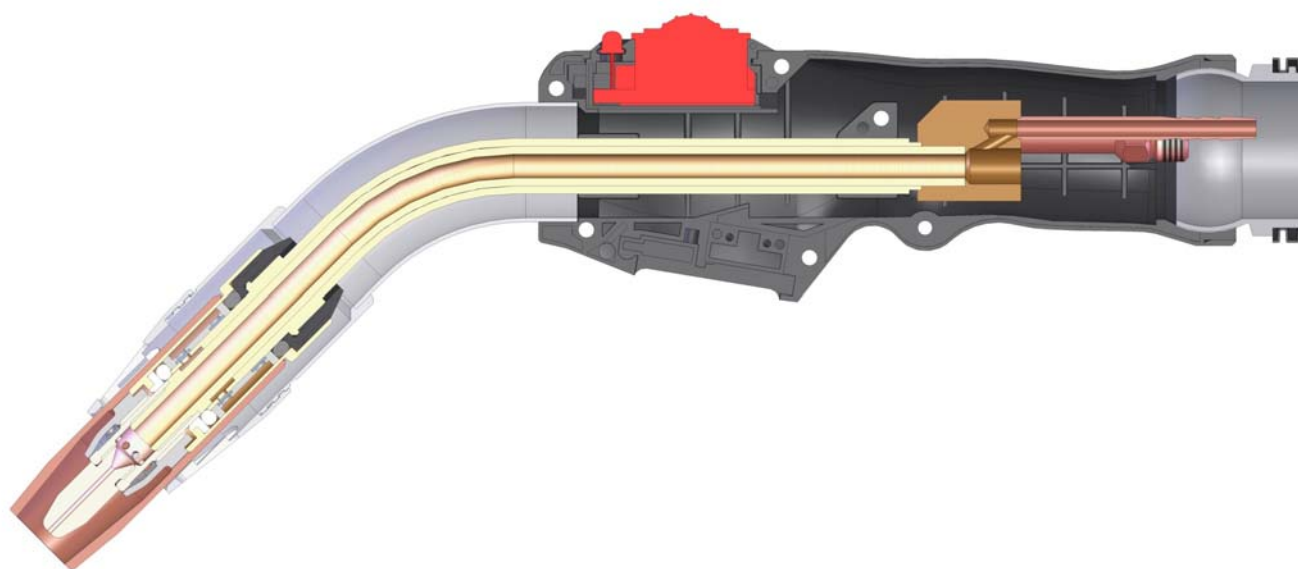
Standard



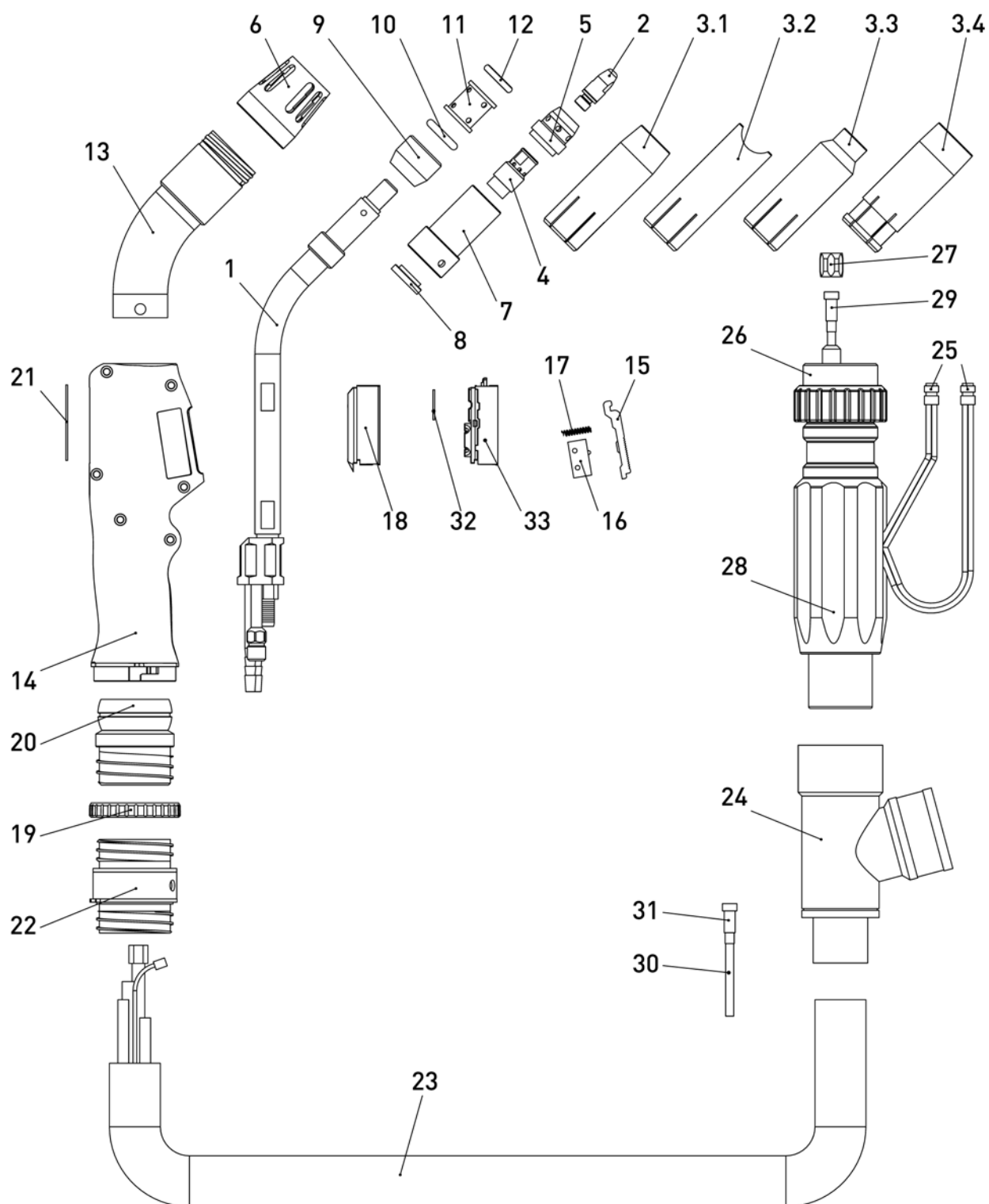
TEDAC®

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO ₂ :	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm [
Aluminium wire:	1.0 - 1.2 - 1.6 mm [
The data are corresponding to (U = 14 + 0.05 x l)	



- Integrated TEDAC system for remote control and display
- Extremely slim torch body: outer tube only 34 mm, fume nozzle only 36 mm diameter
- High fume extraction performance
- Same spare parts and consumables as SB/SBT 504 W
- TEDAC slide switch mounted in totally closed area
- High flexibility of the hose package due to ball joint
- Bypass control for adjustment of the vacuum



Pos.	Description	Pu	PrGrp	Part No.	Price/€
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MIG/MAG fume extraction torch RSB/RSBT 504 W



	Fume extraction torch model RSB 504 W, 3 m	06	164104	795,00
	Fume extraction torch model RSB 504 W, 4 m	06	164106	875,00
	Fume extraction torch TEDAC, model RSBT 504 W, 3 m	06	164102	915,00
	Fume extraction torch TEDAC, model RSBT 504 W, 4 m	06	164108	995,00

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:



	Torch body RSB/RSBT 504 W without water coat	22	160180	132,30	
2.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
2.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
2.2	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
2.3	Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
2.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
2.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
2.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
2.7	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89
3.1	Gas nozzle 17 mm with fastening ring	10 pcs	22	04514300	6,87
3.2	Spot welding gas nozzle with fastening ring	10 pcs	22	04514304	25,40
3.3	Gas nozzle 14 mm with fastening ring	10 pcs	22	04514301	11,90
3.4	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	22	04514305	37,20
4	Tip adapter SB/SBT 300/502/503/504 W	10 pcs	22	02211578	6,95
5.1	Gas diffuser 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	9,94
5.2	Gas diffuser 455/502/503/504 W, plastic	10 pcs	22	02211568	9,94
6	Fume extraction nozzle RSB/T 503 W	22	130992	42,20	

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	7	Water coat SB503/504 W for thread piece 131.276		22	131280	14,20
	8	Isolator 503/504 W for water coat 131.280		22	131278	3,12
	9	Thread piece 503/504 W for water coat 131.280		22	131276	10,50
	10	O-ring 14 x 4	10 pcs	22	02210077	2,37
	11	Pressure bushing SB/RSBT 502/503/504 W double wall	10 pcs	22	02211424	13,88
	12	O-ring 12 x 4	10 pcs	22	02210076	2,37
	13	Fume extraction tube RSB/T 503 W		22	130990	117,22
	14	Handle fume extraction torch left and right		22	130320	201,62
	15	Trigger for MIG/MAG torch (red)		22	02210796	11,63
	16	Micro switch for torch trigger		22	113638	11,92
	17	Spring for switch	10 pcs	22	02210131	1,16

Only for RSBT 503 W:

	18	TEDAC pcb incl. slide switch and frame for RSBT 351/503		22	131274	208,66
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		Bayonet ring for all torches with ball joint		22	131788	10,41
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	20	Ball joint connection RSB/T 503 W		22	131778	24,38
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Only for RSB 503 W:

	21	Cover cap for RSB torches with ball joint		22	131996	16,10
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Pos.	Description	Pu	PrGrp	Part No.	Price/€
	22.1 Bypass piece complete RSB/T 503 W		22	132596	79,71
	22.2 Bypass piece for RSB/T 503 W		22	131196	70,33
	22.3 Bypass controller ring RSB/T 503 W		22	131194	9,38
	23.1 Fume extraction hose 38 mm (per m)		22	103634	80,30
	23.1 Complete cable assembly, RSB/T 504 W 3 m, with Euro-connector, without torch, without liner		22	167044	656,45
	23.2 Complete cable assembly, RSB/T 504 W 4 m, with Euro-connector, without torch, without liner		22	167046	765,85
	24 T-connector RSB/RSBT D=38 mm		22	103635	84,40
	25 Coupling nipple for water	10 pcs	22	02510400	2,41
	26 Brass neck for Euro-connection water cooled		22	02510200	38,76
	27 Liner nut for Euro connector	10 pcs	22	02511301	2,67
	28 Kinking protection, intake water cooled		22	02510100	18,98
	29.1 Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	29.2 Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	29.3 Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	29.4 Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	29.5 Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	29.6 Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	30.1 Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	30.2 Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	30.3 Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	30.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	30.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	30.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	31.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	31.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	32.1	Wire feeding hose complete 3.0 m long only for SB/T 504 W		22	134498	42,09
	32.2	Wire feeding hose complete 4.0 m long only for SB/T 504 W		22	134500	43,43
	32.3	Wire feeding hose 28 red, 5.5 x 1.75 per m		22	134438	3,21
	32.5	Nippel for wire feeding hose M8 x 1 / Ø8		22	142412	3,34
	32.5	Nippel for wire feeding hose M10 x 1 / Ø8		22	114114	2,94
	33.1	Water-power-cable 3.0 m long for SB/T 352/504 W		22	142524	92,56
	33.2	Water-power-cable 4.0 m long for SB/T 352/504 W		22	142526	109,92
	34.1	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	34.2	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	35	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	36.1	Cable H07V-K 1.5 mm, black per m		22	00800200	0,66
	36.2	Cable H07V-K 1.5 mm red per m		22	00800204	0,64
	37	O-Ring 26 x 1,5		22	131292	2,90
	38	O ring 28 x 2		24	05011542	1,86

4.3. Push-Pull welding torches



4.3.1. PP/PPT 307 G

MIG/MAG Push-Pull torch PP/PPT 307 G gas cooled



45° bent



22° bent

VERSIONS:



Standard



TEDAC®

TECHNICAL DATA:

Cooling:	gas cooled
Mixed gas:	280 A 60% duty cycle
CO ₂ :	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm [
Aluminium wire:	0.8 - 1.0 - 1.2 mm [
Weight:	approx. 1200 g/1 m H

The data are corresponding to $(U = 14 + 0.05 \times I)$



MIG/MAG-Push-Pull welding torch PP/PPT 307 G

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Push pull hand welding torch model PP 307 G, 22° bent, 8 m with rotatable torch head		06	02110292	2.450,00
	Push pull hand welding torch model PP 307 G, 45° bent, 8 m with rotatable torch head		06	02110293	2.450,00
	Push pull hand welding torch TEDAC, PPT 307 G, 22° bent, 8 m, with rotatable torch head		06	02110294	2.700,00
	Push pull hand welding torch TEDAC, PPT 307 G, 45° bent, 8 m, with rotatable torch head		06	02110295	2.700,00

Standard wire equipment: mild steel 1.0 mm
Spare parts and consumables:

	1	Motor-block PP torch	22	02110151	178,18
	3.1	Wire feeding roller st. 0.8 mm (PP)	22	02110251	64,86
	3.2	Wire feeding roller st. 1.0 mm (PP)	22	02110252	64,86
	3.3	Wire feeding roller st. 1.2 mm (PP)	22	02110253	64,86
	3.6	Wire feeding roller alu 1.2 mm (PP)	22	02110257	64,86
	3.4	Wire feeding roller alu 0.8 mm (PP)	22	02110255	64,86
	3.5	Wire feeding roller alu 1.0 mm (PP)	22	02110256	64,86
	4	Wire feeding motor, PP-torch	22	02110272	1.625,48
	5	Pressure bracket PPL/PPW	22	02110160	32,82
	6	Pressure roller PPL/PPW	22	02110170	39,07
	7	Pressure bracket complete	22	02110181	142,70
	8	Spring DFO, 7x4, 3x9, 3x4x1.12 for fastening yoke 021.1.0181	22	02110182	3,79
	9	Insertion nozzle PP 307/502/504 Cold wire feed system KDZF	22	02110190	26,20
	10	Kinking protection	22	02110279	39,86
	13	Insertion nozzle KDZF (cold wire) PP 307/502	22	02110205	22,35

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	14, 15	Handle for Push-Pull hand welding torch PP/T 307, 502, 504 with fixed torch body, left and right side		22	134468	234,44
	16	Swivel cover for PP torch		22	02110237	47,67
	17	Stainless steel pressure piece, spring lock		22	02110185	4,53
	18	Torch interruptor		22	02110335	34,07
	19	Cover cap for TEDAC handle		22	02210604	5,21
	20	Potentiometer 10 kOhm PP-torch		22	00100506	71,90
	21			22	139940	
	22	Torch lead cpl. 8 m, PP/PPT 307 without torch, with Euro-connector		22	02110119	640,82
	23	Coax cable, cpl. 8 m, PP-torch		22	02110288	265,00
	24	Gas hose 8 m		22	02110260	14,00
	25	Control cable 8 x 0,5 (8 G 0,5) per meter		07	114578	6,28
	26	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	27	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	28	Kinking protection, intake water cooled		22	02510100	18,98
	29	Brass neck for Euro-connection water cooled		22	02510200	38,76
	30	Sleeve nut black		22	02510300	13,07
	31	Liner for steel uncoated 2,5 x 4,5 0.6 -1.6 mm, 8 m long		22	02110325	18,76
	32	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	33	Socket 10-pole (-) (for push pull torch)		22	02110384	59,39
	34	Cable support for 10 pol. plug		07	02110388	28,50
	35	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36	Teflon liner 2.0 x 4.0 Alu/stainl. steel 0.8 - 1.6 mm, 8 m		22	02110326	49,75
	38	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	39	Brass liner 2 x 4, per meter		22	135578	9,72
	40	Torch neck support		22	02110020	129,73
	41	Sleeve		22	02110021	30,01
	42	O-ring 7.5 x 1.5, PP-torch 307		22	02110022	2,56
	43	O-ring 9.5 x 1.5, PP-torch 307		22	02110023	3,50
	44.1	Torch neck PP/PPT 307, 22°, cpl.		22	02110024	191,46
	44.2	Torch neck PP/PPT 307 G, 45°		22	02110025	191,46
	45	Bearing bush, seperated, PP 307		22	02110026	11,72
	46	Thread sleeve, PP 307		22	02110027	19,22
	47.1a	Gas diffuser SB/SBT 307 G ceramic spatter resistant	10 pcs	22	02210219	6,90
	47.1b	Gas diffuser SB/T 307 G plastic, black, for gas nozzle 022.1.0267, 022.1.0310	10 pcs	22	02210222	6,90
	47.2	Gas diffuser SB/T 307 G, plastic for gas nozzle 111.462	10 pcs	22	111938	15,62
	48.1	Tip adapter, SB 307 G, 38 mm	10 pcs	22	02210217	5,21
	48.2	Tip adapter SB 307, 38 mm for aluminium, inner diameter 4. 8 mm	10 pcs	22	02210215	10,02
	49.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	49.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	49.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	49.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	49.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	49.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	50	Insulation ring SB 300/307	20 pcs	22	02210369	3,30
	51.1	Gas nozzle SB/SBT 300/307, with thread		22	02210267	8,85
	51.2	Gas nozzle 12 mm screw fixing (only with gas diffuser 111.938)	10 pcs	22	111462	24,60
	51.3	Spot welding gas nozzle 300/307 with fastening ring		22	02210310	9,83

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	55	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	152,72
	56	Insertion element PP 307/502/504		22	02110337	9,07
	57	Cover cap on water outlets for handle, water cooled		22	117508	1,56

4.3.2. PP/PPT 504 W

MIG/MAG Push-Pull torch PP/PPT 504 W

water cooled



45° bent



straight

45° bent with rotatable
torch head



VERSIONS:



Standard



TEDAC®

TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO ₂ :	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.6 mm [
Aluminium wire:	0.8 - 1.0 - 1.6 mm [
Weight:	approx. 1850 g/1 m H

The data are corresponding to $(U = 14 + 0.05 \times I)$



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG-Push-Pull welding torch PP/PPT 504 W					
	Push-Pull hand welding torch model PP 504 W, straight, 8 m		06	166478	2.600,00
	Push-Pull hand welding torch model PP 504 W, 45° bent, 8 m		06	166474	2.600,00
	Push-Pull hand welding torch TEDAC, PPT 504 W, straight, 8 m		06	166472	2.850,00
	Push-Pull hand welding torch TEDAC, PPT 504 W, 45° bent, 8 m		06	166476	2.850,00
With rotatable torch head:					
	Push-Pull hand welding torch model PP 504 W, 45° bent, 8 m with rotatable torch head		06	131789	2.840,00
	Push-Pull hand welding torch TEDAC, model PPT 504 W, 45 ° bent, 8 m with rotatable torch head		06	131790	3.090,00
Standard wire equipment: mild steel 1.0 mm					
Spare parts and consumables:					
	1 Motor-block PP torch		22	02110151	178,18
	2.1 Wire feeding roller st. 0.8 mm (PP)		22	02110251	64,86
	2.2 Wire feeding roller st. 1.0 mm (PP)		22	02110252	64,86
	2.3 Wire feeding roller st. 1.2 mm (PP)		22	02110253	64,86
	2.4 Wire feeding roller st. 1.6 mm (PP)		22	02110254	64,86
	2.5 Wire feeding roller alu 0.8 mm (PP)		22	02110255	64,86
	2.6 Wire feeding roller alu 1.0 mm (PP)		22	02110256	64,86
	2.7 Wire feeding roller alu 1.2 mm (PP)		22	02110257	64,86
	3 Wire feeding motor, PP-torch		22	02110272	1.625,48
	4 Pressure bracket PPL/PPW		22	02110160	32,82
	5 Pressure roller PPL/PPW		22	02110170	39,07
	6 Pressure bracket complete		22	02110181	142,70
	7 Spring DFO, 7x4, 3x9, 3x4x1.12 for fastening yoke 021.1.0181		22	02110182	3,79

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	8	Insertion nozzle PP 307/502/504 Cold wire feed system KDZF		22	02110190	26,20
	9	Kinking protection		22	02110279	39,86
	10	Insertion nozzle KDZF (cold wire) PP 307/502		22	02110205	22,35
	11.1	Handle for Push-Pull hand welding torch PP/T 307, 502, 504 with fixed torch body, left and right side		22	134468	234,44
	11.2	Handle for Push-Pull hand welding torch PP/T 502/504 with rotatable torch body, left and right side		22	134472	296,96
	13	Swivel cover for PP torch		22	02110237	47,67
	14	Stainless steel pressure piece, spring lock		22	02110185	4,53
	15	Torch interruptor		22	02110335	34,07
	16	Cover cap for TEDAC handle		22	02210604	5,21
	17	Potentiometer 10 kOhm PP-torch		22	00100506	71,90
	18			22	139940	
	19	Torch lead cpl. 8 m, PP/T 502/504 without torch, without Euro-connection		22	134466	520,00
	20	Wire feeding hose 8 m		22	02110283	124,88
	20a	Connection nipple		22	02110310	14,46
	21	Gas hose 8 m		22	02110260	14,00
	22	Control cable 8 x 0,5 (8 G 0,5) per meter		07	114578	6,28
	23	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	24	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	25	Kinking protection, intake water cooled		22	02510100	18,98
	26	Brass neck for Euro-connection water cooled		22	02510200	38,76
	27	Sleeve nut black		22	02510300	13,07
	28	Plastic liner 2.0 x 4.0 per meter		22	132792	4,28

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	29	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	30	Socket 10-pole (-) (for push pull torch)		22	02110384	59,39
	31	Cable support for 10 pol. plug		07	02110388	28,50
	32	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	33	Plastic liner 2.0 x 4.0 per meter		22	132792	4,28
	34	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	35	Brass liner 2 x 4, per meter		22	135578	9,72
	36.1			22	166492	214,05
	36.2			22	166494	327,43
	36.3	Torch neck PP/PPT 504 W, 45° bent for torch with rotatable torch neck		22	158492	351,67
	37	Secure nut for PP/T 504 W with rotatable torch neck		22	158494	77,37
	38	Thread piece 503/504 W for water coat 131.280		22	131276	10,50
	39	O-ring 14 x 4	10 pcs	22	02210077	2,37
	40	O-ring 12 x 4	10 pcs	22	02210076	2,37
	41	Pressure bushing SB/SBT 502/503/504 W double wall	10 pcs	22	02211424	13,88
	42	Water coat SB503/504 W for thread piece 131.276		22	131280	14,20
	43	Insulation ring SB/SBT 502 W	20 pcs	22	02211421	2,39
	44	Tip adapter SB/SBT 300/502/503/504 W	10 pcs	22	02211578	6,95
	45.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	45.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	45.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	45.4	Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
	45.5	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	45.6	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	45.7	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	46.1	Gas diffuser 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	9,94
	46.2	Gas diffuser 455/502/503/504 W, plastic	10 pcs	22	02211568	9,94
	47	Gas nozzle 17 mm with fastening ring	10 pcs	22	04514300	6,87
	47.1	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	22	04514305	37,20
	48	Spot welding gas nozzle with fastening ring	10 pcs	22	04514304	25,40
	49	Gas nozzle 14 mm with fastening ring	10 pcs	22	04514301	11,90
	50	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	152,72
	51	Insertion element PP 307/502/504		22	02110337	9,07
	52	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	53	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	54	Coupling nipple for water	10 pcs	22	02510400	2,41
	55	Water-power-cable 8.0 m long		22	02110321	190,68
	56	O ring 12 x 1.5	10 pcs	22	131898	2,37
	57	O ring 11 x 1.5	10 pcs	22	131896	2,37
	58	O ring 9.25 x 1.78	10 pcs	22	02110040	2,41
	59	Water distributor for PP/T 504 W with rotatable torch neck		22	158496	368,86
	60	Red cap for water torch connector	10 pcs	22	130958	2,43
	61	Blue cap for torch water connector	10 pcs	22	130959	2,43
	62	Clamping V2 for PP torch		22	137424	31,00
	63	Kinking protection for MIG torches water cooled		22	02211580	13,07
	64	Isolation piece PP/T 503/504		22	139196	40,09

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4.4. Machine and robot welding torches



4.4.1. MSB 401 W

MIG/MAG machine welding torch

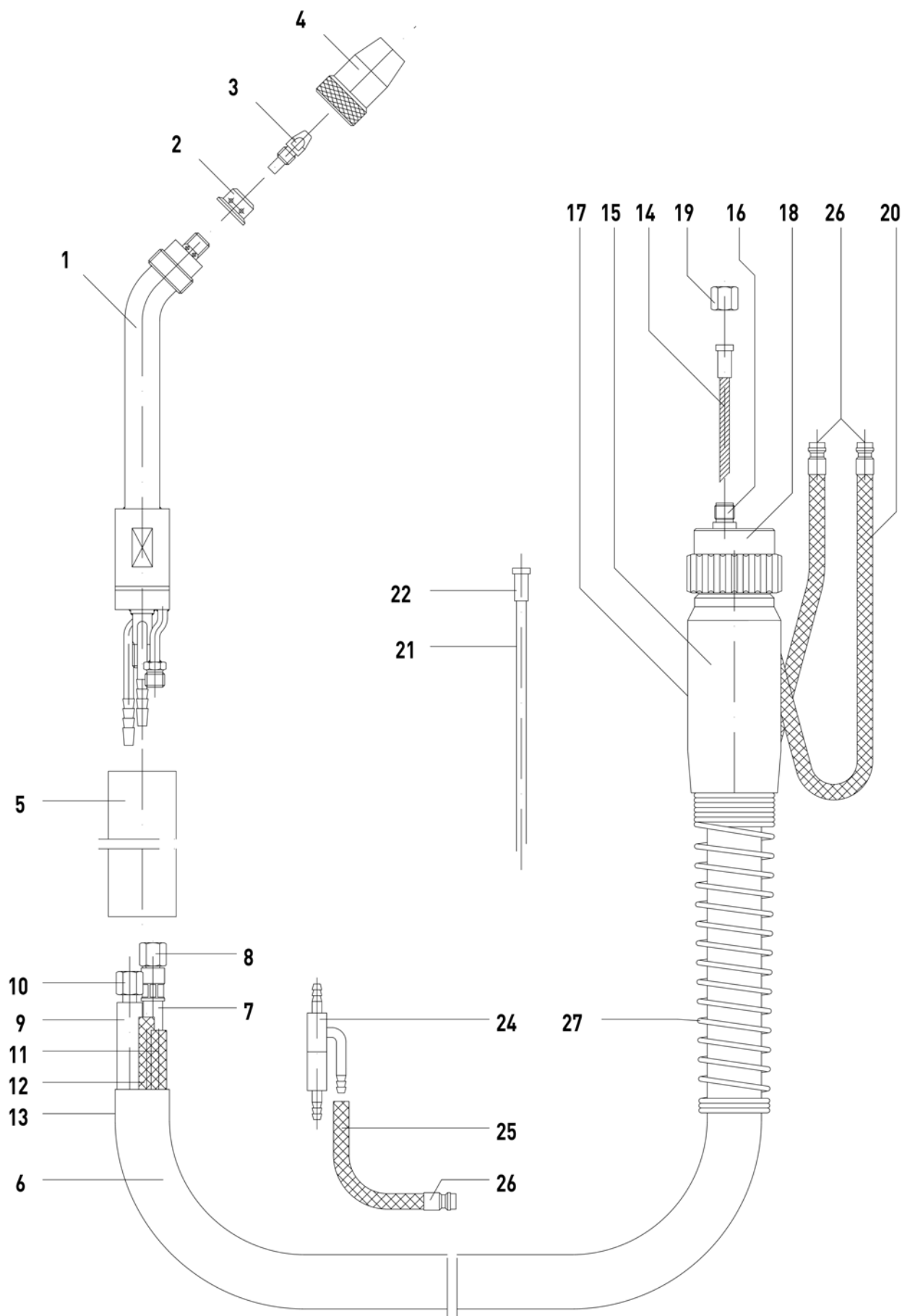
MSB 401 W

water cooled



TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	380 A 60% duty cycle
CO ₂ :	350 A 100% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm [
Aluminium wire:	1.0 - 1.2 - 1.6 mm [
The data are corresponding to (U = 14 + 0.05 x l)	



Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG machine welding torch MSB 401 W					
	MIG/MAG machine welding torch Model MSB 401 W, 1.5 m, bent		06	111812	1.625,50
	MIG/MAG machine welding torch Model MSB 401 W, 2.0 m, bend		06	111816	1.638,00
	MIG/MAG machine welding torch Model MSB 401 W, 2.5 m, bent		06	111820	1.650,50
	MIG/MAG machine welding torch Model MSB 401 W, 3.0 m, bent		06	111824	1.663,00
	MIG/MAG machine welding torch Model MSB 401 W, 4.0 m, straight		06	111830	1.548,00
	Blow-out device for MIG/MAG machine welding torch		06	02211810	175,00

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:

1.1	Torch neck MSB 401 W, bent		22	111810	1.122,29
1.2	Torch neck MSB 401 W, straight		22	111806	1.018,16
2	Gas diffusor MSB 400/401 W ceramic		22	111802	37,50
3.1	Contact tip 0.8 MSB 401 W, Cu-Cr-Zr	20 pcs	22	111776	8,44
3.2	Contact tip 1.0 MSB 401 W, Cu-Cr-Zr	20 pcs	22	111780	8,44
3.3	Contact tip 1.2 MSB 401 W, Cu-Cr-Zr	20 pcs	22	111782	8,44
3.4	Contact tip 1.6 MSB 401 W, Cu-Cr-Zr	20 pcs	22	111786	8,44
3.5	Contact tip alu 0.8 for MSB 401 W Cu-Cr-Zr	20 pcs	22	111788	8,44
3.6	Contact tip alu 1.0 for MSB 401 W Cu-Cr-Zr	20 pcs	22	111790	8,44
3.7	Contact tip alu 1.2 for MSB 401 W Cu-Cr-Zr	20 pcs	22	111792	8,44
3.8	Contact tip alu 1.6 for MSB 401 W Cu-Cr-Zr	20 pcs	22	111794	8,44
4	Gas nozzle for MSB 400/401 W		22	111796	31,26
5	Carrier pipe for MSB 401 W, pvc		22	131512	34,39
6.1	Hose-package MSB, 1.5 m long with Euro-connection		22	02210157	342,29
6.2	Hose-package MSB, 2.0 m long with Euro-connection		22	02210158	356,36
6.3	Hose-package MSB, 2.5 m long with Euro-connection		22	02210159	368,86
6.4	Hose-package MSB, 1.5 m long with Euro-connection, blow-out-device		22	02210910	396,99
6.5	Hose-package MSB, 2.0 m long with Euro-connection, blow-out-device		22	02210911	411,06
6.6	Hose-package MSB, 2.5 m long with Euro-connection, blow-out-device		22	02210912	429,82
7.1	Water-power-cable 1.5 m long		22	02210283	73,50
7.2	Water-power-cable 2.0 m long		22	02210284	80,18
7.3	Water-power-cable 2.5 m long		22	02210285	117,22
8	Connection-nipple for water-power-cable, at torch side		22	04510200	16,08

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	9.1	Wire feeding hose cpl. 1.5 m long		22	02211659	37,66
	9.2	Wire feeding hose cpl. 2.0 m long		22	02211660	46,89
	9.3	Wire feeding hose cpl. 2.5 m long		22	02211661	51,58
	10	Nipple for wire feeding hose at torch side		22	04510310	10,20
	11	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	12	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	12.1	Gas-hose cpl. 1.5 mm long with blow-out-value		22	02210920	57,62
	12.2	Gas-hose cpl. 2.0 m long with blow-out-value		22	02210921	58,20
	12.3	Gas-hose cpl. 2.5 m long with blow-out-value		22	02210922	58,20
	13	Protective hose 28 x 1,5 black		22	00600405	11,90
	14.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	14.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	14.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	14.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	14.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	14.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	15	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	16	Brass neck for Euro-connection water cooled		22	02510200	38,76
	17	Kinking protection, intake water cooled		22	02510100	18,98
	18	Sleeve nut black		22	02510300	13,07
	19	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	20	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	21.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	21.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	21.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	21.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	21.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	21.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	22.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	22.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	24	Blow-out-valve		22	02210055	68,77
	25	Hose highly flexible 5,0 x 1,5, black		22	104332	6,77
	26	Coupling nipple for water	10 pcs	22	02510400	2,41
	27	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
		Kinking protection for MIG torches water cooled		22	02211580	13,07

4.4.2. MSB 603 W

MIG/MAG machine welding torch

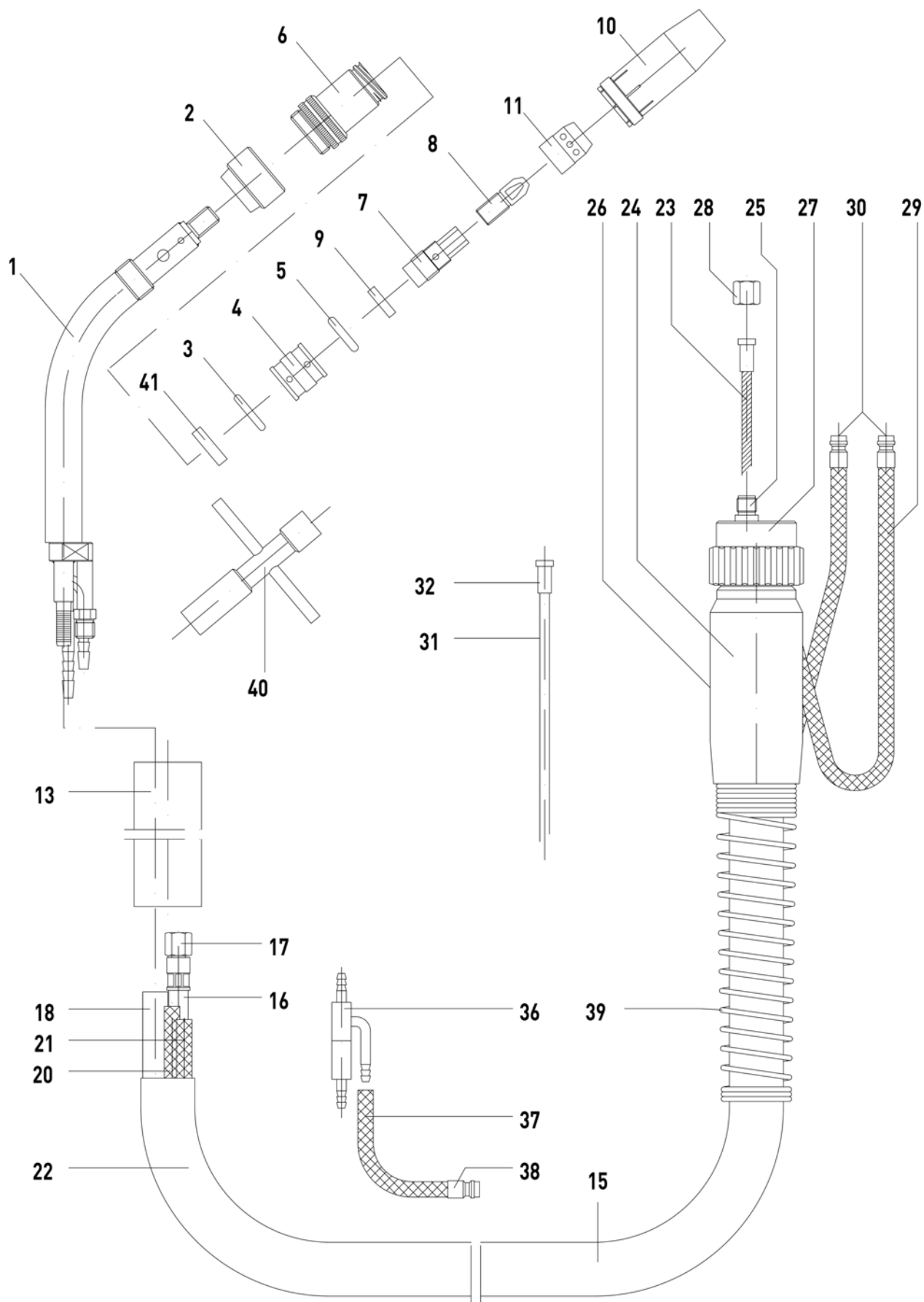
MSB 603 W

water cooled



TECHNICAL DATA:

Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO ₂ :	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1.6 mm [
Aluminium wire:	1.0 - 1.2 - 1.6 mm [
The data are corresponding to (U = 14 + 0.05 x I)	



MIG/MAG machine welding torch MSB 603 W



Pos.	Description	Pu	PrGrp	Part No.	Price/€
	MIG/MAG machine welding torch model MSB 603 W, 1.5 m, straight		06	02211801	965,50
	MIG/MAG machine welding torch model MSB 603 W, 2.0 m straight		06	02211803	978,00
	MIG/MAG machine welding torch model MSB 603 W, 2.5 m , straight		06	02211805	990,50
	MIG/MAG machine welding torch model MSB 603 W, 3.0 m, straight		06	02211807	1.003,00
	MIG/MAG machine welding torch model MSB 603 W, 4.0 m, straight		06	02211809	1.028,00
	MIG/MAG machine welding torch model MSB 603 W, 1.5 m, bent		06	02211800	980,50
	MIG/MAG machine welding torch model MSB 603 W, 2.0 m, bent		06	02211802	993,00
	MIG/MAG machine welding torch model MSB 603 W, 2.5 m, bent		06	02211804	1.005,50
	MIG/MAG machine welding torch model MSB 603 W, 3.0 m, bent		06	02211806	1.018,00
	MIG/MAG machine welding torch model MSB 603 W, 4.0 m, bent		06	02211808	1.043,00
	Blow-out device for MIG/MAG machine welding torch		06	02211810	175,00

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:

1.1	Torch neck MSB 603 W, straight		22	02211729	202,48
1.2	Torch neck MSB 603 W, bent		22	02211730	225,62
2	Thread ring for ROB 504, SB/MSB 603 W		22	111982	13,10
3	O-ring 16 x 3.5	10 pcs	22	02211777	1,83
4	Internal sleeve 600/603 W	2 pcs	22	02211753	14,03
5	O-ring 14 x 4	10 pcs	22	101059	6,94
6	Water coat ROB 504, SB/MSB 603 W for gas nozzle 110.136		22	110138	27,88
7	Tip holder 504/603 W	2 pcs	22	108258	11,51
8.1	High performance contact tip 1.0 mm for SB/MSB 600/603 W	20 pcs	22	02211758	3,56
8.2	High performance contact tip 1.2 mm for SB/MSB 600/603 W	20 pcs	22	02211759	3,56
8.3	High performance contact tip 1.6 mm for SB/MSB 600/603 W	20 pcs	22	02211761	3,56
8.4	High performance contact tip 1.0 mm alu for SB/MSB 600/603 W	20 pcs	22	107894	4,34
8.5	High performance contact tip 1.2 mm alu for SB/MSB 600/603 W	20 pcs	22	107896	4,34
8.6	High performance contact tip 1.6 mm alu for SB/MSB 600/603 W	20 pcs	22	107898	4,34
9	Ceramic ring 504/603 W	2 pcs	22	02210340	3,59

Pos.	Description	Pu	PrGrp	Part No.	Price/€
10.1	Gas nozzle d = 17 mm, l = 67 mm standard B/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	110136	14,66
10.2	Gas nozzle d = 17 mm, l = 61 mm SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	138146	24,10
10.3	Gas nozzle d = 17 mm, l = 64 mm SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	138158	24,10
10.4	Gas nozzle d = 15.5 mm, l = 61 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144046	33,50
10.5	Gas nozzle d = 15.5 mm, l = 64 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144044	33,50
10.6	Gas nozzle d = 15.5 mm, l = 67 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144042	41,50
11	Gas diffuser SB 300/603 W ceramic	5 pcs	22	107966	6,01
13	Handle tube MSB 455/603 W		22	02210125	88,00
15.1	Hose-package MSB, 1.5 m long with Euro-connection		22	02210157	342,29
15.2	Hose-package MSB, 2.0 m long with Euro-connection		22	02210158	356,36
15.3	Hose-package MSB, 2.5 m long with Euro-connection		22	02210159	368,86
15.4	Hose-package MSB, 1.5 m long with Euro-connection, blow-out-device		22	02210910	396,99
15.5	Hose-package MSB, 2.0 m long with Euro-connection, blow-out-device		22	02210911	411,06
15.6	Hose-package MSB, 2.5 m long with Euro-connection, blow-out-device		22	02210912	429,82
16.1	Water-power-cable 1.5 m long		22	02210283	73,50
16.2	Water-power-cable 2.0 m long		22	02210284	80,18
16.3	Water-power-cable 2.5 m long		22	02210285	117,22
16.4	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	95,45
17	Connection-nipple for water-power-cable, at torch side		22	04510200	16,08
18.1	Wire feeding hose cpl. 1.5 m long		22	02211659	37,66
18.2	Wire feeding hose cpl. 2.0 m long		22	02211660	46,89
18.3	Wire feeding hose cpl. 2.5 m long		22	02211661	51,58
20	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
21	PVC hose 5 x 1.5, black per m		22	00600207	1,61
21.1	Gas-hose cpl. 1.5 mm long with blow-out-value		22	02210920	57,62
21.2	Gas-hose cpl. 2.0 m long with blow-out-value		22	02210921	58,20
21.3	Gas-hose cpl. 2.5 m long with blow-out-value		22	02210922	58,20
22	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	23.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	23.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	23.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	23.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	23.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	23.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	24	Euro-connector, torch side for water cooled version incl. spring		22	02510150	76,94
	25	Brass neck for Euro-connection water cooled		22	02510200	38,76
	26	Kinking protection, intake water cooled		22	02510100	18,98
	27	Sleeve nut black		22	02510300	13,07
	28	Liner nut for Euro connector	10 pcs	22	02511301	2,67
	29	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	31.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	31.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	31.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	31.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	31.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	31.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	32.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	32.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	36	Blow-out-valve		22	02210055	68,77
	37	Hose highly flexible 5,0 x 1,5, black		22	104332	6,77
	38	Coupling nipple for water	10 pcs	22	02510400	2,41

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	39	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	40	Key for 504/600/603 W		22	01370043	28,93
	41	Distance ring 21,8 x 5,5 504/603 W		22	02211815	2,87
		Kinking protection for MIG torches water cooled		22	02211580	13,07
				22	02211816	13,60
		Threaded insert M5 x 9.4 mm		22	04514606	3,80

4.4.3. ROB 505 W

MIG/MAG machine welding torch ROB 505 W

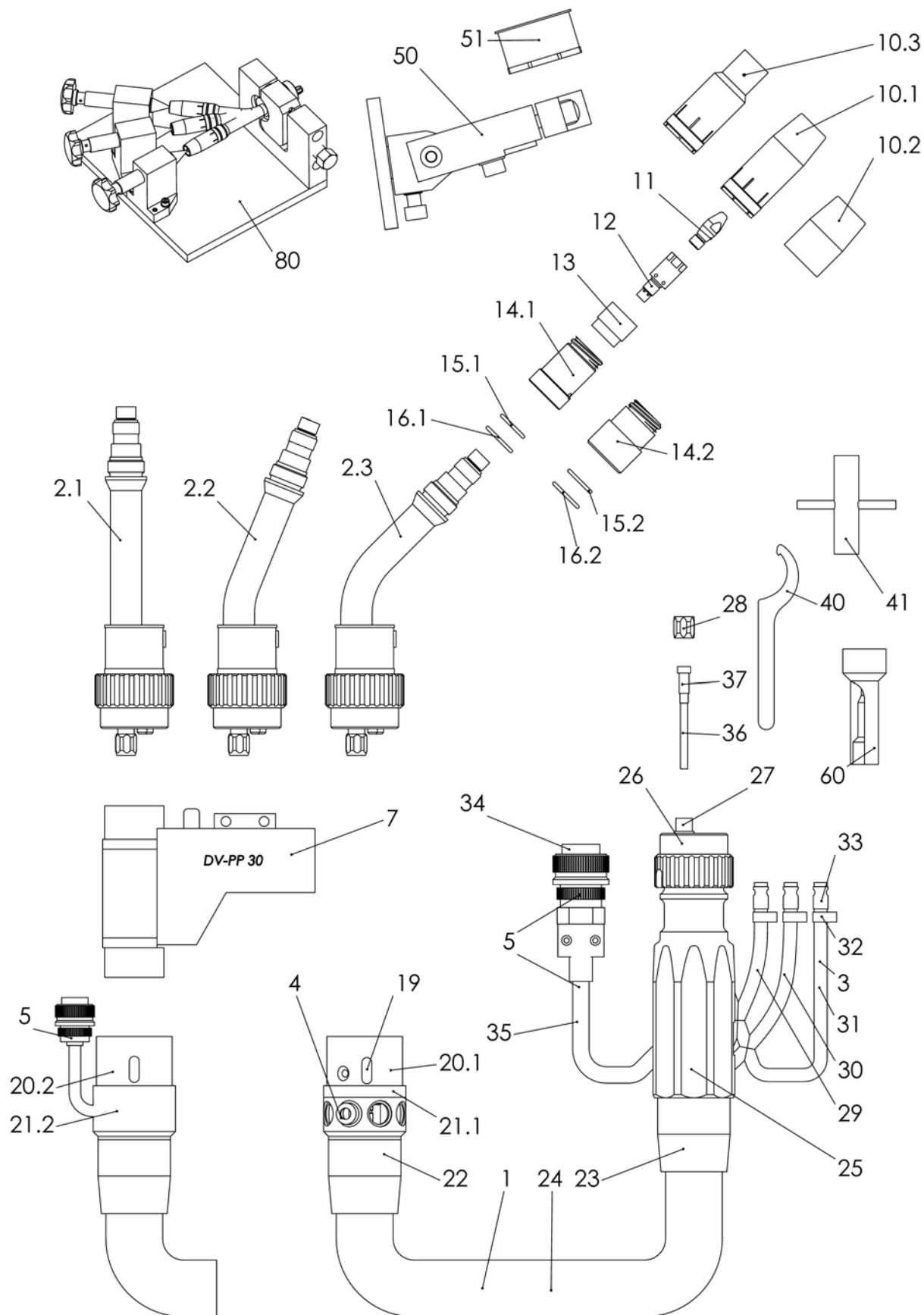
water cooled / Euro connector
 separate torch head

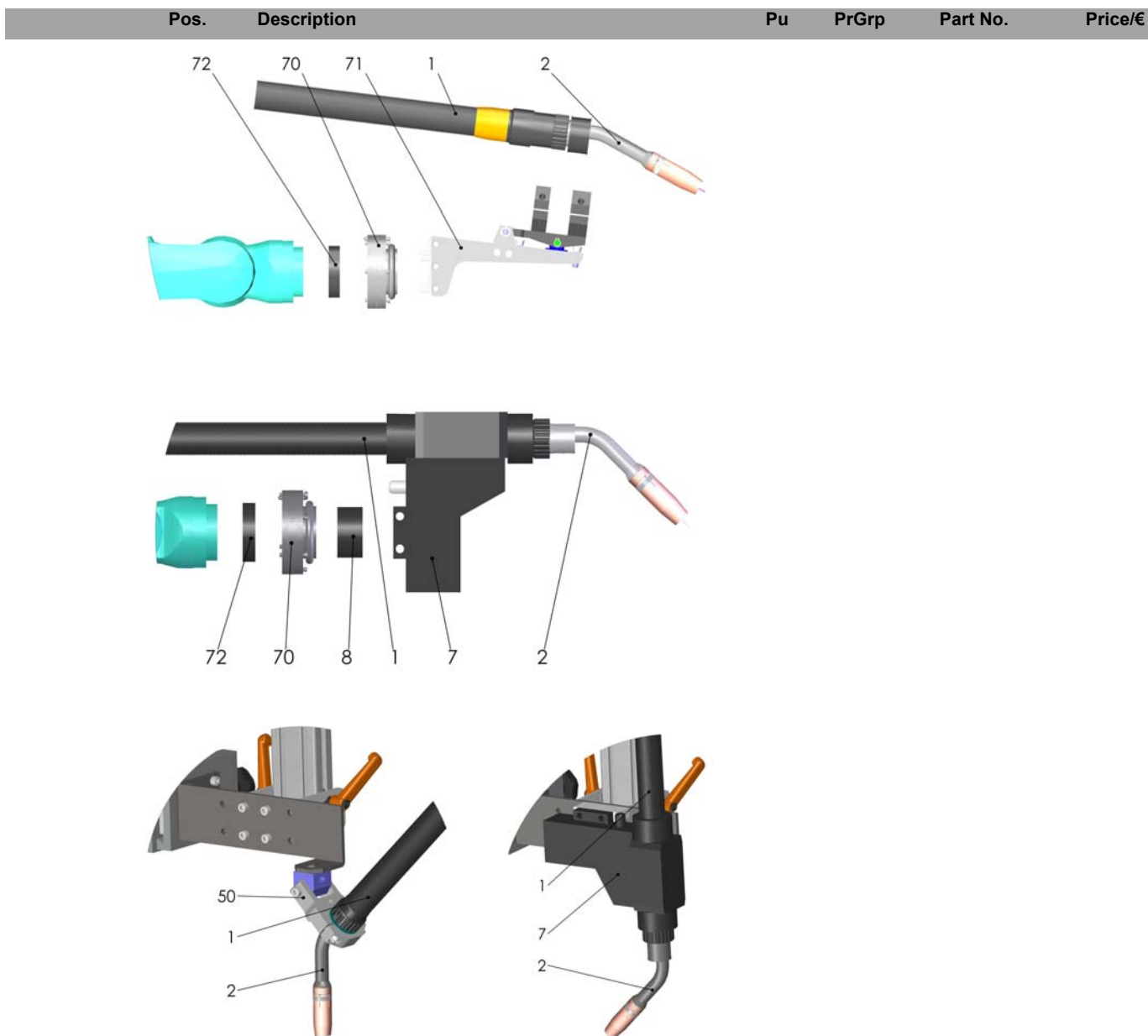
Versions of the torch head: straight, 22° bent, 45° bent



TECHNICAL DATA:

Gas nozzle	Standard	High performance
60% duty cycle:	450 A (36.5 V)*	500 A (39.0 V)*
100% duty cycle:	400 A (34.0 V)*	450 A (36.5 V)*
*Mixed gas (Ar/CO ₂ 82/18)		
Cooling:	water cooled	
Wire diameter:	0.8 - 1.0 - 1.2 - 1.6 mm [	
Weight torch head:	0.75 kg	
The data are corresponding to (U = 14 + 0.05 x I)		





Hose assemblies ROB 505 W

1.1	Hose assembly 1.2 m, ROB 505 W	06	118503	797,50
1.2	Hose assembly 1.5 m, ROB 505 W	06	118504	802,50
1.3	Hose assembly 2.0 m, ROB 505 W	06	119264	815,00
1.4	Hose assembly 2.5 m, ROB 505 W	06	119266	827,50

For use with WCM tractor:

1.5	Hose assembly up to 4 m, ROB 505 W (only for WCM)	06	133770	865,00
1.6	Hose assembly up to 8 m, ROB 505 W (only for WCM and PP)	06	133772	1.030,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Torch bodies ROB 505 W					
	2.1 Torch body ROB 505 W, 0°		06	151829	760,00
	2.2 Torch body ROB 505 W, 22°		06	118478	790,00
	2.3 Torch body ROB 505 W, 45°		06	118480	790,00
Options for ROB 505 W:					
3	Blow-out device for hose assembly ROB 505 W		06	120478	105,00
4	Buttons "wire inching" and "gas test" at torch connector of hose assembly ROB 505 W incl. control cable with plug		06	120476	230,00
4.1	Fixture for switch		22	111590	25,01
5.1	Connection cable for TBi crash sensor mounted in hose assembly ROB 505 W		06	120132	210,00
5.2	Connection cable and socket for Dinse crash sensor mounted in hose assembly ROB 505 W		06	120134	210,00
5.3	Connection cable for AbicorBinzel crash sensor mounted in hose assembly ROB 505 W		06	120136	210,00
5.4	Connection cable for external buttons in torch holder or for push pull feeder ROB-PP mounted in hose assembly ROB 505 W		06	120138	210,00
6	Dinse torch connector for ROB 505 W		06	125334	
7	Wire feed unit DV-PP 30 for ROB-W-PP with 4 roller drive		06	110900	3.820,00
8	Flange wire feed unit DV-PP 30 at crash sensor (please indicate crash sensor)		51	126824	0,00
9	Connection cable for touch sensor gas nozzle, mounted in the robot torch hose assembly, incl. cable from hose assembly to torch holder		06	146784	155,00
60.1	Torch cleaning station BRG 2000 incl. spray unit and milling head		51	117726	0,00
60.2	Milling head for torch cleaning station BRG 2000 for ROB 505 W		51	120492	0,00
60.3	Wire cutting unit DA 2000 KPL		51	117728	0,00
60.4	Stand for BRS 20, BRG 2000		51	111716	0,00
70.1	Crash sensor TBi KS2 without assembly device		51	145790	688,59
70.2	Crash sensor DIX SAS 100 system Dinse without adapter		51	128284	0,00
70.3	Crash sensor Binzel CAT2 without adapter		51	111402	1.005,56
71.1	Torch holder for ROB 505 W for TBi KS1/KS2 incl. accessories		51	123750	380,36
71.2	Torch holder for ROB 505 W Dinse TCP, for SASS 2000 incl. accessories		51	152325	380,36
71.3	Torch holder for ROB 505 W for Abicor Binzel CAT2, CAT 3 incl. accessories		51	123748	300,58
72.1	Flange for KUKA robot at crash sensor (please indicate exact robot model)		51	126812	355,23
72.2	Flange for MOTOMAN robot at crash sensor (please indicate exact robot model)		51	126814	

Pos.	Description	Pu	PrGrp	Part No.	Price/€
72.3	Flange for Fanuc robot at crash sensor (please indicate exact robot model)		51	126816	
72.4	Flange for ABB robot at crash sensor (please indicate exact robot model)		51	126818	
72.5	Flange for REIS robot at crash sensor (please indicate exact robot model)		51	128730	

Spare parts and consumables:

10.1a	Gas nozzle d = 17 mm, l = 67 mm standard B/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	110136	14,66
10.1b	Gas nozzle d = 17 mm, l = 61 mm SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	138146	24,10
10.1c	Gas nozzle d = 17 mm, l = 64 mm SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	138158	24,10
10.2	Gas nozzle d=17 mm ROB 505 W high performance version push and screw fixing, nickel plated for water jacket 123.328	10 pcs	22	123332	24,10
10.3a	Gas nozzle d = 15.5 mm, l = 61 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144046	33,50
10.3b	Gas nozzle d = 15.5 mm, l = 64 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144044	33,50
10.3c	Gas nozzle d = 15.5 mm, l = 67 mm bottle shape SB/MSB 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	22	144042	41,50
11.1	Contact tip ROB 355/505, 0.8 mm conical	20 pcs	22	124802	3,33
11.2	Contact tip ROB 355/505, 1.0 mm conical	20 pcs	22	124804	3,33
11.3	Contact tip ROB 355/505, 1.2 mm conical	20 pcs	22	124800	3,33
11.4	Contact tip ROB 355/505, 1.4 mm conical	20 pcs	22	124806	3,33
11.5	Contact tip ROB 355/505, 1.6 mm conical	20 pcs	22	124808	3,51
11.6	Contact tip ROB 355/505, 2.0 mm conical	20 pcs	22	124810	3,33
11.7	Contact tip ROB 355/505, 2.4 mm conical	20 pcs	22	124812	3,33
11.8	Contact tip ROB 355/505, alu 1.0 mm conical	20 pcs	22	125108	3,76
11.9	Contact tip ROB 355/505, alu 1.2 mm conical	20 pcs	22	125110	3,76
11.10	Contact tip ROB 355/505, alu 1.6 mm conical	20 pcs	22	124814	3,76
12.1	Tip adaptor ROB 505 W, conical with forced contacting (max. 1.4 mm)	10 pcs	22	124796	11,88
12.2	Tip adaptor ROB 505 W, conical without forced contacting (from 1.6 mm)	10 pcs	22	124798	11,88
13	Gas diffusor ROB 505 W	10 pcs	22	151695	13,91
14.1	Water coat ROB 505 W for gas nozzle 110.136		22	151656	59,39
14.2	Water coat ROB 505 W high performance version for gas nozzle 123.332		22	123328	70,33
15.1	O-ring 16 x 2, WHW 20	10 pcs	22	01340063	3,34
15.2	O ring 16 x 3 mm	10 pcs	22	00202402	3,34
16.1	O ring 18 x2	10 pcs	22	05011541	3,34

Pos.	Description	Pu	PrGrp	Part No.	Price/€
16.2	O ring 18 x 3 mm	10 pcs	22	122942	3,34
19	Keyfixture 6x6x16		22	112242	4,53
20.1	Mounting piece for hose assembly ROB-W, ROB-W-PP (for 2 part kinking protection 110.904)		22	111598	134,41
20.2	Mounting piece for hose assembly ROB-W, ROB-W-PP (for 1 part kinking protection 120.876)		22	120878	134,41
21.1	Kinking protection (2 parts) for hose assembly ROB-W, ROB-W-PP for button and plug incl. switch connection (for 111.598)		22	110904	315,72
21.2	Kinking protection (2 parts) for hose assembly ROB-W, ROB-W-PP		22	120876	243,82
22.1	Nut on torch side ROB-W, ROB-W-PP		22	111588	83,04
22.2	Ring holder ROB-W, ROB-W-PP		22	111594	55,49
22.3	Locking ring ROB-W, ROB-W-PP		22	111596	25,01
23.1	Nut on machine side ROB-W, ROB-W-PP		22	111592	38,29
23.2	Ring holder ROB-W, ROB-W-PP		22	111594	55,49
23.3	Locking ring ROB-W, ROB-W-PP		22	111596	25,01
24	Protection hose for robot and machine welding torch		22	111418	52,36
 25	Kinking protection, intake water cooled		22	02510100	18,98
 26	Sleeve nut black		22	02510300	13,07
 27	Brass neck for Euro-connection water cooled		22	02510200	38,76
 28	Liner nut for Euro connector	10 pcs	22	02511301	2,67
29	PVC hose 5 x 1.5, red per m		22	00600206	1,74
30	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
31	PVC hose 5 x 1.5, black per m		22	00600207	1,61
32	Clamping ring 9.5 GER		07	02210206	2,54
 33	Coupling nipple for water	10 pcs	22	02510400	2,41
34.1	Socket 10-pole (-) (for push pull torch)		22	02110384	59,39
34.2	Cable support for 10 pol. plug		07	02110388	28,50
35	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	55,00
 36.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
36.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	36.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	36.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	36.8	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	36.9	Liner for steel uncoated 2,5 x 4,5 0.6 -1.6 mm, 8 m long		22	02110325	18,76
	36.10	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	36.11	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	36.12	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	36.13	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	36.14	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	36.15	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
	37.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	3,88
	37.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	3,36
	38.1	Water current cable 1.2 m ROB-W, ROB-W-PP		22	121086	75,02
	38.2	Water current cable 1.5 m ROB-W, ROB-W-PP		22	110912	78,15
	38.3	Water-power-cable 2.0 m long		22	02210284	80,18
	38.4	Water-power-cable 2.5 m long		22	02210285	117,22
	38.5	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	95,45
	38.6	Water-power-cable 8.0 m long		22	02110321	190,68
	39.1	Wire feed liner 1.2 m ROB-W, ROB-W-PP		22	121088	57,77
	39.2	Wire feed liner 1.5 m ROB-W, ROB-W-PP		22	110914	58,61
	39.3	Wire feed liner 2.0 m ROB-W, ROB-W-PP		22	02210280	59,39
	39.4	Wire feed liner 2.5 m ROB-W, ROB-W-PP		22	02210274	107,84
	39.5	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	46,77
	39.6	Wire feed liner 8.0 m ROB-W, ROB-W-PP		22	133774	68,77
	40	Key for water coat		22	121094	27,35
	41	Key for 504/600/603 W		22	01370043	28,93
	50	Machine Torch Mount Ø=35 mm for MIG/MAG torches, isolated		05	152232	195,00
	51	Isolation ring for machine welding torch		22	152225	50,80

Pos.	Description	Pu	PrGrp	Part No.	Price/€
80	Test device for torch head ROB 505 W 0°, 22°, 45°		51	124754	1.136,72

5. TIG welding units

5. TIG welding units

5.1 TIG DC welding units

LiteTIG 190/210 DC

MobiTIG 304 DC

HighTIG W 350 DC

HighTIG 452/552 DC

HighTIG 452/552 DC RS

5.2 TIG AC/DC welding units

LiteTIG 190/210 AC/DC

LogiTIG 221/240/300 AC/DC

Insquare W 321/421/600 AC/DC

5.1. TIG DC welding units



5.1.1. LiteTIG 190 DC

Primary:

Supply: 1 x 230 V
 Frequency: 50 / 60 Hz
 Cont. current: 16 A
 Max. current (TIG/MMA): 30 A / 35 A

TIG operation:

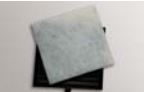
Open circuit voltage: 68 V
 Welding voltage: 10.2 - 17.6 V
 Welding current: 5 - 190 A
 Duty cycle 25 % (10 min.): 190 A (40 °C)
 Duty cycle 60 % (10 min.): 140 A (40 °C)
 Duty cycle 100 %: 115 A (40 °C)



Protection class: IP 23
 Insulation class: F
 Cooling: AF
 Modes: TIG (DC) / MMA-welding
 Parameter: current 1, current 2, reduction, final current, gas post flow
 Programmable jobs: 15 jobs
 Adjustments: continuously at rotary switch
 Current control: at the unit, at the torch, at the remote control
 Functions: 2 stroke, 4 stroke, 4 stroke with current 2
 Ignition: HF / LiftTIG
 Indication: display
 Current 2: switchable via 2nd torch button
 Spot welding time: 0.01 – 2.5 s
 Pulse times slow: 0.1 - 2.5 s
 Pulse times fast: 50 Hz - 16 kHz
 Down slope time: 0 - 25 s
 Up slope time: 0 - 2 s
 Gas pre flow time: 0 - 2 s
 Gas post flow time: 0 - 25 s
 Hotstart time: 0.01 - 2.5 s
 Hotstart current: 20 - 170 A
 Arc force: up to 170 A
 Remote control: connection via 5pol torch connection
 Power source: inverter
 Ignition: HF device
 Torch connection: Merkle TCG and 5-pole plug
 Cooling torch: gas
 Socket 50 mm²: earth lead
 Socket 50 mm²: electrode welding cable
 Mains supply cable: 3 x 2.5 mm² 5 m long with plug Schuko
 Gas hose: 2 m
 Transport: adjustable carry/shoulder strap
 Norm: EN 60974/1 S / CE
 Weight: 7.4 kg
 Dimension l x w x h: 410 x 150 x 240 mm

MMA/stick electrode operation:

Stick electrode: 1.5 - 4 mm
 Open circuit voltage: 68 V
 Welding voltage: 20.8 - 26.8 V
 Welding current: 20 - 170 A
 Duty cycle 30 % (10 min.): 170 A (40 °C)
 Duty cycle 60 % (10 min.): 135 A (40 °C)
 Duty cycle 100 %: 90 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit LiteTIG 190 DC						
	A	TIG welding unit LiteTIG 190 DC (Merkle TCG connector)		48	154082	1.820,00
	AB	TIG welding unit LiteTIG 190 DC with accessories (Merkle TCG connector)		48	SET154084	1.906,00
	ABC1	TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		48	SET154086	2.256,00
	ABC2	TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		48	SET154088	2.386,00
B Standard accessories:						
	B1	Earth lead 16 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210385	43,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
D Accessories:						
	D1a	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 59 x 47 x 21 cm		46	n01200372	295,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	695,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D5	Electrode welding cable 16 mm ² , 4 m incl. plug 50 mm ² electrode holder		46	115702	40,00
	D6	Handle set for LiteTIG 190/210		46	158342	41,00
	D7a	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm ² , torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D7b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm ² , torch plug: 5-pol		46	153802	84,00
	D8	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

5.1.2. LiteTIG 210 DC

Primary:

Supply: 1 x 230 V
Frequency: 50 / 60 Hz
Cont. current: 16 A
Max. current (TIG/MMA): 22 A / 25 A

TIG operation:

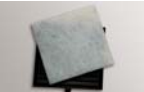
Open circuit voltage: 73 V
Welding voltage: 10.2 - 18.4 V
Welding current: 5 - 210 A
Duty cycle 20 % (10 min.): 210 A (40 °C)
Duty cycle 60 % (10 min.): 145 A (40 °C)
Duty cycle 100 %: 135 A (40 °C)



Protection class: IP 23
Insulation class: F
Cooling: AF
Modes: TIG (DC) / MMA-welding
Parameter: current 1, current 2, reduction, final current, gas post flow
Programmable jobs: 15 jobs
Adjustments: continuously at rotary switch
Current control: at the unit, at the torch, at the remote control
Functions: 2 stroke, 4 stroke, 4 stroke with current 2
Ignition: HF / LiftTIG
Indication: display
Current 2: switchable via 2nd torch button
Spot welding time: 0.01 - 2.5 s
Pulse times slow: 0.1 - 2.5 s
Pulse times fast: 50 Hz - 16 kHz
Down slope time: 0 - 25 s
Up slope time: 0 - 2 s
Gas pre flow time: 0 - 2 s
Gas post flow time: 0 - 25 s
Hotstart time: 0.01 - 2.5 s
Hotstart current: 20 - 170 A
Arc force: up to 170 A
Remote control: connection via 5pol torch connection
Power source: inverter
Ignition: HF device
Torch connection: Merkle TCG and 5-pole plug
Cooling torch: gas
Socket 50 mm²: earth lead
Socket 50 mm²: electrode welding cable
Mains supply cable: 3 x 2.5 mm² 5 m long
Gas hose: 2 m
Transport: adjustable carry/shoulder strap
Norm: EN 60974/1 S / CE
Weight: 8.0 kg
Dimension l x w x h: 410 x 150 x 240 mm

MMA/stick electrode operation:

Stick electrode: 1.5 - 4 mm
Open circuit voltage: 73 V
Welding voltage: 20.8 - 26.8 V
Welding current: 20 - 170 A
Duty cycle 20 % (10 min.): 170 A (40 °C)
Duty cycle 60 % (10 min.): 135 A (40 °C)
Duty cycle 100 %: 125 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit LiteTIG 210 DC						
	A	TIG welding unit LiteTIG 210 DC (Merkle TCG connector)		48	155876	2.350,00
	AB	TIG welding unit LiteTIG 210 DC with accessories (Merkle TCG connector)		48	SET155878	2.436,00
	ABC1	TIG welding unit LiteTIG 210 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		48	SET155880	2.786,00
	ABC2	TIG welding unit LiteTIG 210 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		48	SET155882	2.916,00
B Standard accessories:						
	B1	Earth lead 16 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210385	43,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
D Accessories:						
	D1a	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 59 x 47 x 21 cm		46	n01200372	295,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	695,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D5	Electrode welding cable 16 mm ² , 4 m incl. plug 50 mm ² electrode holder		46	115702	40,00
	D6	Handle set for LiteTIG 190/210		46	158342	41,00
	D7a	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm ² , torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D7b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm ² , torch plug: 5-pol		46	153802	84,00
	D8	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

5.1.3. MobiTIG 304 DC

Primary:

Supply: 3 x 220 - 400 V | 1 x 220 - 440 V*
Frequency: 50 / 60 Hz

Data at mains input: **3 x 400 V** | **1 x 230 V***

Cont. power (TIG/MMA): 8.3 / 9.7 kVA | 3.2 / 3.7 kVA
Cont. current (TIG/MMA): 12 / 14 A | 14 / 16 A
Max current (TIG/MMA): 16 / 21 A | 26 / 26 A

TIG operation:

Open circuit voltage: 90 V | 90 V
Welding voltage: 10 - 22 V | 10 - 17.2 V
Welding current: 5 - 300 A | 5 - 180 A
Duty cycle 35 % (10 min.): 300 A (40 °C) | 180 A (40 °C)
Duty cycle 60 % (10 min.): 265 A (40 °C) | 110 A (40 °C)
Duty cycle 100 %: 250 A (40 °C) | 90 A (40 °C)



Optional: with water cooling unit WK 210 and trolley TW 112, with drawer as an option.

Protection class: IP 23
Insulation class: H
Cooling: AF
Modes: TIG (DC) / MMA-welding
Parameter: current 1, current 2, reduction,

Adjustments: continuously at rotary switch
Current control: at the unit, at the torch, at the remote control

Functions: 2 stroke, 4 stroke, 4 stroke with current 2

Ignition: HF / LiftTIG

Indication: display

Current 2: switchable via 2nd torch button

Spot welding time: 0.01 - 2.5 s

Pulse times slow: 0.1 - 2.5 s

Pulse times fast: 50 Hz - 12 kHz

Down slope time: 0 - 25 s

Up slope time: 0 - 2 s

Gas pre flow time: 0 - 2 s

Gas post flow time: 0 - 25 s

Hotstart time: 0.01 - 5 s

Hotstart current: 20 - 280 A

Arc force: up to 280 A

Electrode type: selectable rutile, basic

LEDs: mains ON, welding ON, temperature protection, failure

Socket: connection remote control

Current source: inverter

Ignition: HF device

Torch connection: Merkle TCG and 5-pole plug

Torch cooling: gas, option: water

Socket 50 mm²: earth lead

Socket 50 mm²: electrode welding cable

Mains supply cable: 4 x 2.5 mm² 5 m long with plug 400 V/16 A

Gas hose: 2 m

Connection water cooling device: option

Handle: at topside of device

Norm: EN 60974/1 S / CE

Weight: 20 kg

Dimensions l x w x h: 495 x 210 x 450 mm

Data at mains input: **3 x 400 V** | **1 x 230 V***

MMA/stick electrode operation:

Stick electrode: 1.5 - 5.0 mm | 1.5 - 3.25 mm
Open circuit voltage: 90 V | 90 V
Welding voltage: 20.6 - 31.2 V | 20 - 26 V
Welding current: 20 - 280 A | 20 - 160 A
Duty cycle 40 % (10 min.): 280 A (40 °C) | 160 A (40 °C)
Duty cycle 60 % (10 min.): 265 A (40 °C) | 110 A (40 °C)
Duty cycle 100 %: 250 A** (40 °C) | 90 A (40 °C)

*: BiPowerPLUS: Multi voltage supply system:

Automatic switching between 1 and 3 phase in the range 220 - 400 V (option)

** : max. 210 A (40 °C) at duty cycle 100 % with 16 A fuse

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit MobiTIG 304 DC						
	A	TIG welding unit MobiTIG 304 DC (Merkle TCG connector)		02	155888	3.750,00
	AB	TIG welding unit MobiTIG 304 DC with accessories (Merkle TCG connector)		02	SET155890	3.861,00
	ABC1	TIG welding unit MobiTIG 304 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		02	SET155892	4.211,00
	ABC2	TIG welding unit MobiTIG 304 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		02	SET155894	4.341,00
With water cooler and trolley TW 112:						
		TIG welding unit MobiTIG 304 DC incl. water cooler WK 210 and trolley TW 112		02	SET155896	5.250,00
		TIG welding unit MobiTIG 304 DC with accessories incl. water cooler WK 210 and trolley TW 112		02	SET155898	5.361,00
		TIG welding unit MobiTIG 304 DC with accessories and torch TH 452 W, 4 m incl. water cooler WK 210 and trolley TW 112		02	SET155900	5.856,00
		TIG welding unit MobiTIG 304 DC with accessories and torch TH 452 W, 8 m incl. water cooler WK 210 and trolley TW 112		02	SET155902	5.916,00
	Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
B Standard accessories:						
	B1	Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210401	68,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
	C4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	C5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
	C6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00

D Accessories:

	D1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	214,00
	D2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	52,00
	D3	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	D4a	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D4b	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	470,00
	D6.1	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D6.2	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D7	Euro connector for portable TIG welding units		46	110430	69,00
	D8	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D9	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm², torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D10	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm ² , torch plug: 5-pol		46	153802	84,00
 Automation	D11	Connection for automated welding for MobiTIG 284/304 DC, MobiMIG 321/322 - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	123166	480,00
	D11.1	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
	D12	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Accessories for using water cooler:

	E1	Water cooling unit model WK 210		46	143136	980,00
	E2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321		46	124858	185,00
	E3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00

5.1.4. HighTIG W 352 DC

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

TIG DC-operation:

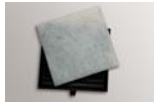
Open circuit voltage: 57 V
Welding voltage: 10 - 24 V
Welding current: 5 - 350 A
Duty cycle 50 % (10 min.): 350 A (40 °C)
Duty cycle 100 %: 280 A (40 °C)
Prim. cont. power: 13.1 kVA
Prim. cont. current: 19 A
Prim. max. current: 23 A



Protection class: IP 23
Insulation class: H
Cooling: AF
Main switch: 3-phase
Welding modes: TIG DC, MMA
Digital displays: LED display with pre-indication and hold function for current, voltage
Timer functions: OFF, quick and slow pulsation, spot welding time
Ignition: OFF, high frequency, LiftTIG
Energy control: at the machine, at the remote control, at the torch
Operation modes: 2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming
Job-Operation: 2048 jobs programmable
Program storage: 512 programs
Gas pre-flow time: 0 - 3 s
Gas post-flow time: 0 - 25 s
Up slope time: 0 - 2 s
Down slope time: 0 - 20 s
Spot welding time: 0.1 - 25 s
Pulsation slow: 10 ms - 2.5 s
Pulsation fast: 50 Hz-12 kHz
Hotstart time: 0 - 1.5 s
Hotstart current: 10 - 200 %
Arc force: 100 - 250 %
LEDs: mains ON, temperature protection, failure, display-hold
Power source: inverter
Norm: EN 60974-1 "S" / CE
Torch connection: Euro connector with 5-pol. plug
Torch cooling: integrated water cooler
Socket 95 mm²: earth lead
Socket 50 mm²: electrode cable
Mains supply cable: 4 x 4 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose: 2 m
Gas bottle holder: 10 - 20 - 50 l cylinders
Lifting eyes: 4 pieces (option)
Weight: 115 kg
Dimensions l x w x h: 1100 x 490 x 895 mm incl. gas bottle holder

MMA/stick electrode operation

Stick electrodes: 1.5 - 6 mm
Open circuit voltage: 57 V
Welding voltage: 20 - 34 V
Welding current: 20 - 350 A
Duty cycle 50 % (10 min.): 350 A (40 °C)
Duty cycle 100 %: 280 A (40 °C)
Prim. cont. power: 15.2 kVA
Prim. cont. current: 22 A
Prim. max. current: 27 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit HighTIG W 352 DC						
	A	TIG welding unit HighTIG W 352 DC		02	138882	8.165,00
	AB	TIG welding unit HighTIG W 352 DC with accessories		02	SET138884	8.328,00
	ABC1	TIG welding unit HighTIG W 352 DC with accessories and torch TH 452 W, 4 m		02	SET138885	8.853,00
	ABC2	TIG welding unit HighTIG W 352 DC with accessories and torch TH 452 W, 8 m		02	SET138886	8.913,00
B Standard accessories:						
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/rubber hose assembly		10	145086	525,00
	C2	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/rubber hose assembly		10	145088	585,00
D Accessories:						
	D1	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/rubber hose assembly		10	145090	685,00
	D2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D5	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	D6	Cover with lock, transparent, for power source HighPULSE, SpeedMIG and HighTIG version KW and DW		46	138238	190,00
	D7	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	D8	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	4,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D9	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	138,00

E Automation accessories:



E1	Connection for automated welding for hand welding unit HighPULSE, SpeedMIG, HighTIG - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	138296	390,00
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E1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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5.1.5. HighTIG 452 DC

Primary:

Power supply: 3 x 400 V
 Frequency: 50 / 60 Hz

TIG DC-Operation:

Open circuit voltage: 72 V
 Welding voltage: 10 - 28 V
 Welding current: 5 - 450 A
 Duty cycle 50 % (10 min.): 450 A (40 °C)
 Duty cycle 100 %: 350 A (40 °C)
 Prim. cont. power: 13.2 kVA
 Prim. cont. current: 19 A
 Prim. max. current: 29 A



Optional: with water cooling unit
 WK 350 and trolley TW 114

Protection class: IP 23
 Insulation class: H
 Cooling: AF
 Main switch: 3-phase
 Welding modes: TIG DC, MMA/stick electrode
 Digital displays: LED display with pre-indication
 and hold function for current, voltage
 Timer functions: OFF, quick and slow pulsation,
 spot welding time
 Ignition: high frequency, LiftTIG
 Energy control: at the machine,
 at the remote control,
 at the torch

Operation modes: 2-stroke, 4-stroke, 4-stroke
 with 2 currents, gas check

Job-Operation: 999 jobs programmable

Program storage: 512 storage places

Gas pre-flow time: 0 - 3 s

Gas post-flow time: 1 - 60 s

Up slope time: 0 - 2 s

Down slope time: 0 - 20 s

Spot welding time: 0.01 - 25 s

Pulsation slow: 10 ms - 2.5 s

Pulsation fast: 50 Hz - 12 kHz

Hotstart time: 0.1 - 2.0 s

Hotstart current: 5 - 450 A

Arc force: 0 - 100 %

LEDs: mains ON, temperature protection
 failure, display-hold

Power source: inverter

Norm: EN 60974-1 "S" / CE

Torch connection: Euro connector with 5-pole plug

Torch cooling: separate water cooling system
 (option)

Socket water cooling unit: 6-pol.

Socket 95 mm²: earth lead

Socket 50 mm²: electrode welding cable

Mains supply cable: 4 x 6 mm², 5 m long with plug 3 x 400 V, 32 A

Gas hose: 2 m

Weight: 63 kg

Dimensions l x w x h: 740 x 350 x 690 mm

MMA/stick electrode operation:

Stick electrodes: 1.5 - 6 mm
 Open circuit voltage: 72 V
 Welding voltage: 20 - 38 V
 Welding current: 20 - 450 A
 Duty cycle 40 % (10 min.): 450 A (40 °C)
 Duty cycle 100 %: 310 A (40 °C)
 Prim. cont. power: 15.9 kVA
 Prim. cont. current: 23 A
 Prim. max. current: 39 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit HighTIG 452 DC						
	A	TIG welding unit HighTIG 452 DC with TIG Euro connector		02	SET144040	9.922,00
	ABC	TIG welding unit HighTIG 452 DC with water cooling unit WK 350 and trolley TW 114		02	SET144042	12.027,00
	ABCDE	TIG welding unit HighTIG 452 DC with water cooling unit WK 350 and trolley TW 114 incl. accessories and torch TH 452 W, 8 m		02	SET144046	12.810,00
B Water cooling unit:						
		Water cooling unit model WK 350		46	144008	1.680,00
C Trolley:						
		Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	425,00
D Accessories:						
		Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
		Regulator argon/CO2, single stage		46	01200300	75,00
E Welding torches:						
		TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/rubber hose assembly		10	145088	585,00
F Accessories:						
	F1	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/rubber hose assembly		10	145090	685,00
	F2	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		10	104410	745,00
	F3	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	845,00
	F4a	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	F4b	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	F5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F6	Key switch for locking the system in job mode for HighPULSE and HighTIG series		46	148246	129,00
	F7	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	F8	Filter 205 x 314 mm for ighTIG / HighPULSE x52 RS		46	156804	4,60
	F9	Cover for operation panel RS series 352/452/552		46	145206	170,00

5.1.6. HighTIG 552 DC

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

TIG DC operation:

Open circuit voltage: 72 V
Welding voltage: 10 - 32 V
Welding current: 5 - 550 A
Duty cycle 50 % (10 min.): 550 A (40 °C)
Duty cycle 100 %: 420 A (40 °C)
Prim. cont. power: 18 kVA
Prim. cont. current: 26 A
Prim. max. current: 40 A



Optional: with water cooling unit
WK 350 and trolley TW 114

Protection class: IP 23
Insulation class: H
Cooling: AF
Main switch: 3-phase
Welding modes: TIG DC, MMA/stick electrode
Digital displays: LED display with pre-indication
and hold function for current, voltage
Timer functions: OFF, quick and slow pulsation
spot welding time
Ignition: high frequency, liftTIG
Energy control: at the machine,
at the remote control,
at the torch
Operation modes: 2-stroke, 4-stroke, 4-stroke
with 2 currents, gas check
Job-Operation: 999 jobs programmable
Program memory: 512 storage places
Gas pre-flow time: 0 - 3 s
Gas post-flow time: 1 - 60 s
Up slope time: 0 - 2 s
Down slope time: 0 - 20 s
Spot welding time: 0.01 - 25 s
Pulsation slow: 10 ms - 2.5 s
Pulsation fast: 50 Hz - 12 kHz
Hotstart time: 0.1 - 2.0 s
Hotstart current: 5 - 550 A
Arc force: 0 - 100 %
LEDs: mains ON, temperature protection
failure, hold-function
Power source: inverter
Norm: EN 60974-1 "S" / CE
Torch connection: Euro connector with 5-pole plug
Torch cooling: separate water cooling system
(option)
Socket water cooling unit: 6-pol.
Socket 95 mm²: earth lead
Socket 50 mm²: electrode welding cable
Mains supply cable: 4 x 6 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose: 2 m
Weight: 65 kg
Dimensions l x w x h: 740 x 350 x 690 mm

MMA/stick electrode operation:

Stick electrodes: 1.5 - 6 mm
Open circuit voltage: 72 V
Welding voltage: 20 - 42 V
Welding current: 20 - 550 A
Duty cycle 40 % (10 min.): 550 A (40 °C)
Duty cycle 100 %: 410 A (40 °C)
Prim. cont. power: 24.9 kVA
Prim. cont. current: 36 A
Prim. max. current: 52 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC welding unit HighTIG 552 DC						
	A	TIG welding unit HighTIG 552 DC with TIG Euro connection		02	SET144050	10.213,00
	ABC	TIG welding unit HighTIG 552 DC with water cooling unit WK 350 and trolley TW 114		02	SET144052	12.318,00
	ABCDE	TIG welding unit HighTIG 552 DC with water cooling unit WK 350 and trolley TW 114 with accessories and torch TH 600 W, 8 m		02	SET144054	13.320,00
B Water cooling unit:						
		Water cooling unit model WK 350		46	144008	1.680,00
C Trolley:						
		Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	425,00
D Accessories:						
		Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
		Regulator argon/CO2, single stage		46	01200300	75,00
E Welding torches:						
		TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		10	104410	745,00
F Accessories:						
	F1	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	845,00
	F2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	F3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	F4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	F5	Key switch for locking the system in job mode for HighPULSE and HighTIG series		46	148246	129,00
	F6	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F7	Filter 205 x 314 mm for ighTIG / HighPULSE x52 RS		46	156804	4,60
	F8	Cover for operation panel RS series 352/452/552		46	145206	170,00

5.1.7. HighTIG 452/552 DC RS

Primary:

Power supply: 3 x 400 V
Frequency: 50 / 60 Hz

TIG DC-operation:

Model:	452 DC	552 DC
Open circuit voltage:	72 V	72 V
Welding voltage:	10 - 28 V	10 - 32 V
Welding current:	5 - 450 A	5 - 550 A
Duty cycle 40 % (10 min.):	450 A	550 A
Duty cycle 60 % (10 min.):		
Duty cycle 100 %:	350 A	420 A
Prim. cont. power:	13.2 kVA	18 kVA
Prim. cont. current:	19 A	26 A
Prim. max. current:	29 A	40 A



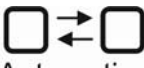
Optional: with water cooling unit
WK 350 and trolley TW 114

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC
Digital displays:	LED display with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	high frequency
Energy control:	at the machine
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	0 - 100 %
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection, failure, hold function
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Sockets 95 mm ² :	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm ² , 5 m long (HT 452/552 DC) with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	63 kg (HT 452 DC) 65 kg (HT 552 DC)
Dimensions l x w x h:	740 x 350 x 690 mm (HT 452/552 DC)

Roboter interface: bus interface
(Profibus, DeviceNet,
CANopen, interbus,
analogue interface, etc.)

Communication: RS 232,
ethernet 10 Mbit with
RJ45 connector (option)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG DC robot and automation welding unit HighTIG 452/552 DC RS						
	A1	TIG Welding Unit Model HighTIG 452 DC and HighTIG 452 DC RS with TIG Euro connector (without interface, front panel, wiring)		02	144014	7.527,00
	A2	TIG Welding Unit Model HighTIG 552 DC and HighTIG 552 DC RS with TIG Euro connector (without interface, front panel, wiring)		02	144016	7.818,00
B Operation panel/front (please select one):						
	B1	Front panel for series HighTIG RS with display and controls		46	138894	1.800,00
	B2	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	980,00
B3 External operation panel:						
	B3.1	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	980,00
	B3.2	External operation panel in housing for manual process control incl. displays for series HighTIG with 5 m cable (only with 139.042 and job panel)		46	139438	1.735,00
	B3.3	External operation panel mounted in ext. controller incl. displays for series HighTIG with 5 m cable (only with 139.042)		46	139436	1.735,00
	B3.4	Kit for connection of MRC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	190,00
	B3.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	55,00
C Interface connection (please select one):						
	C1	Bus interface RS series "Universal" ProfiNet, EtherCAT, EtherNet/IP, Modbus TCP u. RTU incl. serial-to-serial converter and wiring and 10-pol socket emergency stop (please specify the required bus version)		17	167058	3.245,00
	C2	Interface RS series "CANopen" incl. wiring for welding unit and 10-pol socket emergency stop		17	117428	3.245,00
	C3	Bus interface RS series RS 485 incl. wiring for welding unit and 10-pol socket emergency stop		17	139818	2.425,00
	C1-3a	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00
	C4	Digital interface for job operation (6 bit - 63 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	1.230,00
	C4a	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	167,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
 Analogue Interface	C5	Analogue interface for RS series 8 IO, 24pol.		17	164184	3.095,00
	C5a	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	167,00
 Automation	C6	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	700,00
	C6a	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	115,00
 Automation	C7	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage OUTPUT 0 - 10 V - socket 10 pol.		46	158270	1.450,00
	C8	Connection for automated welding HP, HPt, HT - emerg. STOP, welding ON, arc OK - 1 x control voltage INPUT 0 - 10 V - socket 10 pol.		46	158271	1.450,00
	C7-8a	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	133,00
	C9	Internal wiring for HighTIG 352/452/552 DC for hand welding application without interface		46	144058	595,00
D Trolley:						
	D1	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	425,00
E Water cooling:						
	E1	Water cooling unit model WK 350		46	144008	1.680,00
	E2	Water flow control device mounted in the water cooler		46	02610156	340,00
	E3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
F Option cold wire:						
	F1	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		05	138921	960,00
	F2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		05	104634	2.430,00
	F3	Cold Wire Feed KDZF with Feed Tube for TM 450 W (Mechanic with Motor) for Push-Pull use		05	141614	2.810,00

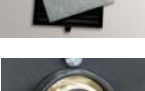
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	99,00

G External HF Box:

Required in manual mode when more than 8 m torch and 8 m extension are used, in automated mode when more than 8 m torch assembly are used

G1	Extra charge for external HF box for HighTIG RS incl. HF ignition and torch connection	46	144068	2.990,00
G2a	Connection cable 5 m for HighTIG RS to external HF box	46	138922	1.100,00
G2b	Connection cable 10 m for HighTIG RS to external HF box	46	138924	1.670,00

H Accessories:

	H1	Regulator argon/CO2, single stage	46	01200300	75,00
	H2	Earth lead 50 mm², 4 m long with plug and earth clamp	46	02210402	88,00
	H3	Earth lead 95 mm², 4 m long with plug and earth clamp	46	02210403	182,00
	H4	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm	46	139816	195,00
	H5	Foot remote with 5 m cable and 10 pin plug	46	01903000	710,00
	H6	Foot remote with 8 m cable and 10 pin plug	46	01902999	722,00
	H7	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)	46	123791	470,00
	H8	Filter 205 x 314 mm for ighTIG / HighPULSE x52 RS	46	156804	4,60
	H9	Euro connector for portable TIG welding units	46	110430	69,00
	H10	Touch Sensor for HighPULSE, HighTIG for welding wire or gas nozzle (HighPULSE) or TIG electrode (HighTIG) (depending on welding torch)	46	106894	480,16
	H11	Coolant ME-KM 22 eco, 10 l for welding units	07	169376	68,00

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5.2. TIG AC/DC welding units



5.2.1. LiteTIG 190 AC/DC

Primary:

Supply: 1 x 230 V
 Frequency: 50 / 60 Hz
 Cont. current: 16 A
 Max. current (TIG/MMA): 30 A / 35 A

TIG operation:

Open circuit voltage: 68 V
 Welding voltage: 10 - 17.2 V
 Welding current (DC): 5 - 190 A
 Welding current (AC): 10 - 180 A
 Duty cycle 20 % (10 min.): 180 A (40 °C)
 Duty cycle 60 % (10 min.): 140 A (40 °C)
 Duty cycle 100 % 115 A (40 °C)



Protection class: IP 23
 Insulation class: F
 Cooling: AF
 Modes: TIG (AC/DC), MMA-welding
 Parameter: current 1, current 2, reduction, final current, gas post flow
 Programmable jobs: 15 jobs
 Adjustments: continuously at rotary switch
 Current control: at the unit, at the torch, at the remote control
 Functions: 2 stroke, 4 stroke, 4 stroke with current 2
 Ignition: HF / LiftTIG
 Indication: display
 Current 2: switchable via 2nd torch button
 Spot welding time: 0.01 - 2.5 s
 Pulse times slow: 0.1 - 2.5 s
 Pulse times fast: 50 Hz - 16 kHz
 Down slope time: 0 - 25 s
 Up slope time: 0 - 2 s
 Gas pre flow time: 0 - 2 s
 Gas post flow time: 0 - 25 s
 Hotstart time: 0.1 - 2 s
 Hotstart current: 5 - 170 A
 Arc force: up to 170 A
 AC frequency: 60 - 200 Hz
 Balance: 15 - 70 %
 Power socket: via remote control connection
 Power source: inverter
 Ignition: HF device
 Torch connection: Merkle TCG and 5-pole plug
 Torch cooling: gas
 Socket 50 mm²: earth lead
 Socket 50 mm²: electrode welding cable
 Mains supply cable: 3 x 2.5 mm² 5 m long with plug Schuko
 Gas hose: 2 m
 Transport: adjustable carry/shoulder strap
 Norm: EN 60974/1 S / CE
 Weight: 8.0 kg
 Dimensions l x w x h: 410 x 150 x 240 mm

MMA/stick electrode operation:

Stick electrode: 1.5 - 4 mm
 Open circuit voltage: 68 V
 Welding voltage: 20 - 26.8 V
 Welding current: 20 - 170 A
 Duty cycle 30 % (10 min.): 170 A (40 °C)
 Duty cycle 60 % (10 min.): 135 A (40 °C)
 Duty cycle 100 % 90 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit LiteTIG 190 AC/DC						
	A	TIG welding unit LiteTIG 190 AC/DC (Merkle TCG connector)		48	155842	2.825,00
	AB	TIG welding unit LiteTIG 190 AC/DC with accessories (Merkle TCG connector)		48	SET155844	2.911,00
	ABC1	TIG welding unit LiteTIG 190 AC/DC with access. and torch TH 202 G, 4 m (Merkle TCG connector)		48	SET155846	3.261,00
	ABC2	TIG welding unit LiteTIG 190 AC/DC with access. and torch TH 202 G, 8 m (Merkle TCG connector)		48	SET155848	3.391,00
B Standard accessories:						
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	43,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
D Accessories:						
	D1a	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 59 x 47 x 21 cm		46	n01200372	295,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	695,00
	D5	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	40,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D6	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D7	Handle set for LiteTIG 190/210		46	158342	41,00
	D8a	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm², torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D8b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	84,00
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

5.2.2. LiteTIG 210 AC/DC

Primary:

Supply: 1 x 230 V
Frequency: 50 / 60 Hz
Cont. current: 16 A
Max. current (TIG/MMA): 22 A / 25 A

TIG operation:

Open circuit voltage: 73 V
Welding voltage: 10.2 - 18.4 V
Welding current (DC): 5 - 210 A
Welding current (AC): 10 - 200 A
Duty cycle 20 % (10 min.): 210 A (40 °C)
Duty cycle 60 % (10 min.): 140 A (40 °C)
Duty cycle 100 % 130 A (40 °C)



Protection class: IP 23
Insulation class: F
Cooling: AF
Modes: TIG (AC/DC), MMA-welding
Parameter: current 1, current 2, reduction, final current, gas post flow
Programmable jobs: 15 jobs
Adjustments: continuously at rotary switch
Current control: at the unit, at the torch, at the remote control
Functions: 2 stroke, 4 stroke, 4 stroke with current 2
Ignition: HF / LiftTIG
Indication: display
Current 2: switchable via 2nd torch button
Spot welding time: 0.01 - 2.5 s
Pulse times slow: 0.1 - 2.5 s
Pulse times fast: 50 Hz - 16 kHz
Down slope time: 0 - 25 s
Up slope time: 0 - 2 s
Gas pre flow time: 0 - 2 s
Gas post flow time: 0 - 25 s
Hotstart time: 0.1 - 2 s
Hotstart current: 5 - 170 A
Arc force: up to 170 A
AC frequency: 50 - 200 Hz
Balance: 10 - 70 %
Power socket: via remote control connection
Power source: inverter
Ignition: HF device
Torch connection: Merkle TCG and 5-pole plug
Torch cooling: gas
Socket 50 mm²: earth lead
Socket 50 mm²: electrode welding cable
Mains supply cable: 3 x 2.5 mm² 5 m long with plug Schuko
Gas hose: 2 m
Transport: adjustable carry/shoulder strap
Norm: EN 60974/1 S / CE
Weight: 8.9 kg
Dimensions l x w x h: 410 x 150 x 240 mm

MMA/stick electrode operation:

Stick electrode: 1.5 - 4 mm
Open circuit voltage: 73 V
Welding voltage: 20 - 26.8 V
Welding current: 20 - 170 A
Duty cycle 30 % (10 min.): 170 A (40 °C)
Duty cycle 60 % (10 min.): 130 A (40 °C)
Duty cycle 100 % 120 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit LiteTIG 210 AC/DC						
	A	TIG welding unit LiteTIG 210 AC/DC (Merkle TCG connector)		48	155868	3.525,00
	AB	TIG welding unit LiteTIG 210 AC/DC with accessories (Merkle TCG connector)		48	SET155870	3.611,00
	ABC1	TIG welding unit LiteTIG 210 AC/DC with access. and torch TH 202 G, 4 m (Merkle TCG connector)		48	SET155872	3.961,00
	ABC2	TIG welding unit LiteTIG 210 AC/DC with access. and torch TH 202 G, 8 m (Merkle TCG connector)		48	SET155874	4.091,00
B Standard accessories:						
	B1	Earth lead 16 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210385	43,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
D Accessories:						
	D1a	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 59 x 47 x 21 cm		46	n01200372	295,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	695,00
	D5	Electrode welding cable 16 mm ² , 4 m incl. plug 50 mm ² electrode holder		46	115702	40,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D6	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D7	Handle set for LiteTIG 190/210		46	158342	41,00
	D8a	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm², torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D8b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	84,00
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

5.2.3. LogiTIG 221 AC/DC

Primary:

Supply: 1 x 230 V
Frequency: 50 / 60 Hz

TIG operation:

Open circuit voltage: 80 V
Welding voltage: 10 - 18.8 V
Welding current (DC): 3 - 220 A
Welding current (AC): 5 - 220 A
Duty cycle 25 % (10 min.): 220 A* (40 °C)
Duty cycle 30 % (10 min.): 200 A* (40 °C)
Duty cycle 40 % (10 min.): 220 A** (20 °C)
Duty cycle 45 % (10 min.): 200 A** (20 °C)
Duty cycle 60 % (10 min.): 190 A** (20 °C) 150 A (40 °C)
Duty cycle 100 %: 170 A (20 °C) 130 A (40 °C)
Prim. cont. power: 2.8 kVA
Prim. cont. current: 12 A
Prim. max. current: 24 A



Optional: with water cooling unit WK 210 and trolley TW 112, with drawer as an option.

Protection class:	IP 23	Power source:	inverter
Insulation class:	H	Ignition:	HF ignition generator
Cooling:	AF	Torch connection:	Merkle TCG-connector and 5-pole socket
Operation modes:	TIG (DC and AC), MMA/stick electrode welding	Torch cooling:	gas
Button:	current 1, current 2, down slope, final current, gas post flow time		option: water
Jobs:	17 jobs	Socket 50 mm²:	earth lead
Open circuit voltage:	< 24 V (option)	Socket 50 mm²:	electrode welding cable
Setting:	continuous at rotary switch	Mains supply cable:	3 x 2.5 mm² 5 m long with plug schuko
Energy control:	at the unit, at the torch, at the hand remote control, foot pedal	Gas hose:	2 m
Functions:	2 stroke, 4 stroke, 4 stroke with 2 currents	Connection for water cooling unit:	option
Ignition:	HF/LiftTIG	Handle:	on top of the machine
Indication:	display	Norm:	EN 60974/1 S / CE
Current 2:	switchable via 2 nd torch button	Weight:	17 kg
Spot welding time:	0.01 - 2.5 s	Dimensions l x w x h:	495 x 210 x 450 mm
Pulsation slow:	0.1 - 2.5 s		
Pulsation fast:	50 Hz - 12 kHz		
Pulse shape:	"hard"/"soft"		
Down slope time:	0 - 25 s		
Up slope time:	0 - 2 s		
Gas pre-flow time:	0 - 2 s		
Gas post-flow time:	0 - 25 s		
Pos. igniton impuls:	0 - 200 ms		
Balance:	± 91%		
AC frequency:	50 - 200 Hz		
AC curve shape:	square, soft, AC special, sinus (50 Hz)		
Hotstart time:	0.1 - 2 s		
Hotstart current:	5 - 220 A		
Arc force:	up to 220 A		
LED green:	mains ON		
LED green:	welding ON		
LED yellow:	temperature protection		
LED red:	failure		
Socket:	remote control		

MMA/stick electrode operation:

Stick electrodes: 1.5 - 3.25 mm
Open circuit voltage: 80 V (with VRD < 24 V)
Welding voltage: 20 - 27 V
Welding current: 20 - 180 A
Duty cycle 30 % (10 min.): 180 A (40 °C)
Duty cycle 60 % (10 min.): 170 A** (20 °C) 130 A (40 °C)
Duty cycle 100 %: 140 A** (20 °C) 110 A (40 °C)
Prim. cont. power: 3.2 kVA
Prim. cont. current: 14 A
Prim. max. current: 26 A

*: slow-blow fuse 16 A

** : slow blow fuse min. 20 A (and CEE plug)

Pos.	Description	Pu	PrGrp	Part No.	Price/€
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A TIG AC/DC welding unit LogiTIG 221 AC/DC



A	TIG welding unit LogiTIG 221 AC/DC (Merkle TCG connector)		49	143074	5.380,00
AB	TIG welding unit LogiTIG 221 AC/DC with accessories (Merkle TCG connector)		49	SET143096	5.491,00
ABC1	TIG welding unit LogiTIG 221 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		49	SET143098	5.841,00
ABC2	TIG welding unit LogiTIG 221 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		49	SET143100	5.971,00

With water cooler and trolley TW 112:



	TIG welding unit LogiTIG 221 AC/DC incl. water cooler WK 210 and trolley TW 112		49	SET143102	6.880,00
	TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112		49	SET143104	6.991,00
	TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112 and torch TH 452 W, 4 m		49	SET143106	7.486,00
	TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112 and torch TH 452 W, 8 m		49	SET143108	7.546,00



Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
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B Standard accessories:



B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
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B2	Regulator argon/CO2 standard version		46	107018	43,00
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C Welding torches:



C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
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C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
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C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
D	Accessories:					
	D1a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D1b	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D2	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	D3	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D4	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D6	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D7	Euro connector for portable TIG welding units		46	110430	69,00
	D8a	Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm², torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D8b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	84,00
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00
E	Accessories for using water cooler:					
	E1	Water cooling unit model WK 210		46	143136	980,00
	E2	Socket for water cooling unit 6-pol. for LogiTIG 220/221 AC/DC		46	125928	185,00
	E3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00

F Robot and automation accessories:



F1	Connection for automated welding for LogiTIG 220/221 AC/DC - emerg. STOP, welding ON, arc OK - socket 6 pol. - increased HF ignition	46	125930	390,00
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F1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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F2	Connection for automated welding - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.	46	01301123	1.450,00
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F2.1	Connection cable 10-pol. 5m welding unit - automated system	46	01903556	133,00
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5.2.4. Water cooling unit WK 210

Power supply:	1 x 230 V
Frequency:	50 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr.connection:	cable with 6-pole plug
water connection:	2 quick couplings
Weight:	15 kg
Dimensions l x w x h:	590 x 210 x 210 mm



	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Water cooling unit:						
	A	Water cooling unit model WK 210		46	143136	980,00
B Accessories:						
	B1	Socket for water cooling unit 6-pol. for LogiTIG 220/221 AC/DC		46	125928	185,00
	B2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321		46	124858	185,00
	B3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

5.2.5. LogiTIG 240 AC/DC

Primary:

Supply: 1 x 230 V / 3 x 400 V*
Frequency: 50 / 60 Hz

TIG operation:

Open circuit voltage: 95 V
Welding voltage: 10 - 17.2 V / 19.6 V*
Welding current (DC): 3 - 180 A / 240 A*
Welding current (AC): 5 - 180 A / 240 A*
Duty cycle 35 % (10 min.): 240 A* (20 °C)
Duty cycle 60 % (10 min.): 160 A (40 °C)
Duty cycle 100 %: 130 A (40 °C)
Prim. cont. power: 3.7 kVA
Prim. cont. current: 16 A
Prim. max. current: 23 A / 32 A*



Optional: with water cooling unit WK 230 and trolley TW 112, with drawer as an option.



Protection class: IP 23
Insulation class: H
Cooling: AF
Operation modes: TIG (DC and AC), MMA/stick electrode welding
Button: current 1, current 2, down slope, final current, gas post flow time
Jobs: 17 jobs
Setting: continuous at rotary switch
Energy control: at the unit, at the torch, at the hand remote control, foot pedal
Functions: 2 stroke, 4 stroke, 4 stroke with 2 currents
Ignition: HF/LiftTIG
Indication: display
Current 2: switchable via 2nd torch button
Spot welding time: 0.01 - 2.5 s
Pulsation slow: 0.1 - 2.5 s
Pulsation fast: 50 Hz - 12 kHz
Pulse shape: "hard" / "soft"
Down slope time: 0 - 25 s
Up slope time: 0 - 2 s
Gas pre-flow time: 0 - 2 s
Gas post-flow time: 0 - 25 s
Pos. igniton impuls: 0 - 200 ms
Balance: ± 91 %
AC frequency: 50 - 200 Hz
AC curve shape: square, soft, sinus
Hotstart time: 0.1 - 2 s
Hotstart current: 5 - 160 A / 200 A*
Arc force: up to 160 A / 200 A*
LED: mains ON
LED: welding ON
LED: temperature protection
LED: failure
Socket: remote control
Power source: inverter
Ignition: HF ignition generator
Torch connection: Merkle TCG-connector and 5-pole socket

Torch cooling: gas
option: water
Socket 50 mm²: earth lead
electrode welding cable
Socket 50 mm²:
Mains supply cable: 5 x 4.0 mm² 5 m long with plug 400 V/32 A
Gas hose: 2 m
Connection for water cooling unit: option
Handle: on top of the machine
Norm: EN 60974/1 S / CE
Weight: 24.5 kg
Dimensions l x w x h: 535 x 230 x 465 mm

MMA/stick electrode operation:

Stick electrodes: 1.5 - 4 mm
Open circuit voltage: 100 V
Welding voltage: 20 - 26.4 V / 28 V*
Welding current: 5 - 160 A / 200 A*
Duty cycle 40 % (10 min.): 200 A* (20 °C)
Duty cycle 60 % (10 min.): 150 A (40 °C)
Duty cycle 100 %: 120 A (40 °C)
Prim. cont. power: 4.1 kVA
Prim. cont. current: 16 A / 18 A*
Prim. max. current: 26 A / 34 A*

* BiPower-Technology:

Automatic switching to "High Current" mode at supply voltage 3phase 400 V/32 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit LogiTIG 240 AC/DC						
	A	TIG welding unit LogiTIG 240 AC/DC (Merkle TCG connector)		49	113226	5.720,00
	AB	TIG welding unit LogiTIG 240 AC/DC with accessories (Merkle TCG connector)		49	SET113228	5.831,00
	ABC1	TIG welding unit LogiTIG 240 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		49	SET113230	6.181,00
	ABC2	TIG welding unit LogiTIG 240 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		49	SET113232	6.311,00
With water cooler and trolley TW 112:						
		TIG welding unit LogiTIG 240 AC/DC incl. water cooler WK 230 and trolley TW 112		49	SET113302	7.220,00
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112		49	SET113304	7.331,00
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112 and torch TH 452 W, 4 m		49	SET113290	7.826,00
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112 and torch TH 452 W, 8 m		49	SET113292	7.886,00
	Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
B Standard accessories:						
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
	B2	Regulator argon/CO2 standard version		46	107018	43,00
C Welding torches:						
	C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
D Accessories:					
	D1 Coupling 230/400 V 32 Socket 400 V/32 A to plug 230V/16 A		46	110612	60,16
	D2a Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D2b Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D3 Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	D4 Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D5 Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D6 Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D7 Filter frame incl. filter for TIG 300 DC, LT 240 AC/DC, C 82		46	112548	135,00
	D8	10 pcs	46	112550	4,10
	D9 Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D10 Euro connector for portable TIG welding units		46	110430	69,00
	D11a Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm², torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D11b Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	84,00
	D12 Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00
E Accessories for using water cooler:					
	E1 Water cooling unit model WK 230		46	02610142	980,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E2	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	185,00
	E3	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00

F Robot and automation accessories:



F1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	02010907	320,00
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F1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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F2	Connection for automated welding - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.	46	01301123	1.450,00
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F2.1	Connection cable 10-pol. 5m welding unit - automated system	46	01903556	133,00
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5.2.6. Water cooling unit WK 230

Power supply:	1 x 400 V / 230 V
Frequency:	50 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cabl with 6-pole plug
Water connection:	2 quick couplings
Weight:	18 kg
Dimensions l x w x h:	610 x 230 x 215 mm



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Water cooling unit:					
	A Water cooling unit model WK 230		46	02610142	980,00
B Accessories:					
	B1 Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	185,00
	B2 Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

5.2.7. LogiTIG 300 AC/DC

Primary:

Supply: 3 x 400 V
Frequency: 50 / 60 Hz

TIG operation:

Open circuit voltage: 70 V
Welding voltage: 10 - 22 V
Welding current: 5 - 300 A
Duty cycle 50 % (10 min.): 300 A (40 °C)
Duty cycle 60 % (10 min.): 280 A (40 °C)
Duty cycle 100 %: 250 A (40 °C)
Prim. cont. power: 10.4 kVA
Prim. cont. current: 15 A
Prim. max. current: 19 A



Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.

Protection class: IP 23
Insulation class: H
Cooling: AF
Operation modes: TIG (DC und AC), MMA/stick electrode welding
Button: current 1, current 2, down slope, final current, gas post flow time
Jobs: 17 jobs
Setting: continuous at rotary switch
Energy control: at the unit, at the torch, at the hand remote control, foot pedal
Functions: 2 stroke, 4 stroke, 4 stroke with 2 currents
Ignition: HF/LiftTIG
Indication: display
Current 2: switchable via 2nd torch button
Spot welding time: 0.01 - 2.5 s
Pulsation slow: 0.1 - 2.5 s
Pulsation fast: 50 Hz - 12 kHz
Pulse shape: "hard" / "soft"
Down slope time: 0 - 25 s
Up slope time: 0 - 2 s
Gas pre-flow time: 0 - 2 s
Gas post-flow time: 0 - 25 s
Pos. igniton impuls: 0 - 200 ms
Balance: ± 91 %
AC frequency: 50 - 200 Hz
AC curve shape: square, soft, sinus
Hotstart time: 0.1 - 2 s
Hotstart current: 5 - 300 A
Arc force: up to 300 A
LED green: mains ON
LED green: welding ON
LED yellow: temperature protection
LED red: failure
Socket: remote control
Cover: transparent, to protect the control panel
Power source: inverter
Ignition: HF ignition generator
Torch connection: Merkle TCG-connector and 5-pole socket

Torch cooling: gas
option: water
Socket 50 mm²: earth lead
Socket 50 mm²: electrode welding cable
Mains supply cable: 5 x 4.0 mm² 5 m long with plug 400 V/32 A
Gas hose: 2 m
Connection for water cooling unit: option
Handle: on top of the machine
Norm: EN 60974/1 S / CE
Weight: 39.2 kg
Dimensions l x w x h: 600 x 300 x 575 mm

MMA/stick electrode operation:

Stick electrodes: 1.5 - 4 mm
Open circuit voltage: 70 V
Welding voltage: 20 - 32 V
Welding current: 5 - 300 A
Duty cycle 40 % (10 min.): 300 A (40 °C)
Duty cycle 60 % (10 min.): 270 A (40 °C)
Duty cycle 100 % ED: 230 A (40 °C)
Prim. cont. power: 13.1 kVA
Prim. cont. current: 19 A
Prim. max. current: 25 A

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit LogiTIG 300 AC/DC					
A	TIG welding unit LogiTIG 300 AC/DC (Merkle TCG connector)		02	117236	8.344,00
AB	TIG welding unit LogiTIG 300 AC/DC with accessories (Merkle TCG connector)		02	SET117238	8.507,00
ABC1	TIG welding unit LogiTIG 300 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)		02	SET117240	8.857,00
ABC2	TIG welding unit LogiTIG 300 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)		02	SET117242	8.987,00



With water cooler and trolley TW 112:

	TIG welding unit LogiTIG 300 AC/DC incl. water cooler WK 300 and trolley TW 112		02	SET117248	9.659,00
	TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112		02	SET117250	9.822,00
	TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112 and torch TH 452 W, 4 m		02	SET117244	10.317,00
	TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112 and torch TH 452 W, 8 m		02	SET117246	10.377,00
Option	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00



B Standard accessories:



B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
B2	Regulator argon/CO2, single stage		46	01200300	75,00



C Welding torches:



C1	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
C2	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
C3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00



Pos.	Description	Pu	PrGrp	Part No.	Price/€
D Accessories:					
	D1a Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	D1b Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	D2 Electrode welding cable 35 mm ² , 5 m incl. plug 50 mm ² & electrode holder		46	02210451	68,00
	D3 Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D4 Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D5 Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D6 Filter frame incl. filter for LogiTIG 300 AC/DC, HighTIG 352 DC, MobiMIG 320 K (reduced duty cycle)		46	117530	121,49
	D7 Filter for LogiTIG 300 AC/DC, (min. 10 pieces)	10 pcs	46	117532	4,05
	D8 Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00
	D9 Euro connector for portable TIG welding units		46	110430	69,00
	D10a Option external gas connection TIG units gas: 1/4" external thread, current: 50 mm ² , torch plug: 5-pol (not for LiteTIG series)		46	153800	38,00
	D10b Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm ² , torch plug: 5-pol		46	153802	84,00
	D11 Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Accessories for using water cooler:


E1	Water cooling unit model WK 300	46	02610143	980,00
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E2	Coolant ME-KM 22 eco, 10 l for welding units	07	169376	68,00
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E3	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	E4	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00

F Robot and automation accessories:


F1	Connection for automated welding for LogiTIG 300 AC/DC - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	118068	323,96
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F1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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F2	Connection for automated welding for LogiTIG 300 AC/DC - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.	46	118070	1.058,66
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F2.1	Connection cable 10-pol. 5m welding unit - automated system	46	01903556	133,00
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G Accessories for synchron welding:


G1	AC synchron welding incl. switch and socket	46	00503023	385,00
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G1.1	Test cable for AC synchron welding	46	00503024	290,00
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5.2.8. Water cooling unit WK 300

Power supply:	1 x 400 V / 230 V
Frequency:	50 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Water cooling unit:					
	A Water cooling unit model WK 300		46	02610143	980,00
B Accessories:					
	B1 Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	185,00
	B2 Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00

5.2.9. Insquare W 321 AC/DC

Primary:

Power supply: 3 x 400 V
Frequency: 50 Hz

TIG DC- and AC-operation:

Open circuit voltage: 80 V
Welding voltage: 10 - 22.8 V
Welding current: 5 - 320 A
Duty cycle 60 % (10 min.): 320 A (40 °C)
Duty cycle 80 % (10 min.): 300 A (40 °C)
Duty cycle 100 %: 260 A (40 °C)
Prim. cont. power: 13.2 kVA
Prim. cont. current: 19 A
Prim. max. current: 22 A



Protection class:	IP 23	Pulsation slow:	10 ms - 2.5 s
Insulation class:	H	Pulsation fast:	50 Hz - 5 kHz
Cooling:	AF	Hotstart time:	0 - 1.5 s
Main switch:	3-phase	Hotstart current:	10 - 200 %
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusodial, MMA/stick electrode square arc	Arc force:	100 - 250 %
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time	Button:	test protection device
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage	Button:	program selection
Adjusting:	2 rotary switches for selectors 1 and 2	LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr. inverter
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency	Power source:	EN 60974-1 "S" / CE
Timer functions:	OFF, quick and slow pulsation, spot welding time	Norm:	Euro connector with 5-pole plug
Ignition:	OFF, high frequency, LiftTIG	Torch connection:	integrated water cooling system
Energy control:	at the machine, at the remote controls, at the torch	Torch cooling:	earth lead
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming	Socket 50 mm²:	electrode welding cable
Program storage:	20 programs	Socket 50 mm²:	4 x 4 mm², 5 m long with plug 3 x 400 V, 32 A
AC frequency:	50 - 200 Hz	Mains supply cable:	2 m
AC balance:	9 - 91 %	Gas hose:	10 - 20 - 50 l cylinders
Gas pre-flow time:	0 - 3 s	Gas bottle holder:	4 pieces (option)
Gas post-flow time:	0 - 25 s	Lifting eyes:	140 kg
Up slope time:	0 - 2 s	Weight:	1020 x 476 x 970 mm
Down slope time:	0 - 20 s	Dimensions l x w x h:	incl. gas bottle holder
Ignition impulse:	0 - 100 ms		
Spot welding time:	0.1 - 2.5 s		

MMA/stick electrode operation:

Stick electrodes: 1.5 - 6 mm (Cel-suitable)
Open circuit voltage: 80 V
Welding voltage: 20 - 32.8 V
Welding current: 5 - 320 A
Duty cycle 60 % (10 min.): 320 A (40 °C)
Duty cycle 80 % (10 min.): 300 A (40 °C)
Duty cycle 100 %: 260 A (40 °C)
Prim. cont. power: 14.5 kVA
Prim. cont. current: 21 A
Prim. max. current: 27 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit Insquare W 321 AC/DC						
	A	TIG welding unit Insquare W 321 AC/DC		02	123790	12.822,00
	AB	TIG welding unit Insquare W 321 AC/DC with accessories		02	SET123792	12.985,00
	ABC1	TIG welding unit Insquare W 321 AC/DC with access. and torch TH 452 W, 4 m		02	SET123794	13.510,00
	ABC2	TIG welding unit Insquare W 321 AC/DC with access. and torch TH 452 W, 8 m		02	SET123796	13.570,00
B Standard accessories:						
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/rubber hose assembly		10	145086	525,00
	C2	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/rubber hose assembly		10	145088	585,00
	C3	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/rubber hose assembly		10	145090	685,00
D Accessories:						
	D1	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	D2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D5	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	D6	Filter frame incl. filter for Insquare W 321 and 421		46	122626	138,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Door for control panel with lock for Insquare 321 and 421		46	123836	215,00
	D8	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Robot and automation accessories:



Automation

E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	02010907	320,00
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E1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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Automation

E2	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.	17	01903066	1.295,00
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E2.1	Connection cable 24-pin., 5 m welding unit - robot	46	01903557	167,00
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E3	Bus connection EtherCAT	17	101687	2.400,00
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F Accessories for synchron welding:



Synchron

F1	AC synchron welding incl. switch and socket	46	00503023	385,00
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F1.1	Test cable for AC synchron welding	46	00503024	290,00
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5.2.10. Insquare W 421 AC/DC

Primary:

Power supply: 3 x 400 V
Frequency: 50 Hz

TIG DC- and AC-Operation:

Open circuit voltage: 80 V
Welding voltage: 10 - 26.8 V
Welding current DC: 5 - 420 A
Welding current AC: 5 - 400 A
Duty cycle 40 % (10 min.): 420 A (40 °C)
Duty cycle 50 % (10 min.): 420 A (20 °C)
Duty cycle 60 % (10 min.): 400 A (20 °C) 360 A (40 °C)
Duty cycle 100 %: 320 A (20 °C) 310 A (40 °C)
Prim. cont. power: 14.5 kVA
Prim. cont. current: 21 A
Prim. max. current: 28 A



Protection class:	IP 23	Pulsation slow:	10 ms - 2.5 s
Insulation class:	H	Pulsation fast:	50 Hz - 5 kHz
Cooling:	AF	Hotstart time:	0 - 1.5 s
Main switch:	3-phase	Hotstart current:	10 - 200 %
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusodial, MMA/stick electrode square arc	Arc force:	100 - 250 %
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time	Button:	test protection device
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage	Button:	program selection
Adjusting:	2 rotary switches for selectors 1 and 2	LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr. inverter
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency	Power source:	EN 60974-1 "S" / CE
Timer functions:	OFF, quick and slow pulsation, spot welding time	Norm:	Euro connector with 5-pole plug
Ignition:	OFF, high frequency, LiftTIG	Torch connection:	integrated water cooling system
Energy control:	at the machine, at the remote controls, at the torch	Torch cooling:	earth lead
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming	Socket 50 mm ² :	electrode welding cable
Program storage:	20 programs	Socket 50 mm ² :	4 x 4 mm ² , 5 m long with plug 3 x 400 V, 32 A
AC frequency:	50 - 200 Hz	Mains supply cable:	2 m
AC balance:	9 - 91 %	Gas hose:	10 - 20 - 50 l cylinders
Gas pre-flow time:	0 - 3 s	Gas bottle holder:	4 pieces (option)
Gas post-flow time:	0 - 25 s	Lifting eyes:	150 kg
Up slope time:	0 - 2 s	Weight:	1020 x 476 x 970 mm
Down slope time:	0 - 20 s	Dimensions l x w x h:	incl. gas bottle holder and handle, without lifting eyes
Ignition impulse:	0 - 100 ms		
Spot welding time:	0.1 - 2.5 s		

MMA/stick electrode operation:

Stick electrodes: 1.5 - 6 mm (Cel-suitable)
Open circuit voltage: 80 V
Welding voltage: 20 - 36.8 V
Welding current: 5 - 420 A
Duty cycle 40 % (10 min.): 420 A (40 °C)
Duty cycle 60 % (10 min.): 360 A (40 °C)
Duty cycle 100 %: 300 A (40 °C)
Prim. cont. power: 14.5 kVA
Prim. cont. current: 21 A
Prim. max. current: 28 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit Insquare W 421 AC/DC						
	A	TIG welding unit Insquare W 421 AC/DC		02	122624	13.477,00
	AB	TIG welding unit Insquare W 421 AC/DC with accessories		02	SET122626	13.675,00
	ABC1	TIG welding unit Insquare W 421 AC/DC with access. and torch TH 452 W, 4 m		02	SET122628	14.200,00
	ABC2	TIG welding unit Insquare W 421 AC/DC with access. and torch TH 452 W, 8 m		02	SET122630	14.260,00
B Standard accessories:						
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
	B2	Regulator argon/CO2, single stage		46	01200300	75,00
C Welding torches:						
	C1	TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/rubber hose assembly		10	145086	525,00
	C2	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/rubber hose assembly		10	145088	585,00
	C3	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/rubber hose assembly		10	145090	685,00
D Accessories:						
	D1	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	D2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D5	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	D6	Filter frame incl. filter for Insquare W 321 and 421		46	122626	138,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Door for control panel with lock for Insquare 321 and 421		46	123836	215,00
	D8	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Robot and automation accessories:



E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	02010907	320,00
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E1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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E2	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.	17	01903066	1.295,00
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E2.1	Connection cable 24-pin., 5 m welding unit - robot	46	01903557	167,00
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E3	Bus connection EtherCAT	17	101687	2.400,00
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F Accessories for synchron welding:



F1	AC synchron welding incl. switch and socket	46	00503023	385,00
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F1.1	Test cable for AC synchron welding	46	00503024	290,00
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5.2.11. Insquare W 600 AC/DC

Primary:

Power supply: 3 x 400 V
 Frequency: 50 Hz

TIG DC- and AC-Operation:

Open circuit voltage: 80 V
 Welding voltage: 10 - 34 V
 Welding current: 20 - 600 A
 Duty cycle 80 % (10 min.): 600 A
 Duty cycle 100 %: 500 A (40 °C)
 Prim. cont. power: 24.2 kVA
 Prim. cont. current: 35 A
 Prim. max. current: 42 A



Protection class:	IP 23	Pulsation slow:	10 ms - 2.5 s
Insulation class:	H	Pulsation fast:	50 Hz - 5 kHz
Cooling:	AF	Hotstart time:	0 - 1.5 s
Main switch:	3-phase	Hotstart current:	10 - 200 %
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusoidal, MMA/stick electrode square arc	Arc force:	100 - 250 %
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time	Button:	test protection device
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage	Button:	program selection
Adjusting:	2 rotary switches for selectors 1 and 2	LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr.
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency	Power source:	inverter
Timer functions:	OFF, quick and slow pulsation, spot welding time	Norm:	EN 60974-1 "S" / CE
Ignition:	OFF, high frequency, LiftTIG	Torch connection:	Euro connector with 5-pole plug
Energy control:	at the machine, at the remote controls, at the torch	Torch cooling:	integrated water cooling system
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming	Socket 50 mm ² :	earth lead
Program storage:	20 programs	Socket 50 mm ² :	electrode welding cable
AC frequency:	50 - 200 Hz	Mains supply cable:	4 x 6 mm ² , 5 m long with plug 3 x 400 V, 32 A
AC balance:	9 - 91 %	Gas hose:	2 m
Gas pre-flow time:	0 - 3 s	Gas bottle holder:	10 - 20 - 50 l cylinders
Gas post-flow time:	0 - 25 s	Lifting eyes:	4 pieces (option)
Up slope time:	0 - 2 s	Weight:	255 kg
Down slope time:	0 - 20 s	Dimensions l x w x h:	1055 x 630 x 1290 mm incl. gas bottle holder and handle, without lifting eyes
Ignition impulse:	0 - 100 ms		
Spot welding time:	0.1 - 2.5 s		

MMA/stick electrode operation:

Stick electrodes: 1.5 - 6 mm (Cel-suitable)
 Open circuit voltage: 80 V
 Welding voltage: 20 - 44 V
 Welding current: 5 - 600 A
 Duty cycle 50 % (10 min.): 600 A (40 °C)
 Duty cycle 60 % (10 min.): 550 A (40 °C)
 Duty cycle 100 %: 450 A (40 °C)
 Prim. cont. power: 25.6 kVA
 Prim. cont. current: 37 A
 Prim. max. current: 50 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A TIG AC/DC welding unit Insquare W 600 AC/DC						
	A	TIG welding unit Insquare W 600 AC/DC		02	100304	25.134,00
	AB	TIG welding unit Insquare W 600 AC/DC with accessories		02	SET100306	25.435,00
	ABC	TIG welding unit Insquare W 600 AC/DC with accessories and torch TH 600 W, 8 m		02	SET100308	26.180,00
B Standard accessories:						
	B1	Earth lead 120 mm ² , 4 m long with plug and earth clamp		46	02210396	226,00
	B2	Regulator argon/CO ₂ , single stage		46	01200300	75,00
C Welding torches:						
	C1	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		10	104410	745,00
	C2	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	845,00
D Accessories:						
	D1	Electrode welding cable 70 mm ² , 5 m incl. plug and electrode holder		46	02210449	190,00
	D2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	D3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	D4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	D5	Coolant ME-KM 22 eco, 10 l for welding units		07	169376	68,00
	D6	Filter frame incl. filter for IQ 300/420/600, CM 350/400, RM 3000/4000, reduced duty cycle	2 pcs	46	00501047	135,00
	D7	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	4,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D8	Lifting eye screw, galvanized	4 pcs	46	09002001	4,75
	D9	Mains plug 5-pol. CEE, 63 A, 400 V		07	01201702	150,00
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	159,00

E Robot and automation accessories:


E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.	46	02010907	320,00
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E1.1	Connection cable 6-pol welding unit - automated system, 5 m	46	01903593	115,00
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E2	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.	17	01903066	1.295,00
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E2.1	Connection cable 24-pin., 5 m welding unit - robot	46	01903557	167,00
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E3	Bus connection EtherCAT	17	101687	2.400,00
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F Accessories for synchron welding:


F1	AC synchron welding incl. switch and socket	46	00503023	385,00
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F1.1	Test cable for AC synchron welding	46	00503024	290,00
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6. TIG welding torches

6. TIG welding torches

Hand welding torches

6.1. **TH 202 G**

6.2. **TH 452 W**

6.3. **TH 600 W**

Machine welding torch

6.4. **TM 450 W**

Cold Wire Feed System

6.5. **KDFZ**



6.1. TH 202 G

TIG hand welding torch TH 202 G gas cooled



VERSIONS:



Standard



Potentiometer

TECHNICAL DATA:

Cooling:	gas cooled
DC range:	200 A 40% duty cycle
AC range:	180 A 40% duty cycle*
	*at 30% positive polarity
Tungsten electrodes:	1.0 - 2.4 mm [
Weight:	230 g without hose assembly

Pos.	Description	Pu	PrGrp	Part No.	Price/€
With Merkle TCG connection:					
	TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/rubber hose assembly		10	129516	350,00
	TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/rubber hose assembly		10	129518	480,00
	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/rubber hose assembly		10	129520	580,00
With Euro connection:					
	TIG hand welding torch model TH 202 G-EURO, 4 m with Euro connector leather/rubber hose assembly		10	129522	370,00
	TIG hand welding torch model TH 202 G-EURO, 8 m with Euro connector leather/rubber hose assembly		10	129526	500,00
	TIG hand welding torch model TH 202 G-EURO, 8 m with Euro connector & potentiometer leather/rubber hose assembly		10	129528	600,00
With Euro connection for HighPULSE/MobiMIG:					
	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/rubber hose assembly		10	133632	350,00
	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/rubber hose assembly		10	129532	480,00
Standard equipment: 2.4 mm, ceramic 10.0					
Spare parts and consumables:					
	3.1 Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,94
	3.2 Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	3,07
	3.3 Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	6,60
	8.1 Back cap "quick TIG" 1.0 mm, long TH 161/201/202 G		26	114184	36,40
	8.2 Back cap "quick TIG" 1.6 mm, long TH 161/201/202 G		26	114186	36,40
	8.3 Back cap "quick TIG" 2.4 mm, long TH 161/201/202 G		26	114188	36,40
	9.1 Back cap "quick TIG" 1.0 mm, short TH 161/201/202 G		26	114190	33,60
	9.2 Back cap "quick TIG" 1.6 mm, short TH 161/201/202 G		26	114192	33,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	9.3	Back cap "quick TIG" 2.4 mm, short TH 161/201/202 G		26	114194	33,60
	10	Torch neck TH 202 G		26	129510	88,90
	11	O ring 9 x 1.5	10 pcs	26	02210704	3,08
	12.1	Ceramic nozzle 6.5 mm TH 202 G screwable version	10 pcs	26	128808	4,13
	12.2	Ceramic nozzle 8.0 mm TH 202 G screwable version	10 pcs	26	128806	4,13
	12.3	Ceramic nozzle 10.0 mm TH 202 G screwable version	10 pcs	26	128804	4,13
	12.4	Ceramic nozzle 12.5 mm TH 202 G screwable version	10 pcs	26	127348	4,13
	12.5	Ceramic nozzle 6.5 mm TH 202 G short screwable version, for gas lens	10 pcs	26	128814	4,12
	12.6	Ceramic nozzle 8.0 mm TH 202 G short screwable version, for gas lens		26	128812	4,12
	12.7	Ceramic nozzle 10.0 mm TH 202 G short screwable version, for gas lens		26	128810	4,12
	13.1	Gas lens 1.0 mm TH 202 G		26	129148	38,65
	13.2	Gas lens 1.6 mm TH 202 G		26	129146	38,65
	13.3	Gas lens 2.4 mm TH 202 G		26	129122	38,65
	29	Adjustment wheel incl. potentiometer for TH torch		26	108354	129,50
	31	Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	21,00
	33	Pc board for TIG double button switch (for torch with ball joint)		26	107992	27,17
	34	Switch button (red) for TIG torch with ball joint		26	107994	4,69
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	21,00
	37	Kinking protection for TIG handle		26	107998	18,90

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	44	Merkle TCG connector plug (gas cooled) incl. rubber housing and 2 o-rings		26	109554	29,12
	45	O-ring 8 x 1.6	10 pcs	22	103544	2,19
	47	Torch plug for TIG-torch (standard)		26	02110380	42,00
	50.1	Cable assembly 4 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106868	129,50
	50.2	Power cable 8 m TH 201/202 G		26	106872	218,00
	50.3	Power cable 8 m TH 201/202 G-MAG		26	107048	215,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,95
	51.2	Control cable 5 x 0.5 LiYY no shield		26	107242	4,34
	54.1	Protection hose 4 m leather/rubber for TIG torch		26	114332	56,70
	54.2	Protection hose 8 m leather/rubber for TIG torch		26	114334	79,10
	58.1	Cable assembly 4 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106866	266,81
	58.2	Cable assembly 8 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106870	404,25
	58.3	Cable assembly 8 m, TH 201/202 G incl. Merkle TCG connector, control cable 5 x 1.5		26	106871	412,34
Hose assembly with Euro connector:						
	62.1	Brass body for TIG Euro connector incl. nut 5/8"		26	01340048	31,50
	62.2	Brass body central connector MAG gas cooled		22	02511401	27,77
	63	Sleeve nut black		22	02510300	
	64.1	Kinking protection at machine side TIG Euro connector (set 3 pieces)		26	01340049	12,45
	64.2	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	9,83
	65	Torch plug for TIG-torch (standard)		26	02110380	42,00
	66.1	Cable assembly 4 m, TH 201/202 G incl. Euro connector, control cable 3 x 0.5		26	108504	282,98

Pos.	Description	Pu	PrGrp	Part No.	Price/€
66.2	Cable assembly 8 m, TH 201/202 G incl. Euro connector, control cable 3 x 0.5		26	108506	420,42
66.3	Cable assembly 8 m, TH 201/202 G for torch with potentiometer incl. Euro connector, control cable 5 x 0.5		26	108507	428,51
66.4	Cable assembly 4 m, TH 201/202 G-MAG incl. Euro connector, control cable 3 x 0.5		26	133634	242,55
66.5	Cable assembly 8 m, TH 201/202 G-MAG incl. Euro connector, control cable 3 x 0.5		26	107047	380,00
	Double connector M 10 x 1		22	02511200	5,88



6.2. TH 452 W

TIG hand welding torch TH 452 W water cooled



VERSIONS:



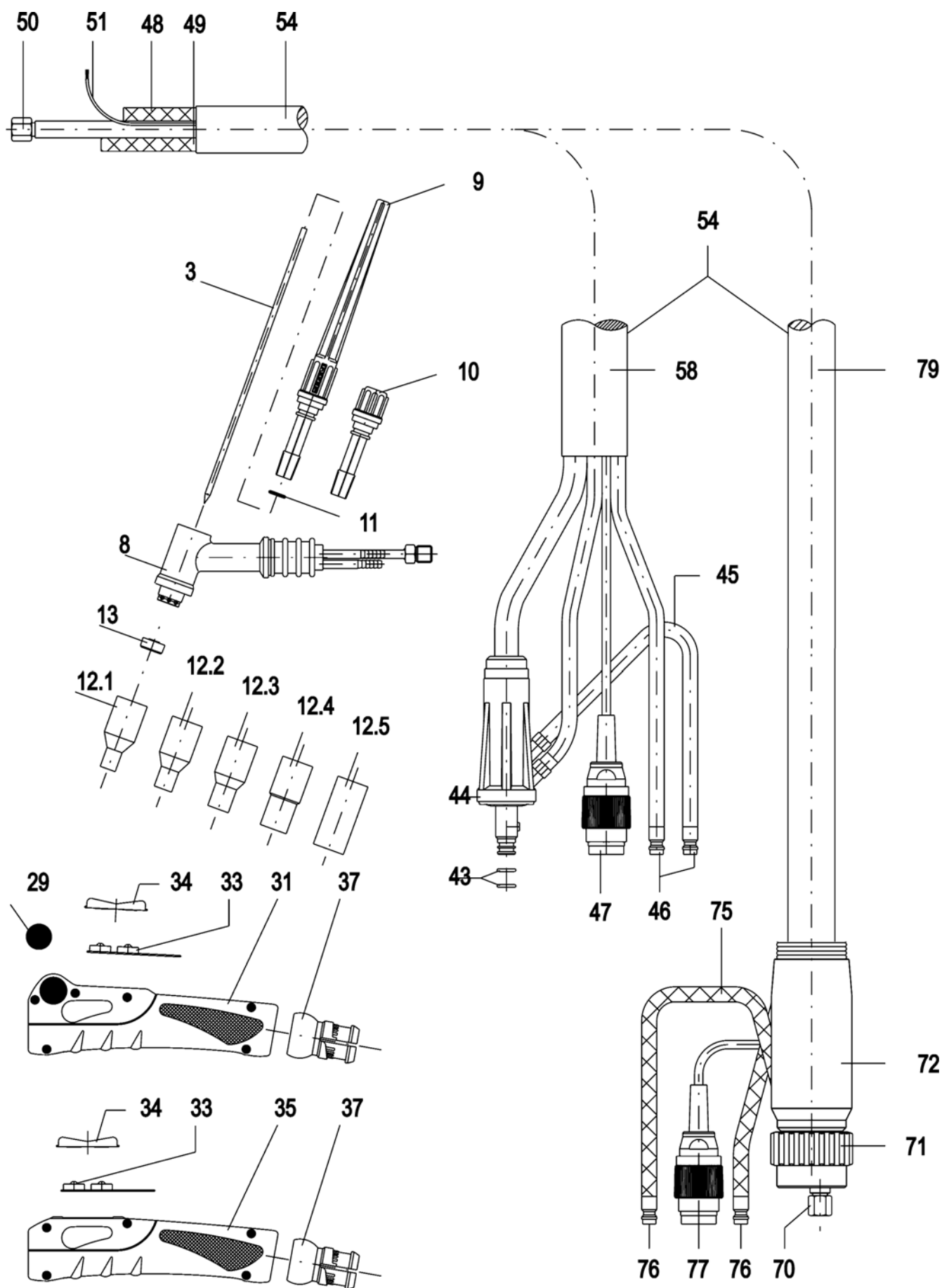
Standard



Potentiometer

TECHNICAL DATA:

Cooling:	water cooled
DC range:	425 A 60% duty cycle
AC range:	385 A 60% duty cycle*
	*at 30% positive polarity
Tungsten electrodes:	1.0 - 4.0 mm [
Weight:	240 g without hose assembly



Pos.	Description	Pu	PrGrp	Part No.	Price/€
With Merkle TCG connection:					
	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/rubber hose assembly		10	145080	495,00
	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/rubber hose assembly		10	145082	555,00
With Merkle TCG connection and potentiometer:					
	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145081	595,00
	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/rubber hose assembly		10	145084	655,00
With Euro connection:					
	TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/rubber hose assembly		10	145086	525,00
	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/rubber hose assembly		10	145088	585,00
	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/rubber hose assembly		10	145092	555,00
With Euro connection and potentiometer:					
	TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector and potentiometer leather/rubber hose assembly		10	145087	625,00
	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/rubber hose assembly		10	145090	685,00
Standard equipment: 3.2 mm, ceramic 12.5					
! Attention: Select gas nozzle holder (pos. 13) according to tungsten electrode diameter					
Spare parts and consumables:					
	3.1 Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,94
	3.2 Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	3,07
	3.3 Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	6,60
	3.4 Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	11,00
	3.5 Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	16,01
8	Torch body TH 452 W		26	145016	162,40

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	9.1	Back cap "quick TIG" 1.0 mm, long TH 452 W		26	142380	36,40
	9.2	Back cap "quick TIG" 1.6 mm, long TH 452 W		26	142382	36,40
	9.3	Back cap "quick TIG" 2.4 mm, long TH 452 W		26	142384	36,40
	9.4	Back cap "quick TIG" 3.2 mm, long TH 452 W		26	142400	36,40
	9.5	Back cap "quick TIG" 4.0 mm, long TH 452 W		26	142386	36,40
	10.1	Back cap "quick TIG" 1.0 mm, short TH 452 W		26	145430	33,60
	10.2	Back cap "quick TIG" 1.6 mm, short TH 452 W		26	145432	33,60
	10.3	Back cap "quick TIG" 2.4 mm, short TH 452 W		26	145434	33,60
	10.4	Back cap "quick TIG" 3.2 mm, short TH 452 W		26	145436	33,60
	10.5	Back cap "quick TIG" 4.0 mm, short TH 452 W		26	145438	33,60
	11	O ring 9 x 1.5	10 pcs	26	02210704	3,08
	12.1	Ceramic nozzle 6.5 TH 452 W	10 pcs	26	142402	4,20
	12.2	Ceramic nozzle 8.0 TH 452 W	10 pcs	26	142404	4,20
	12.3	Ceramic nozzle 10.0 TH 452 W	10 pcs	26	142406	4,20
	12.4	Ceramic nozzle 12.5 TH 452 W	10 pcs	26	142408	4,20
	12.5	Ceramic nozzle 15.0 TH 452 W	10 pcs	26	142410	4,20
	13.1	Gas nozzle holder 1.0 mm TH 452 W complete with integrated gas lense		26	142388	28,28
	13.2	Gas nozzle holder 1.6 mm TH 452 W complete with integrated gas lense		26	142390	28,28
	13.3	Gas nozzle holder 2.4 mm TH 452 W complete with integrated gas lense		26	142392	28,28
	13.4	Gas nozzle holder 3.2 mm TH 452 W complete with integrated gas lense		26	142394	28,28
	13.5	Gas nozzle holder 4.0 mm TH 452 W complete with integrated gas lense		26	142396	28,28
	29	Adjustment wheel incl. potentiometer for TH torch		26	108354	129,50
	31	Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	21,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	33	Pc board for TIG double button switch (for torch with ball joint)		26	107992	27,17
	34	Switch button (red) for TIG torch with ball joint		26	107994	4,69
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	21,00
	37	Kinking protection for TIG handle		26	107998	18,90
	43	O-ring 8 x 1.6	10 pcs	22	103544	2,19
	44	Merkle TCG connector plug (water cooled) incl. rubber housing and 2 o-rings		26	109556	55,16
	45	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	46	Coupling nipple for water	10 pcs	22	02510400	2,41
	47	Torch plug for TIG-torch (standard)		26	02110380	42,00
	48	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	49	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	50.1	Power cable TH 452 W, 4 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104378	89,00
	50.2	Power cable TH 452 W, 8 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104379	127,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,95
	51.2	Control cable 5 x 0.5 LiYY no shield		26	107242	4,34
	54.1	Protection hose 4 m leather/rubber for TIG torch		26	114332	56,70
	54.2	Protection hose 8 m leather/rubber for TIG torch		26	114334	79,10
	58.1	Cable assembly TH 452 W, 4 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107652	291,20
	58.2	Cable assembly TH 452 W, 8 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107660	355,60
	58.3	Cable assembly TH 452 W, 4 m 10 qmm, Merkle TCG connector (control cable 5 x 0.5)		26	155618	299,60
	58.4	Cable assembly TH 452 W, 8 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107664	364,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Hose assembly with Euro connector:					
	70 Euro-connector for TIG torches, water cooled		26	01340061	43,00
	71 Sleeve nut black		22	02510300	13,07
	72 Kinking protection for water cooled TIG torches 3 pieces		22	117678	16,90
	75 PVC hose 5 x 1.5, red per m		22	00600206	1,74
	76 Coupling nipple for water	10 pcs	22	02510400	2,41
	77 Torch plug for TIG-torch (standard)		26	02110380	42,00
	79.1 Cable assembly TH/TM 452 W, 4 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108362	306,60
	79.2 Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108364	387,00
	79.3 Cable assembly TH 452 W, 4 m 10 qmm, Euro connector, for torches with potentiometer (control cable 5 x 1.5)		26	155596	319,20
	79.4 Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, for torches with potentiometer (control cable 5 x 0.5)		26	108366	395,00
	79.5 Cable assembly TH 452 W, 8 m MAG 10 qmm, MIG/MAG Euro connector, (control cable 3 x 1.5)		26	117928	355,60

6.3. TH 600 W

TIG hand welding torch TH 600 W water cooled



VERSIONS:



Standard



Potentiometer

TECHNICAL DATA:

Cooling:	water cooled
DC range:	600 A 60% duty cycle
AC range:	600 A 60% duty cycle
Tungsten electrodes:	2.4 - 4.8 mm [
Weight:	360 g without hose assembly

Pos.	Description	Pu	PrGrp	Part No.	Price/€
TIG hand welding torch TH 600 W					
	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		10	104410	745,00
	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	845,00
Standard equipment: 4.0 mm, ceramic 13.0					
Spare parts and consumables:					
	1.1 Back cap "quick TIG" 2.4 mm, long TH 600 W		26	107722	65,80
	1.2 Back cap "quick TIG" 3.2 mm, long TH 600 W		26	107724	65,80
	1.3 Back cap "quick TIG" 4.0 mm, long TH 600 W		26	107726	65,80
	1.4 Back cap "quick TIG" 4.8 mm, long TH 600 W		26	107728	65,80
	2.1 Back cap "quick TIG" 2.4 mm, short TH 600 W		26	107734	65,80
	2.2 Back cap "quick TIG" 3.2 mm, short TH 600 W		26	107736	65,80
	2.3 Back cap "quick TIG" 4.0 mm, short TH 600 W		26	107738	65,80
	2.4 Back cap "quick TIG" 4.8 mm, short TH 600 W		26	107740	65,80
	3.1 Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	6,60
	3.2 Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	11,00
	3.3 Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	16,01
	3.4 Tungsten-electrode, grey 4.8 x 175 mm	10 pcs	26	01300116	17,63
	4 Torch neck TH 600 W		26	104270	315,00
	5.1 Ceramic nozzle 10.0, TH 600 W	10 pcs	26	104300	4,13
	5.2 Ceramic nozzle 13.0, TH 600 W	10 pcs	26	104302	4,13
	5.3 Ceramic nozzle 16.0, TH 600 W	10 pcs	26	104304	4,13
	7 O ring 11 x 2.5	10 pcs	26	05011829	5,09
	29 Adjustment wheel incl. potentiometer for TH torch		26	108354	129,50
	31 Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	21,00
	33 Pc board for TIG double button switch (for torch with ball joint)		26	107992	27,17

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	34	Switch button (red) for TIG torch with ball joint		26	107994	4,69
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	21,00
	37	Kinking protection for TIG handle		26	107998	18,90
	48	PVC hose 5 x 1.5, blue per m		22	00600205	1,74
	49	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	50	Power cable TH 600 W, 8m, 16 qmm		26	107752	145,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,95
	54	Protection hose 8 m leather/rubber for TIG torch		26	114334	79,10
	58.1	Cable assembly TH 600 W, 8 m 16 qmm, Euro connector		26	107744	387,80
	58.2	Cable assembly TH 600 W, 8 m 16 qmm, Euro connector for torch with potentiometer		26	107746	392,00
	70	Euro-connector for TIG torches, water cooled		26	01340061	43,00
	71	Sleeve nut black		22	02510300	13,07
	72	Kinking protection for water cooled TIG torches 3 pieces		22	117678	16,90
	75	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	76	Coupling nipple for water	10 pcs	22	02510400	2,41
	77	Torch plug for TIG-torch (standard)		26	02110380	42,00

6.4. TM 450 W

TIG machine welding torch TM 450 W

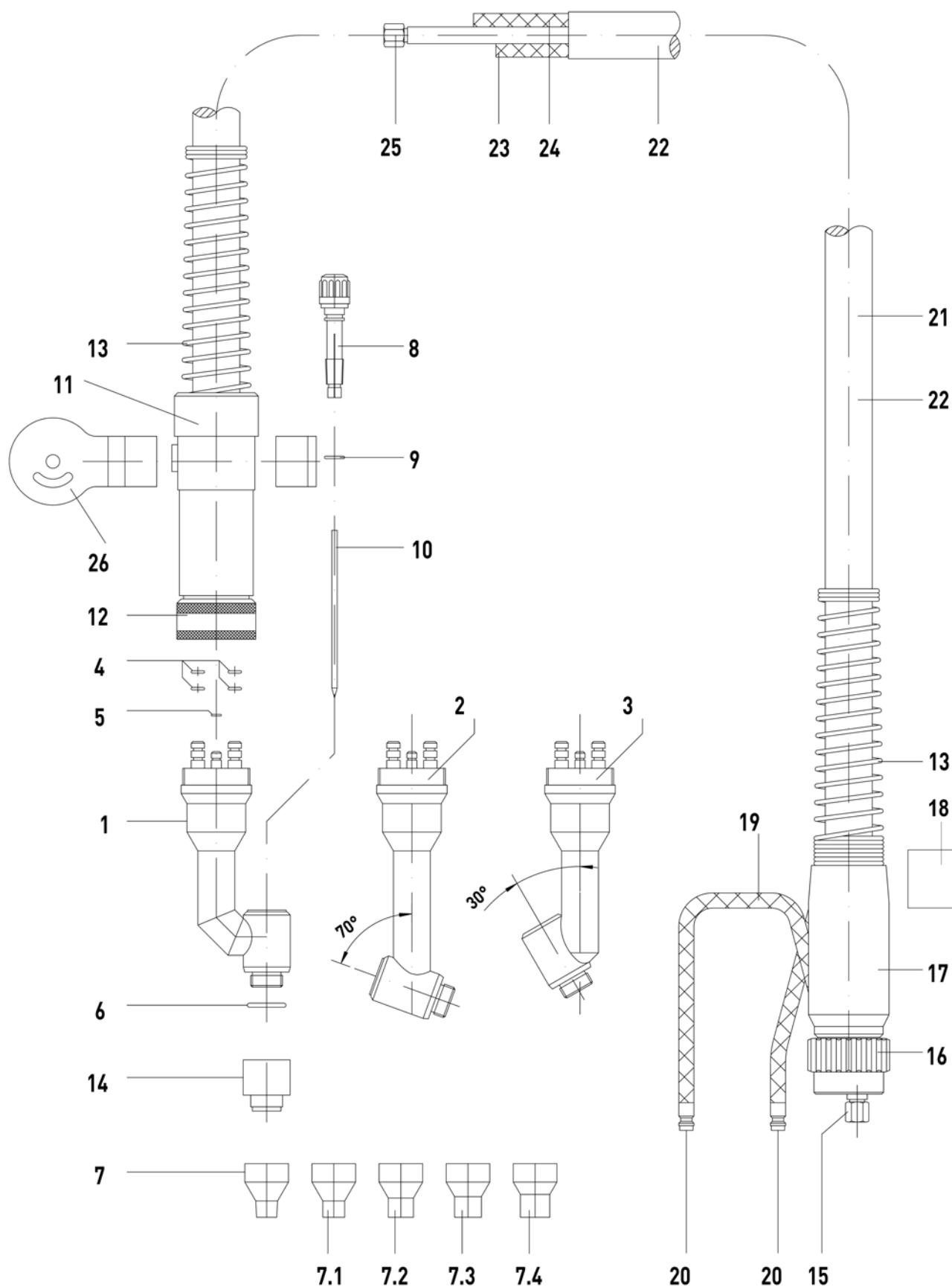
water cooled / Euro connector
removable torch head

Versions of the torch head: straight, 30° bent, 70° bent



TECHNICAL DATA:

Cooling:	water cooled
DC range:	450 A 60% duty cycle
AC range:	450 A 60% duty cycle
Tungsten electrodes:	1.0 - 4.0 mm [
Weight:	470 g torch head

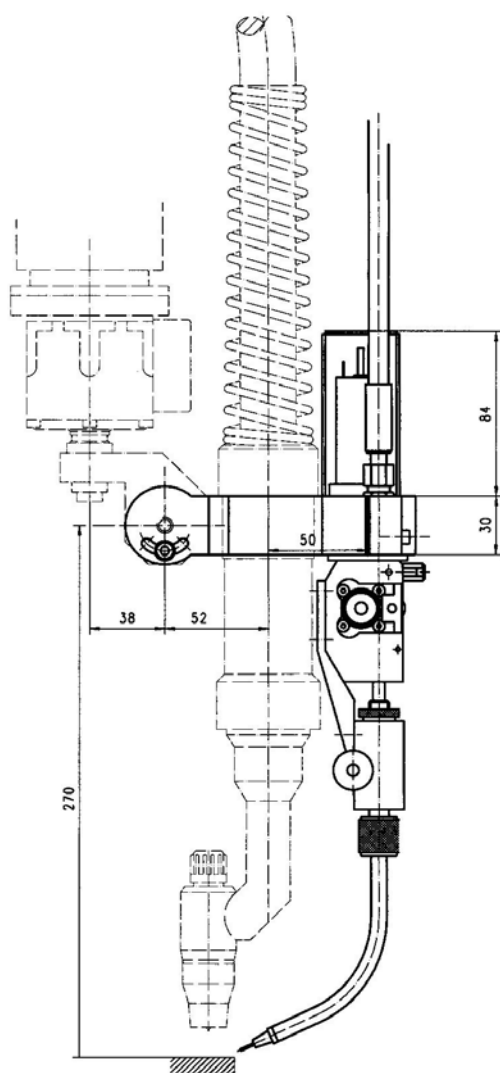


Pos.	Description	Pu	PrGrp	Part No.	Price/€
Hose assemblies:					
	Cable assembly TM 450 W, 4 m incl. upper torch head connector		10	109406	860,00
	Cable assembly TM 450 W, 8 m incl. upper torch head connector		10	109408	940,00
Torch heads:					
	1 Torch head TM 450 W, straight		10	109392	630,00
	2 Torch head TM 450 W, 70° bent		10	109404	630,00
	3 Torch head TM 450 W, 30° bent		10	109400	630,00
Spare parts and consumables:					
	4 O-ring 5 x 1.5 (PM 400/150)	10 pcs	26	103137	5,09
	5 O-ring 4 x 1 liner for steel 70 shore model PA431	10 pcs	22	02210333	4,21
	6 O ring 18 x 2.5	10 pcs	26	05011830	5,09
	7.1 Ceramic gas-nozzle size 4	10 pcs	26	01300066	6,29
	7.2 Ceramic gas-nozzle size 5	10 pcs	26	01300067	6,29
	7.3 Ceramic gas-nozzle size 6	10 pcs	26	01300068	6,29
	7.4 Ceramic gas-nozzle size 7	10 pcs	26	01300069	6,29
	7.5 Ceramic gas-nozzle size 8	10 pcs	26	01300070	7,13
	7.6 Ceramic gas-nozzle size 10	10 pcs	26	109870	8,00
	7.7 Ceramic gas-nozzle size 12	10 pcs	26	109872	8,00
	8 Back cap "quick TIG" 1.0 mm, short TH/TM 450 W		26	107685	33,60
	8.1 Back cap "quick TIG" 1.6 mm, short TH/TM 450 W		26	107687	33,60
	8.2 Back cap "quick TIG" 2.4 mm, short TH/TM 450 W		26	107689	33,60
	8.3 Back cap "quick TIG" 3.2 mm, short TH/TM 450 W		26	107693	33,60
	8.4 Back cap "quick TIG" 4.0 mm, short TH/TM 450 W		26	107695	33,60
	9 O ring 9 x 1.5	10 pcs	26	02210704	3,08
	10 Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,94
	10.1 Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	3,07
	10.2 Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	6,60
	10.3 Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	11,00
	10.4 Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	16,01

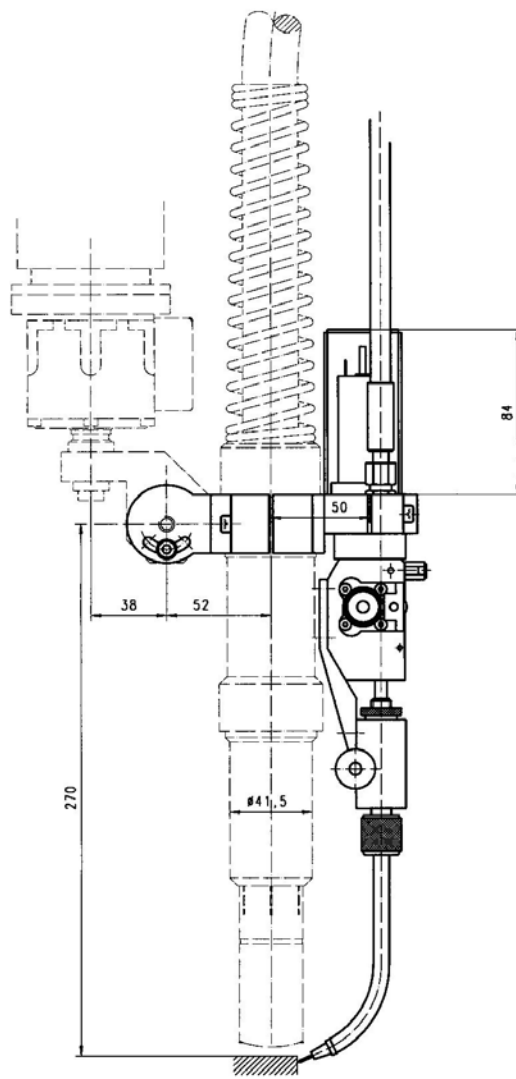
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	11	Tube V2		26	140900	105,00
	11.1	Brass body for EURO connector, torch side, PM 150/400		24	103532	262,61
	12	Fastening nut TM 450 W		26	109388	184,80
	13	Spring for kinking protection Euro connector, water cooled		22	02211579	13,07
	14.1	Gas lense TM 450 W, 1.0 mm		26	125956	74,20
	14.2	Gas lense TM 450 W, 1.6 mm		26	125958	74,20
	14.3	Gas lense TM 450 W, 2.4 mm		26	125462	74,20
	14.4	Gas lense TM 450 W, 3.2 mm		26	125960	74,20
	14.5	Gas lense TM 450 W, 4.0 mm		26	125962	74,20
	15	Euro-connector for TIG torches, water cooled		26	01340061	43,00
	16	Sleeve nut black		22	02510300	13,07
	17	Kinking protection, intake water cooled		22	02510100	18,98
	18	Kinking protection for MIG torches water cooled		22	02211580	13,07
	19.1	PVC hose 7 x 2, black per m		07	00600105	3,76
	19.2	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	20	Coupling nipple for water	10 pcs	22	02510400	2,41
	21	Cable assembly TH/TM 452 W, 4 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108362	306,60
	21.1	Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108364	387,00
	22	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	8,69
	23.1	PVC hose 7 x 2, black per m		07	00600105	3,76
	23.2	PVC hose 5 x 1.5, red per m		22	00600206	1,74
	24	PVC hose 5 x 1.5, black per m		22	00600207	1,61
	25	Power cable TH 452 W, 4 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104378	89,00
	25.1	Power cable TH 452 W, 8 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104379	127,00
	26	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	99,00

6.5. KDZF

Cold Wire Feed System Model KDZF



(with TM 450 W)



(with PM 400 W)

Technical Data:

Wire diameter:	0.8 - 1.2 mm
Wire feed speed:	0.5 - 5.0 m/min
Motor supply voltage:	42 V DC
Connection:	Euro connector and 10-pol plug

Pos.	Description	Pu	PrGrp	Part No.	Price/€
A Cold wire feed system WITH Push-Pull-operation:					
1a	Controller for cold wire feed KDZF with push-pull operation, installed in an automation system of Merkle		05	134570	4.250,00
1b	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		05	138921	960,00
1c	Controller for cold wire feed KDZF with push-pull operation, model E052-DIS-PP installed in external cabinet supply voltage: 230 V incl. sequence controller		05	162546	3.990,00
1d	Controller for cold wire feed KDZF with push-pull operation, model E052-ROB installed in an external cabinet supply voltage: 230 V control through: 1 x control voltage 0-3.3 V		05	145808	2.260,00
1e	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	175,00
2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		05	104634	2.430,00
3a	Cold Wire Feed KDZF with Feed Tube for PM 400 W (Mechanic with Motor) for Push-Pull use		05	141612	2.810,00
3b	Cold Wire Feed KDZF with Feed Tube for TM 450 W (Mechanic with Motor) for Push-Pull use		05	141614	2.810,00
4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	99,00
B Cold wire feed system WITHOUT Push-Pull-operation:					
1a	Controller for cold wire feed KDZF WITHOUT push-pull operation, installed inside HighTIG/HighPLAS incl. software		05	146018	690,00
1b	Controller for cold wire feed KDZF without (!) push-pull operation, model E052-DIS installed in an external cabinet supply voltage: 230 V incl. sequence controller		05	162544	3.400,00
1c	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	175,00
2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		05	104634	2.430,00
3a	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for PM 400 W		05	141608	1.080,00
3b	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for TM 450 W		05	141610	1.080,00
4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	99,00

7. MMA/stick electrode welding units

7. MMA/stick electrode welding units

LiteARC 160/180

MobiARC 284 cel

MobiARC 284 cel ±



7.1. LiteARC 160

Primary:

Voltage:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. power (MMA/TIG):	3.7 kVA / 2.8 kVA
Cont. current (MMA/TIG):	16 A / 12 A
Max. current (E/TIG):	26 A / 20 A

MMA/stick electrode operation:

Stick electrode:	1.5 - 3.25 mm
Open circuit voltage:	64 V
Welding voltage:	20.6 - 26.4 V
Welding current:	15 - 160 A
Duty cycle 25 % (10 min.):	150 A (40 °C)
Duty cycle 30 % (10 min.):	150 A (20 °C)
Duty cycle 60 % (10 min.):	100 A (20 °C) 90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C) 80 A (40 °C)



Protection class:	IP 23
Isolation class:	F
Cooling:	AF
Main switch:	2-phase
Operation modes:	MMA/stick welding, TIG (DC) welding with hotstart (fixed) LiftTIG ignition
Potentiometer:	welding current
LED:	mains ON
LED:	temperature protection
Functions:	anti stick, hotstart and arc force (fixed)
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm², 2.5 m long with plug schuko
Transport:	adjustable carry/shoulder strap
Protection cover:	in front of operation panel
Weight:	6.0 kg
Dimensions l x w x h:	360 x 150 x 240 mm

TIG operation:

Open circuit voltage:	64 V
Welding voltage:	10 - 16.4 V
Welding current:	5 - 160 A
Duty cycle 20 % (10 min.):	160 A (40 °C)
Duty cycle 25 % (10 min.):	160 A (20 °C)
Duty cycle 60 % (10 min.):	100 A (20 °C) 90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C) 80 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MMA/stick electrode and TIG welding unit LiteARC 160						
	A	MMA/Stick electrode and TIG welding unit model LiteARC 160		47	153772	642,00
	AB	MMA/Stick electrode and TIG welding unit model LiteARC 160 incl. accessories		47	SET153774	725,00
B Standard accessories:						
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	43,00
	B2	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	40,00
C Accessories:						
	C1	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	C2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	C3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	C4	Handle set for LiteARC 160/180		46	158340	39,00
D Accessories for TIG welding:						
	D1	TIG hand welding torch WHL 17-H with manual gas valve, 8 m and single connetor 50 mm2		10	101036	235,00
	D2	Regulator argon/CO2 standard version		46	107018	43,00

7.2. LiteARC 180

Primary:

Voltage:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (MMA/TIG):	35 A / 28 A

MMA/stick electrode operation:

Stick electrode:	1.5 - 4 mm
Open circuit voltage:	68 V
Welding voltage:	20.8 - 26.8 V
Welding current:	20 - 170 A
Duty cycle 25 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)



Protection class:	IP 23
Isolation class:	H
Cooling:	AF
Main switch:	2-phase
Operation modes:	MMA/stick welding, with anti stick, arc force and hotstart TIG (DC) welding with LiftTIG ignition
Rotary switch:	welding current
Digital display:	welding current
LEDs:	mains ON temperature protection operation mode MMA/TIG hotstart arc force
Functions:	hotstart (adjustable) arc force (adjustable) anti stick
Norm:	EN 60974-1 "S" / CE
Socket 50 mm ² :	earth lead cable
Socket 50 mm ² :	electrode welding cable
Mains supply cable:	3 x 2.5 mm ² , 5 m long with plug schuko
Transport:	adjustable carry/shoulder strap
Weight:	5.2 kg
Dimensions l x w x h:	360 x 150 x 240 mm

TIG operation:

Open circuit voltage:	68 V
Welding voltage:	10.4 - 17.2 V
Welding current:	10 - 180 A
Duty cycle 25 % (10 min.):	180 A (40 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MMA/stick electrode and TIG welding unit LiteARC 180						
	A	MMA/Stick electrode and TIG welding unit model LiteARC 180		47	157786	905,00
	AB	MMA/Stick electrode and TIG welding unit model LiteARC 180 incl. accessories		47	SET146372	988,00
B Standard accessories:						
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	43,00
	B2	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	40,00
C Accessories:						
	C1	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	C2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	75,00
	C3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	3,60
	C4	Handle set for LiteARC 160/180		46	158340	39,00
	C5	Remote control socket (5 pol) for LiteARC 180/200		46	157166	127,00
	C6	Hand remote control MFR-11 for LiteARC 180/200 with magnet, 5 m cable, 5 pol plug		46	157168	220,00
D Accessories for TIG welding:						
	D1	TIG hand welding torch WHL 17-H with manual gas valve, 8 m and single connetor 50 mm2		10	101036	235,00
	D2	Regulator argon/CO2 standard version		46	107018	43,00

7.3. MobiARC 284 cel

Primary:

Voltage: 3 x 400 V
Frequency: 50 / 60 Hz

Data at mains input: **3 x 400 V** | **1 x 230 V***

Cont. power (TIG/MMA):	8.3 / 9.7 kVA	3.2 / 3.7 kVA
Cont. current (TIG/MMA):	12 / 14 A	14 / 16 A
Max. current (TIG/MMA):	16 / 21 A	26 / 26 A

MMA/stick electrode operation:

Stick electrode:	1.5 - 6.0 mm (Cel-suitable)	1.5 - 3.25 mm
Open circuit voltage:	90 V	103 V
Welding voltage:	20.8 - 31.2 V	20.8 - 26.4 V
Welding current:	20 - 280 A	20 - 160 A
Duty cycle 35 %:	280 A (40 °C)	150 A (20 °C)
Duty cycle 50 %:	250 A (40 °C)	
Duty cycle 60 %:	240 A (40 °C)	90 A (40 °C)
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)



Protection class: IP 23
Isolation class: H
Cooling: AF
Main switch: 3-phasing
Operation modes: MMA/stick welding,
TIG (DC) welding with LiftTIG ignition
Settings: welding current, hotstart current, hotstart time,
TIG down slope time, electrode type
LEDs: mains ON, welding ON,
failure, temperature protection
Display: LED indication for current, time, voltage
Electrode type: selectable rutile, basic, cellulose
Remote control: power socket 10-pole
VRD: optional
Power source: inverter
Norm: EN 60974-1 "S" / CE
Socket 50 mm²: earth lead cable
Socket 50 mm²: electrode welding cable
Mains supply cable: 4 x 2.5 mm² 5 m long with plug 400 V, 16 A
Weight: 17 kg
Dimensions l x w x h: 495 x 210 x 450 mm

Data at mains input: **3 x 400 V** | **1 x 230 V***

TIG operation:

Open circuit voltage:	90 V	103 V
Welding voltage:	10 - 21.2 V	10 - 16.4 V
Welding current:	3 - 280 A	3 - 160 A
Duty cycle 35 %:	280 A (40 °C)	150 A (20 °C)
Duty cycle 50 %:	250 A (40 °C)	
Duty cycle 60 %:	240 A (40 °C)	90 A (40 °C)
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)

*: BiPowerPLUS: Multi voltage supply system:
automatic switching between 1 and
3 phase in the range 220 – 400 V (option)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MMA/stick electrode and TIG welding unit MobiARC 284 cel						
	A	MMA/stick electrode welding unit model MobiARC 284 cel		45	143078	3.060,00
	AB	MMA/Stick electrode welding unit model MobiARC 284 cel incl. accessories		45	SET143110	3.196,00
B Standard accessories:						
	B1	Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210401	68,00
	B2	Electrode welding cable 35 mm ² , 5 m incl. plug 50 mm ² & electrode holder		46	02210451	68,00
C Accessories:						
	C1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	214,00
	C2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	52,00
	C3	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
	C4	Special cable, shielded with copper coat, 7 x 0,75 110 (per 1m)		07	00701015	7,75
D Electrode and earth cable:						
Up to 10 m length:						
		Earth lead 35 mm ² , 4 m long with plug 50 mm ² and earth clamp		46	02210401	68,00
		Electrode welding cable 35 mm ² , 5 m incl. plug 50 mm ² & electrode holder		46	02210451	68,00
		Welding cable, 35 mm ² , black (per m)		07	00900200	15,20
Up to 25 m length:						
		Earth lead 50 mm ² , 4 m long with plug and earth clamp		46	02210402	88,00
		Electrode welding cable 50 mm ² , 5 m incl. plug and electrode holder		46	129354	133,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Welding cable 50 mm², black (per m)		07	00900300	22,00
Up to 50 m length:					
	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
	Welding cable, 70 mm², black (per m)		07	00900400	39,00

7.4. MobiARC 284 cel ±

Primary:

Voltage: 3 x 400 V
Frequency: 50 / 60 Hz
Cont. power (MMA/TIG): 9.7 kVA / 8.3 kVA
Cont. current (MMA/TIG): 14 A / 12 A
Max. current (MMA/TIG): 21 A / 16 A

MMA/stick electrode operation:

Stick electrode: 1.5 - 6.0 mm (Cel-suitable)
Open circuit voltage: 90 V
Welding voltage: 20.6 - 31.2 V
Welding current: 15 - 280 A
Duty cycle 35 %: 280 A (40 °C)
Duty cycle 50 %: 280 A (20 °C) 250 A (40 °C)
Duty cycle 60 %: 260 A (20 °C) 240 A (40 °C)
Duty cycle 100 %: 240 A (20 °C) 210 A (40 °C)



Protection class: IP 23
Isolation class: H
Cooling: AF
Main switch: 3-phase
Operation modes: MMA/stick welding,
TIG (DC) welding with LiftTIG ignition
Settings: welding current, Hotstart current,
Hotstart time, TIG down slope time,
electrode type
LEDs: mains ON, welding ON,
failure, temperature protection
Display: LED indication for current, time, voltage
Electrode type: selectable rutile, basic, cellulose
Remote control: socket 10-pole
polarity switch
VRD: optional
Power source: inverter
Norm: EN 60974-1 "S" / CE
Socket 50 mm²: earth lead cable
Socket 50 mm²: electrode welding cable
Mains supply cable: 4 x 2.5 mm² 5 m long with plug 400 V, 16 A
Weight: 19 kg
Dimensions l x w x h: 495 x 210 x 450 mm

TIG operation:

Open circuit voltage: 90 V
Welding voltage: 10 - 21.2 V
Welding current: 5 - 280 A
Duty cycle 35 %: 280 A (40 °C)
Duty cycle 50 %: 280 A (20 °C) 250 A (40 °C)
Duty cycle 60 %: 270 A (20 °C) 240 A (40 °C)
Duty cycle 100 %: 240 A (20 °C) 210 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A MMA/stick electrode and TIG welding unit MobiARC 284 cel ±						
	A	MMA/Stick electrode welding unit MobiARC 284 cel ± with polarity switch		45	143112	4.470,00
	AB	MMA/Stick electrode welding unit MobiARC 284 cel ± with polarity switch incl. accessories		45	SET143114	4.606,00
B Standard accessories:						
		Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
		Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
Accessories:						
		Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +/-)		46	123791	470,00
		Special cable, shielded with copper coat, 7 x 0,75 110 (per 1m)		07	00701015	7,75
Electrode and earth cable:						
Up to 10 m length:						
		Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
		Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
		Welding cable, 35 mm², black (per m)		07	00900200	15,20
Up to 25 m length:						
		Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
		Electrode welding cable 50 mm², 5 m incl. plug and electrode holder		46	129354	133,00
		Welding cable 50 mm², black (per m)		07	00900300	22,00
Up to 50 m length:						
		Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00

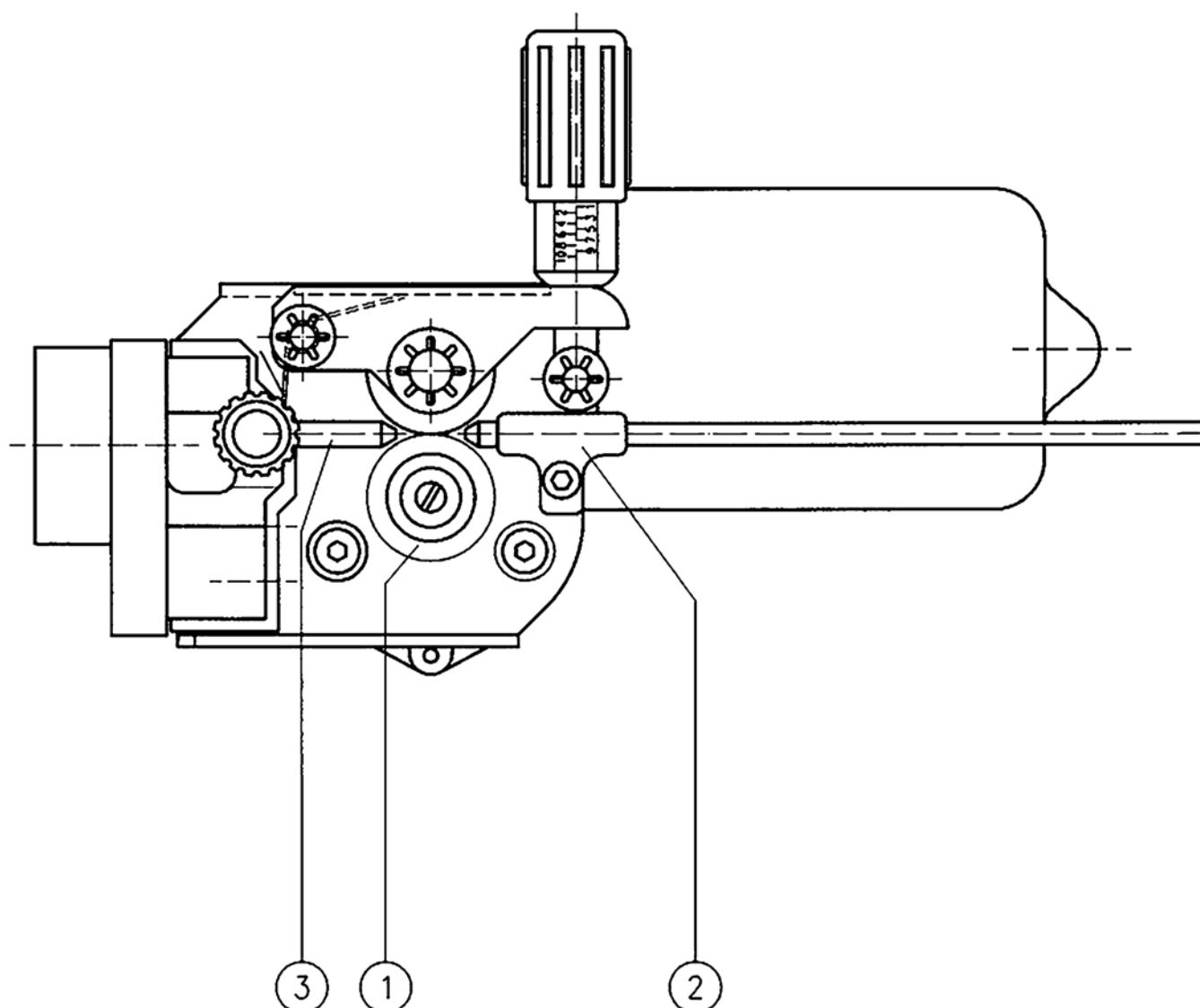
Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Electrode welding cable 70 mm ² , 5 m incl. plug and electrode holder		46	02210449	190,00
	Welding cable, 70 mm ² , black (per m)		07	00900400	39,00

8. Accessories

8. Accessories

- 8.1. Wire feeder gear DV-21**
- 8.2. Wire feeder gear DV-26**
- 8.3. Wire feeder gear DV-31**
- 8.4. Water cooling units**
- 8.5. WeldFACTORY i4.0 (Q.MACS)**
- 8.6. Software, program updates, calibration**
- 8.7. Calibration unit MCU 1000**
- 8.8. Accessories**
- 8.9. Promotional items**
- 8.10. Brochures and catalogs**

8.1. Wire feeder DV-21



Pos.	Description	Pu	PrGrp	Part No.	Price/€
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2-roller drive wire feeder DV-21



2-roller drive wire feeder DV-21,
gear block with motor,
Euro connector and drive roller

07

113756

385,00

Additional wire equipment for DV-21:

A	Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)	46	01200387	55,00
B	Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)	46	01200388	55,00
C	Kit for mild steel 1.0 mm (DV-21,20/2) (without contact tips)	46	01200389	55,00
D	Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)	46	01200390	76,00
E	Kit for stainless steel 1.0 mm (DV-21,20/2) (without contact tips)	46	01200391	76,00
F	Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)	46	01200392	76,00



1 Drive rollers:

1.1	Drive roller steel 0.6/0.6 (DV-21,20/2)	46	01200215	43,80
1.2	Drive roller steel 0.8/1.0 (DV-21,20/2)	46	01200209	43,80
1.3	Drive roller steel 0.8/1.2 (DV-21,20/2)	46	01200216	43,80
1.4	Drive roller alu 1.0/1.2 (DV-21,20/2)	46	01200212	43,80



2 Insertion piece:

2.1	Insertion piece DV-21, 26 complete with insertion liner	46	117938	17,50
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3 Outgoing nozzle:

3.1	Outgoing and guidance nozzle pvc, DV-21, 20/2	46	01200384	8,40
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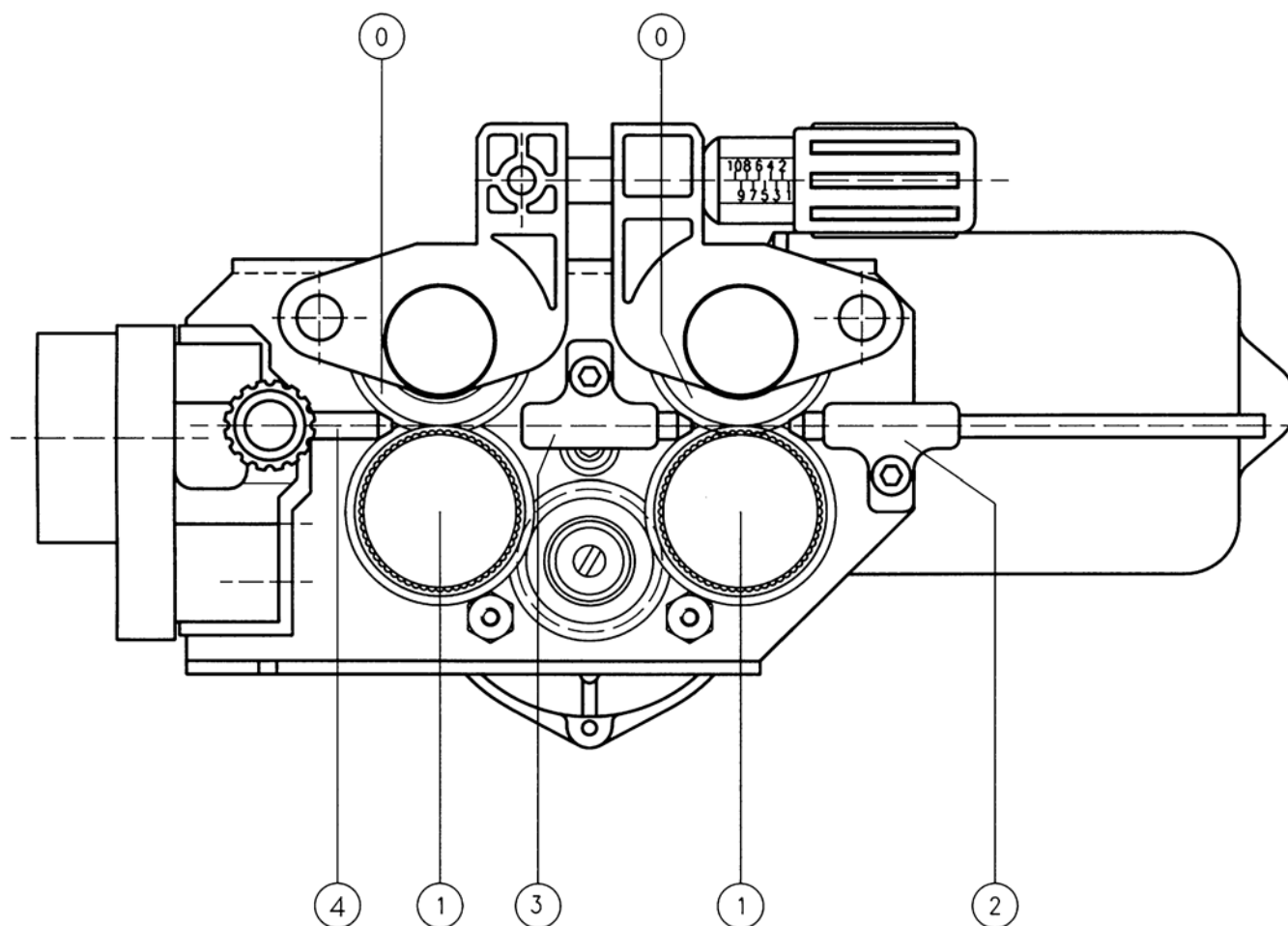
4 Wire feed liners:

4.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long	22	02210246	7,23
4.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long	22	02210247	7,52
4.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long	22	02210244	7,52
4.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long	22	02210245	7,87
4.5	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner	22	02210586	32,97



	Pos.	Description	Pu	PrGrp	Part No.	Price/€
5	Contact tips (for SB/SBT 157 G):					
	5.1	Contact tip 0.6 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152181	1,78
	5.2	Contact tip 0.8 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152180	1,78
	5.3	Contact tip 1.0 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152182	1,78
6	Contact tips (for SB/SBT 307 G):					
	6.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	6.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	6.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17

8.2. Wire feeder DV-26

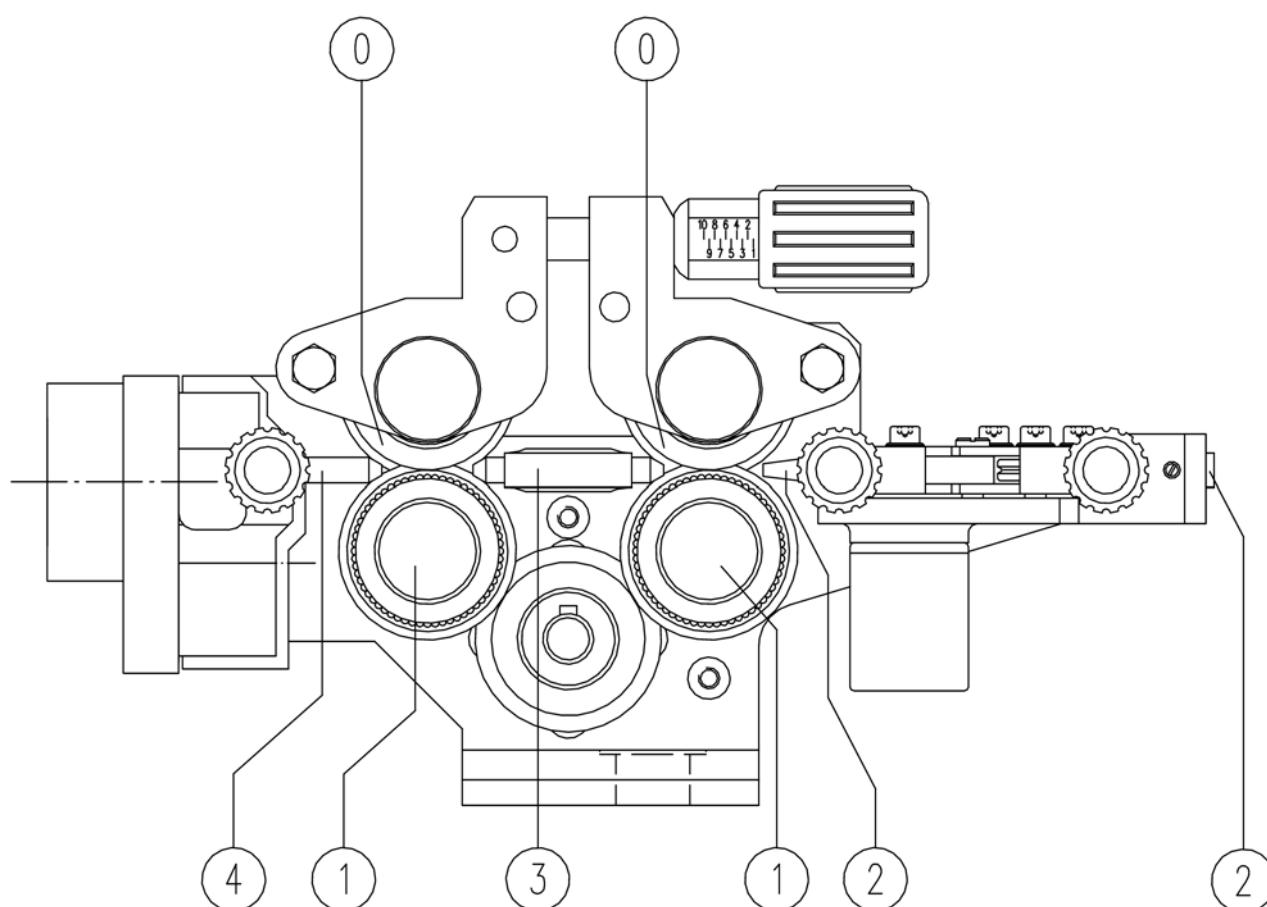


Pos.	Description	Pu	PrGrp	Part No.	Price/€
4-roller drive wire feeder DV-26					
	4-roller drive wire feeder DV-26 incl. motor and Euro connector incl. pressure rollers, drive pinion and roller carrier from metal. without drive rings,		07	113564	545,00
	4-roller drive wire feeder DV-26 incl. motor and Euro connector incl. pressure rollers, drive pinion and roller carrier from plastic. without drive rings,		07	160772	518,00
Additional wire equipment for DV-26:					
	A Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	B Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	C Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	D Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	E Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	F Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
Components for additional wire equipment:					
	0.1 Pressure ring DV-26/31/32		46	124724	33,00
	0.2a Roller carrier metal DV-26/30/31/32 with ball bearing		07	110560	65,50
	0.2b Roller carrier plastic DV-26/31/32 with ball bearing		07	160768	58,80
	0.3 Distance ring for core wire equipment DV-26, DV-31		46	126968	3,60
	0.4a Drive pinion DV-26, metal		07	113580	64,00
	0.4b Drive pinion DV-26, plastic		07	158330	57,00
1 Drive rollers:					
	1.0 Drive ring steel 0.6 + 0.8 DV-26/31/32		46	113945	46,20
	1.1 Drive ring steel 0.8 + 1.0 DV-26/31/32		46	113946	46,20
	1.2 Drive ring steel 1.0 + 1.2 DV-26/31/32		46	01200272	46,20
	1.3 Drive ring steel 0.9 + 0.9 DV-26/31/32		46	01200262	46,20
	1.4 Drive ring alu 1.0 + 1.2 DV-26/31/32		46	01200281	46,20

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.5	Drive ring alu 0.8 + 1.6 DV-26/31/32		46	01200282	46,20
2	Insertion piece:					
	2.1	Insertion piece DV-21, 26 complete with insertion liner		46	117938	17,50
3	Insertion and guidance nozzle:					
	3.1	Guidance piece with double guide DV-21/26		46	131508	10,30
4	Outgoing nozzle:					
	4.1	Outgoing nozzle DV-26, 31, 30/4 0.8 - 1.6 mm		46	110554	6,90
5	Wire feed liners:					
	5.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	5.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	5.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	5.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	5.5	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 5 m long		22	113512	8,21
	5.6	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	5.7	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75
	5.8	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	5.9	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	5.10	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	5.11	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32
6	Contact tips (for SB/SBT 157 G):					
	6.1	Contact tip 0.6 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152181	1,78
	6.2	Contact tip 0.8 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152180	1,78
	6.3	Contact tip 1.0 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	22	152182	1,78
7	Contact tips SB/SBT 307/351/352/504:					
	7.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	7.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	7.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	7.4	Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
	7.5	Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	22	04511817	2,17

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	7.6	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	7.7	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	7.8	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	7.9	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89

8.3. Wire feeder DV-31



Pos.	Description	Pu	PrGrp	Part No.	Price/€
4-roller drive wire feeder DV-31					
	4-roller drive wire feeder DV-31 (OT), incl. motor without tacho and Euro connector incl. pressure rollers, without drive rings		07	113836	1.820,00
Additional wire equipment for DV-31:					
	A Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	78,50
	B Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	78,50
	C Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	78,50
	D Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	97,00
	E Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	97,00
	F Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	97,00
	G Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	99,50
	H Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	99,50
	I Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	99,50
	J Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	103,70
	K Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	103,70
	L Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	279,00
	M Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	279,00
	N Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	279,00
Components for additional wire equipment:					
	0.1 Pressure ring DV-26/31/32		46	124724	33,00
	0.2 Roller carrier metal DV-26/30/31/32 with ball bearing		07	110560	65,50
	0.3 Distance ring for core wire equipment DV-26, DV-31		46	126968	3,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Drive rollers:					
	1.0	Drive ring steel 0.6 + 0.8 DV-26/31/32		46	113945	46,20
	1.1	Drive ring steel 0.8 + 1.0 DV-26/31/32		46	113946	46,20
	1.2	Drive ring steel 1.0 + 1.2 DV-26/31/32		46	01200272	46,20
	1.3	Drive ring steel 0.9 + 0.9 DV-26/31/32		46	01200262	46,20
	1.4	Drive ring steel 1.6 + 1.6 DV-31/32		46	113948	46,20
	1.5	Drive ring alu 1.0 + 1.2 DV-26/31/32		46	01200281	46,20
	1.6	Drive ring alu 0.8 + 1.6 DV-26/31/32		46	01200282	46,20
	1.7	Drive ring core wire 1.2 + 1.6 DV-31/32		46	01200291	51,90
	1.8	Drive ring core wire 2.0 + 2.4 DV-31/32		46	01200292	51,90
	1.9	Drive ring core wire 2.8 + 3.2 DV-31/32		46	01200293	51,90
2	Insertion nozzle:					
	2.1	Insertion nozzle DV-31, 30/4 0.8 - 1.6 mm		46	110862	7,30
	2.2	Insertion nozzle DV-31, 30/4 2.4 - 3.2 mm		46	110863	9,30
3	Guidance nozzle:					
	3.1	Guidance nozzle DV-31, 30/4 0.8 - 1.6 mm		46	110552	7,10
	3.2	Guidance nozzle DV-31, 30/4 2.4 - 3.2 mm		46	110553	9,40
4	Outgoing nozzle:					
	4.1	Outgoing nozzle DV-26, 31, 30/4 0.8 - 1.6 mm		46	110554	6,90
	4.2	Outgoing nozzle DV-31, 30/4 2.4 - 3.2 mm		46	110555	9,30
5	Wire feed liners:					
	5.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	7,23
	5.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	7,52
	5.3	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 3 m long		22	02210244	7,52
	5.4	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 4 m long		22	02210245	7,87
	5.5	Liner for steel (red) 2.0x4.5 1.0 - (1.2) mm, 5 m long		22	113512	8,21
	5.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	7,52
	5.7	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	7,87
	5.8	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 5 m		22	130020	8,27
	5.9	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	32,97
	5.10	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	38,75

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	5.11	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	40,50
	5.12	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	48,59
	5.13	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	50,33
	5.14	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	61,32

6 Contact tips SB/SBT 307/351/352/504:

	6.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	22	04511814	2,17
	6.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	22	04511815	2,17
	6.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	22	04511816	2,17
	6.4	Contact tip Cu-Cr-Zr 1.4 mm M8	20 pcs	22	04511819	2,17
	6.5	Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	22	04511817	2,17
	6.6	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	22	109754	2,89
	6.7	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	22	109756	2,89
	6.8	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	22	109758	2,89
	6.9	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	22	04511818	2,89

8.4. Water cooling units

Power supply:	1 x 230 V 1 x 400 V / 230 V (WK 230 / 300)
Frequency:	50 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficiency pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Water pressure switch:	integrated
Functions:	automatic switch of water pump and fan
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight/Dimensions l x w x h:	15 kg, 590x210x210 mm (WK 210) 18 kg, 610x230x215 mm (WK 230) 20 kg, 600x300x260 mm (WK 300) 28 kg, 700x355x285 mm (WK 350)

WK210

WK230

WK300

WK350



Pos.	Description	Pu	PrGrp	Part No.	Price/€
Water cooling units:					
	Water cooling unit model WK 210		46	143136	980,00
	Water cooling unit model WK 230		46	02610142	980,00
	Water cooling unit model WK 300		46	02610143	980,00
	Water cooling unit model WK 350		46	144008	1.680,00

Coolant ME-KM 20, ideal for all welding units and welding torches:



Coolant ME-KM 22 eco, 10 l for welding units	07	169376	68,00
Coolant ME-KM 22 eco 25 l for welding units	07	169378	167,00
Coolant ME-KM 22 eco, 220 l for welding units	07	169382	1.090,00
Coolant ME-KM 22 eco, 1000 l for welding units	07	169384	4.700,00

8.5. WeldFACTORY i4.0 (Q.MACS)

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	WeldFACTORY: software, required once per network for any number of workstations:				
1.1	Software WeldFACTORY incl. Weldassistant - Suitable for manual, automatic and robot controlled welding processes - Creation, execution, and monitoring of WPS-compliant welding procedures - Any quantity of welding units and machines in the network with any number of workstations - Data communication via OPC UA protocol - Integration of barcode scanners		17	159326	9.230,00
2	WeldFACTORY: machine interface and license required for each welding unit:				
2.1	WeldFACTORY welding machine equipment without software for one unit (159.191), monitoring of current, voltage, incl. ethernet interface and industrial ethernet plug allowing connection to an existing ethernet		17	159190	1.195,00
2.2	WeldFACTORY licence for one welding machine		17	159191	770,00
2.3	Option Wifi equipment only in combination with 126.506 or 159.190		17	144106	225,00
3	Options:				
3.1	WeldFACTORY gas flow monitoring hardware installed in the welding machine (incl. connection cable 1.6 m)		17	159328	1.010,00
3.2	WeldFACTORY option wire feed speed monitoring sensor for DV-31		17	159330	1.550,00
3.3	Barcode-Scanner for WeldFACTORY		17	159198	795,00
3.4	Training and set-up for WeldFACTORY/QMACS software (price per day, extras not included)		85	139188	1.290,00

8.6. Software, Program updates, Calibration

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1	Software for EN 1090:				
	1.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	233,00
	1.2	EN 1090 WPS/WPQR package for series OptiMIG		17	138672	233,00
	1.3	EN 1090 WPS/WPQR package for series HighPULSE, HighPULSE touch 350 - 550 A (incl. jobs) and OptiMIG for existing machines (calibration not included)		17	156806	155,00
	2	Software:				
	2.1	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.500,00
	2.2	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, USB-Stick		17	118444	235,00
	2.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.875,00
	3	Program updates and welding software:				
	3.1	Programm update for all welding units incl. EPROM		17	100724	480,00
	3.2	Programm update for MAG-30 controller		17	117972	360,00
	3.3	Programm update for LogiTIG with pcb ME-TIG-4.7		17	137140	430,00
	3.4	Programming of new welding program according to customer's specifications for synergic pulse units		17	100725	1.540,00
	3.5	Programming of new welding program according to customer's specifications for MIG/MAG units		17	100726	820,00
	 3.6	Software for ColdMIG process for series HighPULSE/GreenMIG		17	118064	880,00
	 3.7	Software for DeepArc process for series HighPULSE		17	118162	880,00
	 3.8	Software for HighUP process for series HighPULSE/GreenMIG		17	134392	880,00
	 3.9	Software for Interpulse process for series HighPULSE		17	120490	280,00
	4	Calibration:				
	4.1	Calibration (incl. working time) for welding machines incl. preparation and documentation		85	100619	148,00

8.7. Calibration unit MCU 1000

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Complete system:				
1.1	 Calibration unit MCU 1000, complete system consistant of: calibration resistor 1000 A, sensor box for wire speed and gas flow, software (without computer, printer, software-installation), all adapters and cables. For the calibration of welding units according to DIN EN 50504, suitable for MIG/MAG, TIG, MMA/stick electrode, Plasma - Measurement of welding current and voltage (+/- 1.0 %) - Measurement of temperatur and supply voltage (1ph/3ph) - External measurement of wire feed speed and gas flow - High duty cycle due to cooling with integrated fan - Automatic switching of the steps - HF proof design for calibration of TIG units - Grafic display for easy setting and recording of calibration and measurement parameters - Robust aluminium housing for mobile application at the customer - External software control - Automatic temperatur switch-off Dimensions appr. L 750 mm, W 310 mm, H 650 mm Weight approx. 45 kg	17		SET146510	17.400,00
1.2	Wheel set 160 mm 2 swivel wheels, 2 fix wheels		46	146132	84,00
1.3	Extension cable between sensor box (MCU 1000) and Euro connector at power source, approx. 1 m		46	146458	700,00
1.4	Calibration of the calibration unit MCU 1000 at Merkle Germany incl. BGVU3 check, incl. documentation, annually required		85	144204	429,00
1.5	Training and set-up for calibration system MCU 1000 incl. software installation (price per day, extras not included)		85	145956	1.290,00
1.6	Software installation via Teamviewer (3 h) Calibration unit MCU 1000 incl. telephone briefing		85	148478	477,00
2	System components:				
2.1	 Calibration resistor 1000 A (MCU 1000) For the calibration of welding units according to DIN EN 50504, suitable for MIG/MAG, TIG, MMA/stick electrode, Plasma - Measurement of welding current and voltage (+/- 1.0 %) - Measurement of temperatur and supply voltage (1ph/3ph) - Connector for external measurement of wire feed speed and gas flow - High duty cycle due to cooling with integrated fan - Automatic switching of the steps - HF proof design for calibration of TIG units - Grafic display for easy setting and recording of calibration and measurement parameters - Robust aluminium housing for mobile application at the customer - External control with optional software - Automatic temperatur switch-off Dimensions appr. L 750 mm, W 310 mm, H 650 mm Weight approx. 45 kg	17		141500	13.350,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
2.2	Set of two connection cables for MCU 1000 each 95 mm ² abd 1.5 mm ² with plugs in protection hose		46	143976	405,00
2.3	Adapter Euro connector --> Dinse socket with wire feed hose for external sensor box for MCU 1000		46	143974	195,00
2.4	Adapter cable and adapter for MCU 1000 for monitoring of the power supply voltage: 3~ 16 A CEE --> 6-pol Harting		46	146102	150,00
2.5	External sensor box for wire feed speed and gas flow for MCU 1000 and QMACS extern, for connection to Euro-connector, range 0 - 30 m/min and 3 - 30 l/min		46	141502	2.270,00
2.6	Connection cable between external sensor box and calibration resistor MCU 1000		46	143972	335,00
2.7	Calibration software (without installation) software functions: measurement of welding current (0-1000 A), welding voltage (0-100 V), wire feed speed (0-30 m/min), gas flow (0-20 l/min), supply voltage, room temperature (0-100°C) => parameter monitoring and control if the parameters are within the tolerance limits => report creation in pdf, excel or word format software in German and English (latest software version can be downloaded)		17	141504	1.395,00
2.8	USB cable 3 m, transparent, gold plug with ferrit ring, USB-A to USB-B		46	144942	16,50

8.8. Accessories

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Trolley:						
	1.1	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	335,00
	1.2	Drawer option for trolley TW 112 incl. one drawer		46	138940	350,00
	1.3	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	425,00
2 Regulators:						
	2.1	Regulator argon/CO2 standard version		46	107018	43,00
	2.2	Regulator argon/CO2, single stage		46	01200300	75,00
	2.3	Gas regulator Argon-CO2 0-30 l/min with flow meter		46	114554	185,00
	2.4	Gas regulator Argon-CO2 0-5 l/min with flow meter		46	144214	300,00
3 Earth leads:						
	3.1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	43,00
	3.2	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	47,00
	3.3	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	68,00
	3.4	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	88,00
	3.5	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	123,00
	3.6	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	182,00
	3.7	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	195,00
	3.8	Earth lead 120 mm², 4 m long with plug and earth clamp		46	02210396	226,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
4	Electrode welding cables:					
	4.1	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	40,00
	4.2	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	68,00
	4.3	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	190,00
5	Remote controls:					
	5.1	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	695,00
	5.2	Foot remote with 5 m cable and 10 pin plug		46	01903000	710,00
	5.3	Foot remote with 8 m cable and 10 pin plug		46	01902999	722,00
	5.4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	470,00
	5.5	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	530,00
	5.6	Hand remote 4m with 10 pin plug		46	01301059	340,00
	5.7	Hand remote 8m with 10 pin plug		46	01301060	375,00
	5.8	Foot switch with single button 3 m cable		05	01902900	251,00
	5.9	Foot switch with double button 3 m cable		05	01902901	435,00
	5.10	MAG Remote Control MRC-50 for HighPULSE und SpeedMIG in steel casing with handgrip and magnet, incl. 5 m supply cable		46	154578	1.150,00
6	Filters:					
	6.1		10 pcs	46	112550	4,10
	6.2	Filter for RS units 450/550 (minimum 10 pieces)	10 pcs	46	114468	4,60
	6.3	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	4,60
	6.4	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	4,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	6.5	Filter for OptiMIG	10 pcs	46	109528	4,60
	6.6	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	138,00
	6.7	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	138,00

7 Accessories:

	7.1	Adapter for wire spool		46	02900104	23,50
	7.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	49,50
	7.3	Transportation box black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 50 x 35 x 19.4 cm		46	n01200370	240,00
	7.4	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190/210 inner dimensions 59 x 47 x 21 cm		46	n01200372	295,00
	7.5	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	140,00

8.9. Advertising articles

Pos.	Description	Pu	PrGrp	Part No.	Price/€
Advertising articles					
	MERKLE ball pen, black		67	171047	1,20
	2 Swiss pocket-knife, 8,5 cm with bottle opener, screwdriver, pincers blue with white MERKLE print		67	102514	12,00
	3 MERKLE - Lighter black BIC L26		67	169648	1,30
	4 MERKLE porcelain mug		67	106784	7,40
	5 MERKLE meter, 2 m long ADGA		67	169650	3,70
	6 College block with 50 pages in MERKLE design		67	137980	1,75
	8 Desk pad à 25 sheets with new MERKLE design and welding positions		67	118088	3,15
	9 MERKLE - Drinking bottle green 800 ml, lid gray		67	169018	4,62
	10 MERKLE - License plate holder		67	169644	5,84
	11 MERKLE flag, 3 m x 1.20 m white with blue MERKLE print		67	106786	68,35
	12 Merkle cotton bag, green		67	169652	3,70

8.10. Leaflets and Catalogues

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	Leaflets:				
	Prospekt -DE- Programmübersicht		00	109608	
	Leaflet - Product Range		00	109610	
	Prospekt -DE- RedMIG eco 2800 K		00	166876	
	Leaflet - RedMIG eco 2800 K		00	166877	
	Prospekt -DE- OptiMIG eco Bauserie		00	170585	
	Leaflet -EN- OptiMIG eco series		00	171758	
	Prospekt -DE- MobiMIG Bauserie		00	109654	
	Leaflet - MobiMIG		00	109656	
	Prospekt -DE- GreenMIG 400/500		00	167064	
	Leaflet - GreenMIG 400/500		00	167066	
	Prospekt -DE- HighPULSE touch Bauserie		00	109678	
	Leaflet - HighPULSE touch		00	160152	
	Prospekt -DE- HighPULSE Bauserie		00	109658	
	Leaflet - HighPULSE		00	109660	
	Prospekt -DE- LiteTIG		00	167068	
	Leaflet - LiteTIG		00	167070	
	Prospekt -DE- MobiTIG 304 DC		00	167072	
	Leaflet - MobiTIG 304 DC		00	167074	
	Prospekt -DE- LogiTIG Bauserie		00	142142	
	Leaflet - LogiTIG		00	142144	
	Prospekt -DE- Baureihen HighTIG, Insquare		00	109670	
	Leaflet - HighTIG and Insquare		00	109672	
	Prospekt -DE- LiteARC Bauserie		00	156114	
	Leaflet - LiteARC 180		00	154726	
	Prospekt -DE- MobiARC 284 cel		00	109674	
	Leaflet - MobiARC 284 cel		00	109676	
	Prospekt -DE- DeepARC		00	129710	
	Leaflet - DeepARC		00	129712	
	Prospekt -DE- ColdMIG		00	129718	
	Leaflet - ColdMIG		00	129720	
	Prospekt -DE- HighUP		00	132822	
	Leaflet - HighUP		00	132930	
	Prospekt -DE- Rauchabsaugbrenner		00	133930	
	Leaflet - Fume extraction torches		00	133931	
	Prospekt -DE- Automatisierung und Robotics		00	129706	
	Leaflet - Automation and Robotics		00	129708	
	Prospekt -DE- WeldROB		00	149368	
	Leaflet -GB- WeldROB		00	160160	
	Prospekt -DE- Schweißfahrwerk		00	160150	
	Leaflet - Welding carriage		00	160162	
	Prospekt -DE- WCM		00	133804	
	Leaflet - WCM		00	133805	
	Prospekt -DE- QMACS		00	134648	

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Leaflet - QMACS		00	134650	
	Prospekt -DE- Kalibriergerät MCU 1000		00	142134	
	Prospekt -DE- Kalibrieren/Wiederholprüfung		00	149364	
	Prospekt -DE- DIN EN 1090		00	142136	
	Leaflet - Company Profile		00	133806	
	Prospekt -DE- Drehtische		00	156120	
	Leaflet - Welding positioner		00	156122	
	Leaflet - Welding units for shipbuilding		00	156124	
	Prospekt -DE- TEDAC Digital		00	156126	
	Leaflet - TEDAC Digital		00	160156	
	Leaflet - MobiARC 160 / 160 mobil		00	109680	
	Leaflet- Project Report Müller-Mitteltal		00	160154	

2 Catalogues:

	General catalogue GERMAN		00	129728	
	General catalogue ENGLISH		00	129730	
	Automation catalogue GERMAN		00	129732	
	Automation catalogue ENGLISH		00	129734	

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and delivery can be found on our website

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