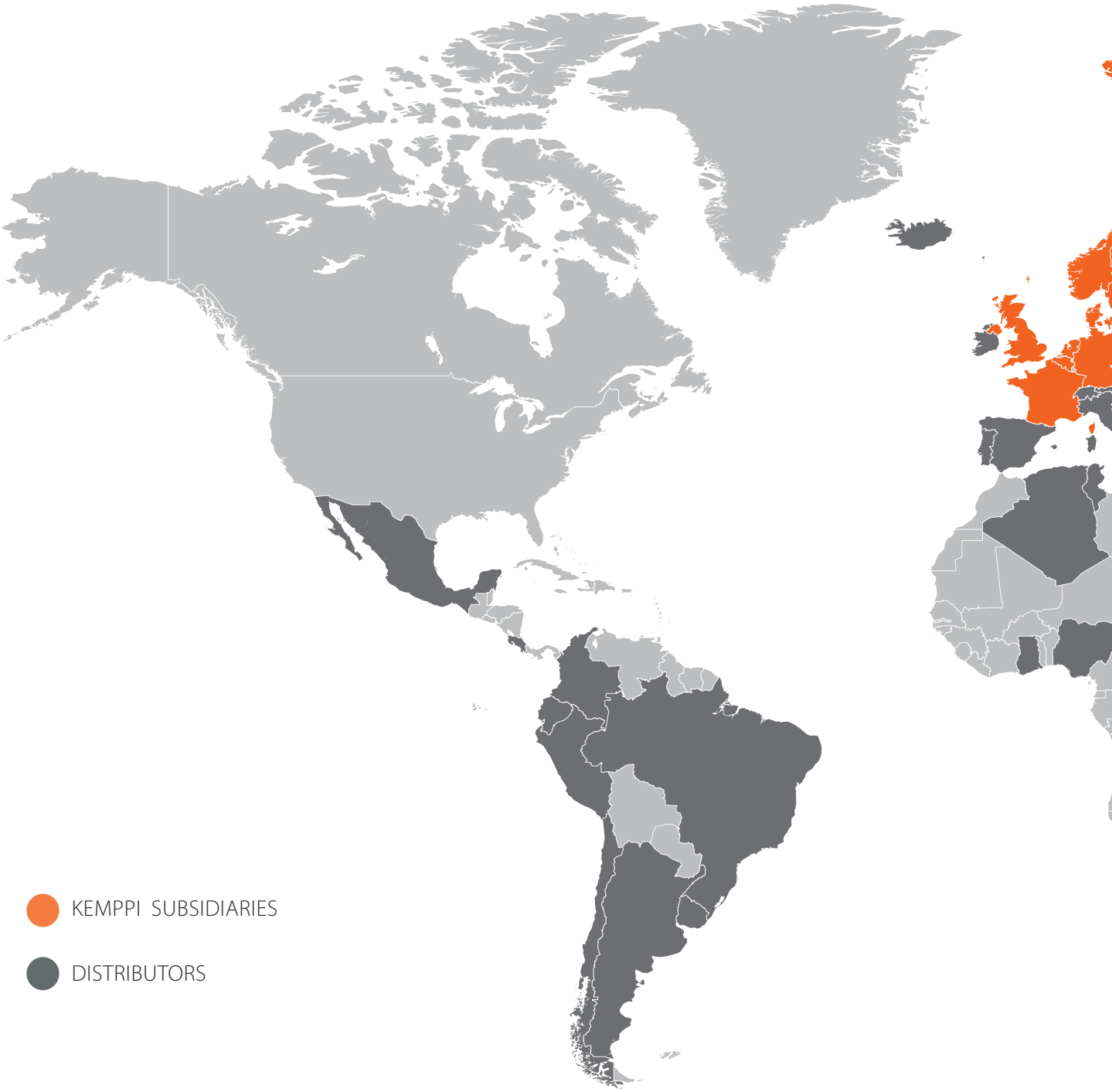
Manual welding

PRODUCT CATALOGUE

2020

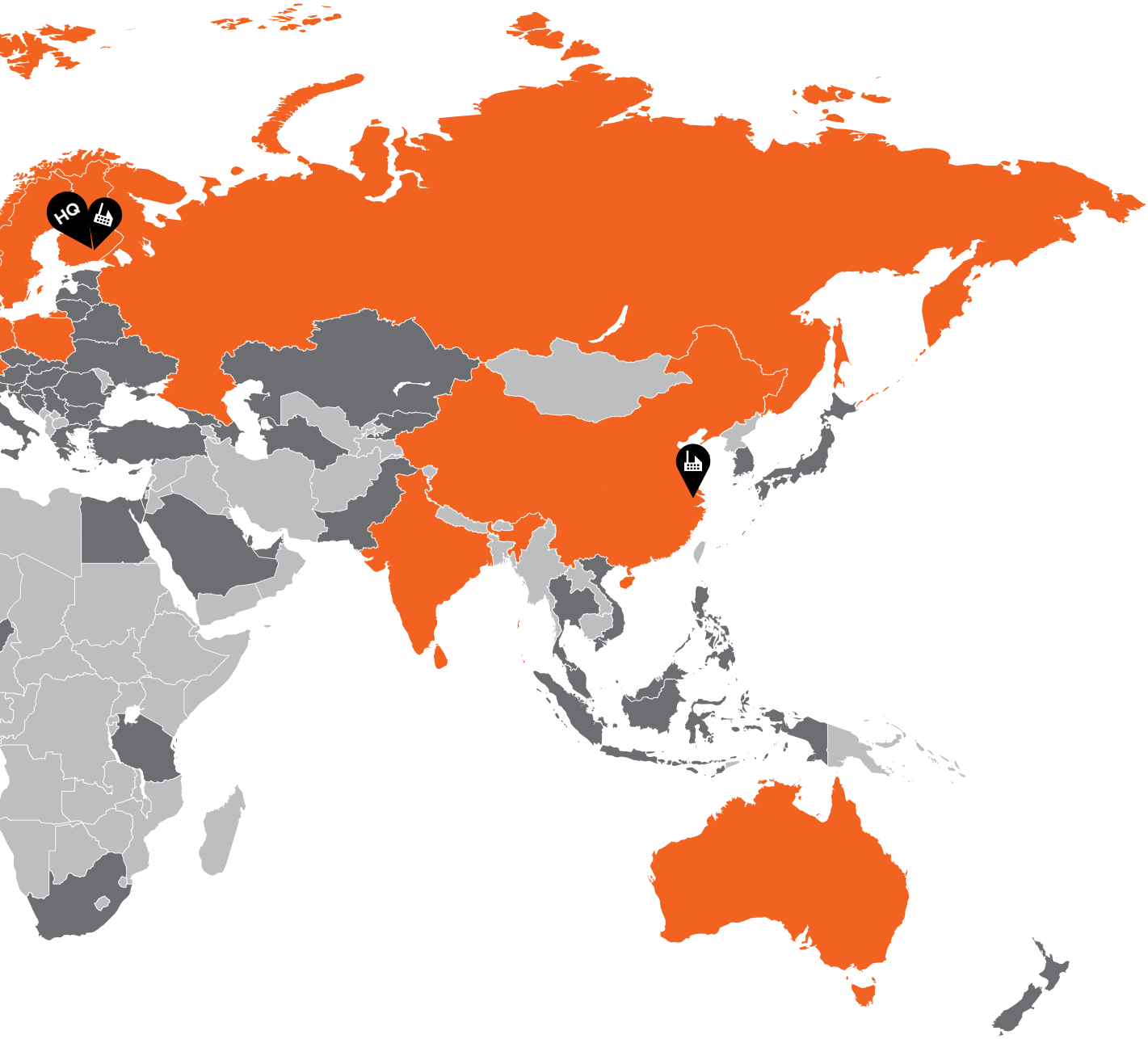
KEMPPI

Kemppi
Globally local



Kemppi business operates globally. The company headquarters and main production units are located in Finland. Kemppi sales organisations are established in Finland, Sweden, Norway, Denmark, Germany, France, United Kingdom, Netherlands, Poland, Russia, Australia, India and China. Kemppi also has representatives in more than 60 countries, responsible for country based product distribution, sales and customer service.

For a full list of Kemppi sales companies, distributors and dealers, visit www.kemppi.com



Special symbols


4-roll wire drive


2-roll wire drive


Water cooling option

Direct and pulsed current output

Supply frequency

Alternating, direct and pulsed current output

Constant voltage output

Constant current output

Constant current and constant voltage output

Requires single phase supply

Requires three phase supply

Multi-voltage unit


Energy efficient compared to alternative product options

Contents


K3
K5
K7
K8

Introduction

No matter your need, there is always a Kemppi solution for you. Our welding equipment is divided into value levels - K8, K7, K5 and K3 - in order to provide you with the most suitable equipment for your purposes. The higher the value level, the more features and functions you get in terms of performance, usability and modern connectivity.

K8 value level

With the K8 value level equipment we are creating tomorrow's welding today. Thanks to smart welding innovations, groundbreaking usability, and full connectivity, the K8 equipment lets you to perform, control and manage the welding production in a way that was not possible before.

K7 value level

The Kemppi K7 value level elevates the welding equipment to a whole new level of performance and intelligence. It offers a unique combination of refined control, advanced welding features, usability, and connectivity.

K5 value level

Kemppi's value level K5 equipment sets new standards for welding. Thanks to their uncompromised design, they convincingly meet all the expectations that are placed on the equipment of their class: versatility, ease of use, and application optimized performance with state-of-the-art technology.

K3 value level

Kemppi's K3 value level equipment features everything that Kemppi stands for - solid build quality and performance without compromises. K3 equipment provides fabricators with a smart investment route to increase efficiency and quality in a wide variety of welding jobs.


KEMPPI

MIG/MAG welding

Designed for the welders with an eye for quality, Kemppi MIG/MAG equipment keeps the technology on the inside, and simple, intuitive control and performance on the outside.

X8 MIG Welder

The future of welding is here

Energy efficient

3 Phase

MVU

- Best arc characteristics for high speed and aluminum (WiseFusion), narrow gap (RGT), root pass (WiseRoot+), thin sheet (WiseThin+) and low spatter welding in globular transfer mode (WiseSteel)
- Precisely controlled, upgradeable welding current up to 600 A
- Digital WPS feature allows the welder to quickly and easily access the WPSs
- Includes a fleet management service free of charge
- Native connectivity to WeldEye software modules Welding Procedure and Qualification Management, Welding Quality Management and Welding Production Analysis

Applications

- Oil rigs
- Process pipelines
- Pressure vessels and boilers

The most advanced multi-process welding equipment in the market

The X8 MIG Welder covers it all, from synergic and pulsed MIG/MAG and stick (MMA) welding to MIG brazing, cladding, and gouging.

The intelligent equipment provides you with extremely precise control of the arc, high-duty welding performance up to 600 A, and native connectivity with WeldEye welding management software. Supreme usability based on actual user needs is engineered in every aspect of the power source, wire feeder, welding guns, user interface, and other components.

Developed, designed and manufactured in Finland, the X8 MIG Welder introduces the digital WPS (dWPS) function, which improves quality control and renders the printed WPS unnecessary.

With an upgradeable power source, a multi-voltage power supply option, and the wide range of Kemppi application software available, the X8 MIG Welder adapts easily to any welding environment and meets even the most extreme expectations of industrial welding.

Extreme performance

Never underestimate the performance of the X8 MIG Welder. In addition to excellent standard welding performance, Kemppi's Wise special processes and functions ensure optimal arc characteristics for whatever you are welding. For example, WiseSteel reduces spatter by 30% and enables a 30% increase in travel speed in steel welding, while Reduced Gap Technology (RGT) allows the reduction of joint volume to bring 25% savings in filler materials and 38% savings in arc time with material thickness of 25 mm.

Supreme usability

High-quality welding requires careful preparation. When comparing the X8 MIG Welder with standard MIG welding equipment, its usability aspects in terms of innovative and user-friendly wire feeder, wireless user interface for power source and digital WPS speed up the setup configuration easily by 30%. When you can speed up the setup configuration process, you will have more time to focus on the welding itself.

Always the right parameters

Printed WPSs give all the necessary guidance for welding, but it's up to the welder to set the right parameters and weld accordingly. By utilizing Control Pad – the X8 MIG Welder's wireless user interface – to select the digital WPS (dWPS) via WeldEye, the power source is automatically set up according to the limits presented in the WPS. Faster setup and 100% certainty over WPS-compliant welding – what could be better?

X8 Wire Feeder

Innovatively designed wire feeder ensures safe and ergonomic loading of filler wire spool. Wire feeder and welding gun lighting enable working in dimly lit conditions.

By utilizing Control Pad – the X8 MIG Welder's wireless user interface – to select the digital WPS (dWPS) via WeldEye, the power source is automatically set up according to the limits presented in the WPS.

Well-balanced welding guns with an ergonomic handle design make welding more comfortable and productive.

An integrated cooling unit enables tool-free coolant filling.

My Fleet is a free-of-charge cloud service for X8 MIG Welder owners. It provides information on the equipment usage and software and includes the manufacturer's validation certificate for the first year.

Technical specifications

X8 MIG Welder		400 A	400 A MV	500 A
Mains connection cable	H07RN-F	6 mm²	16 mm²	6 mm²
Mains connection voltage 3~ 50/60 Hz		-	220 - 230 V ±10 %	-
Mains connection voltage 3~ 50/60 Hz		380 - 460 V ±10 %	380 - 460 V ±10 %	380 - 460 V ±10 %
Rated power	60 % ED	19 kVA	19 kVA	26 kVA
	100 % ED	14 kVA	14 kVA	18 kVA
Open circuit voltage (MMA)	Uav	50 V	50 V	50 V
Fuse	220 - 230 V	-	63 A	-
	380 - 460 V	32 A	32 A	32 A
Output	60 % ED	400 A	400 A	500 A
	100 % ED	320 A	320 A	400 A
Welding current and voltage range	MIG @ 220 V	-	20 A/14 V - 400 A/50 V	-
	MIG @ 380 V	20A/14V - 400A/50V	20 A/14 V - 400 A/50 V	20A/14V - 500A/55V
Welding current and voltage range	MMA @ 220 V	-	15 A/20 V - 400 A/58 V	-
	MMA @ 380 V	15A/20V - 400A/58V	15 A/20 V - 400 A/58 V	15A/20V - 500A/57V
Welding voltage (max)		58 V	58 V	57 V
Power factor at max current	P.F.	0.80 - 0.88	0.80 - 0.88	0.82 - 0.90
Efficiency at max current	η	89 - 91 %	89 - 90 %	89 - 91 %
Operating temperature range		-20…+40 °C	-20…+40 °C	-20…+40 °C
Storage temperature range		-40…+60 °C	-40…+60 °C	-40…+60 °C
EMC class		A	A	A
Degree of protection		IP23S	IP23S	IP23S
External dimensions LxWxH		921x348x795 mm	921 x 348 x 795 mm	921x348x795 mm
Weight without accessories		95 kg	95 kg	95 kg
Recommended generator power (min)	Sgen	25 kVA	25 kVA	35 kVA
Wireless communication type		2.4 GHz WiFi & Bluetooth	2.4 GHz WiFi & Bluetooth	2.4 GHz WiFi & Bluetooth
Wired communication type		Ethernet & USB	Ethernet & USB	Ethernet & USB
Standards		IEC 60974-1, -10	IEC 60974-1, -10	IEC 60974-1, -10

X8 Cooler	
Rated cooling power at 1 l/min	1.4 kW
Rated cooling power at 1.6 l/min	1.9 kW
Recommended coolant	MPG 4456 (Kemppi mixture)
Coolant pressure (max)	0.4 MPa
Tank volume	4 l
Operating temperature range *	-10…+40 °C
Storage temperature range	-40…+60 °C
EMC class	A
Degree of protection **	IP23S
Weight without accessories	15.5 kg
Standards	IEC 60974-2, -10
* With recommended coolant	
** When mounted	

Control Pad	
Operating temperature range	-20…+40 °C
Storage temperature range	-40…+60 °C
Degree of protection	IP54
External dimensions LxWxH	200 x 130 x 33 mm
Weight without accessories	0.89 kg
Typical battery operation time	15 - 24 h
Battery type	Li-ion
Rated battery voltage	7.2 V
Rated battery capacity	6.2 Ah
Typical battery charging time	5 h
Wireless communication type	2.4 GHz Bluetooth
Typical wireless communication range	15 m
Wired communication type	USB
Display type	TFT LCD
Display size	5.7 "
Standards	IEC 60950-1, EN 62368-1; EN 300 328 v2.1.1; EN 300 330 v2.1.1; EN 301 489-1 v2.1.1; EN 301 489-3 v2.1.0; EN 301 489-17 v3.1.1

Technical specifications

X8 MIG Welder		500 A MV	600 A	600 A MV
Mains connection cable	H07RN-F	16 mm²	6 mm²	16 mm²
Mains connection voltage 3~ 50/60 Hz		220 - 230 V ±10 %		220 - 230 V ±10 %
Mains connection voltage 3~ 50/60 Hz		380 - 460 V ±10 %	380 - 460 V ±10 %	380 - 460 V ±10 %
Rated power	60 % ED	26 kVA	27 kVA	27 kVA
	100 % ED	18 kVA	21 kVA	21 kVA
Open circuit voltage (MMA)	Uav	50 V	50 V	50 V
Fuse	220 - 230 V	63 A	-	63 A
	380 - 460 V	32 A	35 A	35 A
Output	60 % ED	500 A	530 A	530 A
	100 % ED	400 A	440 A	440 A
Welding current and voltage range	MIG @ 220 V	20A/14V - 500A/55V	-	20A/14V - 600A/46V
	MIG @ 380 V	20A/14V - 500A/55V	20A/14V - 600A/55V	20A/14V - 600A/55V
Welding current and voltage range	MMA @ 220 V	15A/20V - 500A/57V	-	15A/20V - 600A/46V
	MMA @ 380 V	15A/20V - 500A/57V	15A/20V - 600A/55V	15A/20V - 600A/55V
Welding voltage (max)		57 V	55 V	55 V
Power factor at max current	P.F.	0.82 - 0.90	0.88 - 0.90	0.90
Efficiency at max current	η	89 - 91 %	88 - 91 %	88 - 90 %
Operating temperature range		-20…+40 °C	-20…+40 °C	-20…+40 °C
Storage temperature range		-40…+60 °C	-40…+60 °C	-40…+60 °C
EMC class		A	A	A
Degree of protection		IP23S	IP23S	IP23S
External dimensions LxWxH		921x348x795 mm	921x348x795 mm	921x348x795 mm
Weight without accessories		95 kg	95 kg	95 kg
Recommended generator power (min)	Sgen	35 kVA	40 kVA	40 kVA
Wireless communication type		2.4 GHz WiFi & Bluetooth	2.4 GHz WiFi & Bluetooth	2.4 GHz WiFi & Bluetooth
Wired communication type		Ethernet & USB	Ethernet & USB	Ethernet & USB
Standards		IEC 60974-1, -10	IEC 60974-1, -10	IEC 60974-1, -10

X8 Wire Feeder					
Welding current, I2	40 % ED	600 A	Wire feed speed		0.5 - 25 m/min
	60 % ED	530 A	Wire spool weight (max)		20 kg
	100 % ED	440 A	Wire spool diameter (max)		300 mm
Gun connection		Kemppi	Shielding gas pressure (max)	pmax	0.5 MPa
Wire feed mechanism		4-roll, twin-motor	Operating temperature range		-20…+40 °C
Diameter of feed rolls		32 mm	Storage temperature range		-40…+60 °C
Filler wires	Fe	0.6 - 2.4 mm	EMC class		A
	Ss	0.6 - 2.4 mm	Degree of protection		IP23S
	MC/FC	0.8 - 2.4 mm	External dimensions LxWxH		640 x 220 x 400 mm
	Al	0.8 - 2.4 mm	Weight without accessories		11.2 kg
			Wireless communication type		2.4 GHz Bluetooth
			Standards		IEC 60974-5, 10

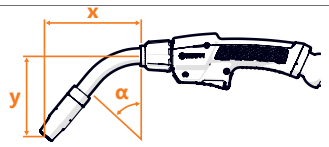
Ordering information

X8 Power Source (includes Control Pad, X8 Wheel Set and X8 Wire Feeder Rotating Plate)		
X8 Power Source without software		
X8 Power Source 400		X8100400000
X8 Power Source 400 with cooler		X8100401000
X8 Power Source 500 with cooler		X8100501000
X8 Power Source 500 MV with cooler		X8100501100
X8 Power Source 600 with cooler		X8100601000
X8 Power Source 600 MV with cooler		X8100601100
X8 Power Source with welding programs and processes, contains X8 Work Pack and WiseFusion (free of charge)		
X8 Power Source 400, CUSTOM		X8100400001
X8 Power Source 400 with cooler, CUSTOM		X8100401001
X8 Power Source 400 MV, CUSTOM		X8100400101
X8 Power Source 500 with cooler, CUSTOM		X8100501001
X8 Power Source 500 MV with cooler, CUSTOM		X8100501101
Wire Feeder		
X8 Wire Feeder *		X8200000002
X8 Wire Feeder with cabinet heater		X8200000001
* Contains GH 20 Gun holder		
X8 Power upgrade		
Power upgrade 500 for X8 Power Source		X8550000
Power upgrade 600 for X8 Power Source		X8560000
Software products		
WiseFusion		X8500000
WiseSteel		X8500001
WisePenetration+		X8500002
WiseRoot+		X8500003
WiseThin+		X8500004
X8 Work Pack		X8520000
Welding programs and packages are available in DataStore via Mobile Maintenance app.		
WeldEye WP & PQ cloud package		6800010
X8 accessories and spare parts		
X8 Cooler		X8600000000
X8 Wheel Set		X8701010000
X8 Gas Cylinder Cart		X8701020000
Wire Feeder Rotating Plate		X8702010000
Double Wire Feeder Rotating Plate *		X8702020000
Wire Feeder Counterbalance Arm		X8702030000
Wire Feeder Hanger For Boom		X8702040000
X8 Cable Rack **		X8701030000
X8 Accessory Tray		X8701040000
Control Pad		X8400110001
Wire Drum Kit	5 m	W012757
Wire Drum Kit	10 m	W012758
Wire Drum Kit	20 m	W012759
Wire Drum Kit	27 m	W012760

* – X8 Double Wire Feeder Rotating Plate is not compatible with X8 Wire Feeder Counterbalance Arm.
** – Mount X8 Cable rack to the front when used with X8 Gas cylinder cart.

Ordering information

Guns			
Flexlite GX 208 G MN 3,5M	3.5 m	x=101 mm, Y=86 mm	GX208GMN35
Flexlite GX 208 G MN 5M	5.0 m	x=101 mm, Y=86 mm	GX208GMN5
Flexlite GX 308 G MN 3,5M	3.5 m	x=117 mm, Y=97 mm	GX308GMN35
Flexlite GX 308 G MN 5M	5.0 m	x=117 mm, Y=97 mm	GX308GMN5
Flexlite GX 408 G MN 3,5M	3.5 m	x=132 mm, Y=110 mm	GX408GMN35
Flexlite GX 408 G MN 5M	5.0 m	x=132 mm, Y=110 mm	GX408GMN5
Flexlite GX 428 W 3,5M	3.5 m	x=132 mm, Y=104 mm	GX428W35
Flexlite GX 428 W 5M	5.0 m	x=132 mm, Y=104 mm	GX428W5
Flexlite GX 528 W 3,5M	3.5 m	x=145 mm, Y=111 mm	GX528W35
Flexlite GX 528 W 5M	5.0 m	x=145 mm, Y=111 mm	GX528W5
Flexlite GX 428 W 3,5M N 250	3.5 m	x=232 mm, Y=104 mm	GX428W35N250
Flexlite GX 428 W 5M N 250	5.0 m	x=232 mm, Y=104 mm	GX428W5N250
Flexlite GX 428 WS	8.0 m	x=132 mm, Y=104 mm	GX428WS8
Flexlite GX 528 W 3,5M N 250	3.5 m	x=245 mm, Y=111 mm	GX528W35N250
Flexlite GX 528 W 5M N 250	5.0 m	x=245 mm, Y=111 mm	GX528W5N250
Flexlite GX 608 W	5.0 m	x=152 mm, Y=104 mm	GX608W5
Mounting Ring Tool			SP012703



Cables		
Earth return cable	5 m, 70 mm^2	6184711
Earth return cable	10 m, 70 mm^2	6184712
Interconnection cables, gas-cooled		
Interconnection Cable 70-g	5 m	X8801700500
Interconnection Cable 70-g	10 m	X8801701000
Interconnection Cable 70-g	20 m	X8801702000
Interconnection Cable 70-g	30 m	X8801703000
Interconnection Cable 95-g	2 m	X8801950200
Interconnection Cable 95-g	5 m	X8801950500
Interconnection Cable 95-g	10 m	X8801951000
Interconnection Cable 95-g	20 m	X8801952000
Interconnection Cable 95-g	30 m	X8801953000
Interconnection cables, water-cooled		
Interconnection Cable 70-w	5 m	X8800700500
Interconnection Cable 70-w	10 m	X8800701000
Interconnection Cable 70-w	20 m	X8800702000
Interconnection Cable 70-w	30 m	X8800703000
Interconnection Cable 95-w	2 m	X8800950200
Interconnection Cable 95-w	5 m	X8800950500
Interconnection Cable 95-w	10 m	X8800951000
Interconnection Cable 95-w	20 m	X8800952000
Interconnection Cable 95-w	30 m	X8800953000
Remote controls		
GXR80 Gun Remote With Display		GXR80

For the ordering codes of consumables for the guns and wire feeder, see Kemppi Consumable Kit Selector.

X8 SuperSnake

Next-level productivity within your reach

- Suitable for Fe/Ss/Al/FCW/MCW filler wires
- 10-, 15-, 20-, 25-meter water-cooled models
- Parameter adjustment with the X8 Control Pad or X8 Gun Remote Control
- Supports all Kemppi Wise special processes
- Strong protective frame included as standard

Applications

- Heavy and medium-heavy metal fabrication workshops
- Installation and site work

Extreme extension

The X8 SuperSnake combines the outstanding benefits of the original SuperSnake sub-feeder with the X8 MIG Welder's modern technology and precise arc control. Available in water-cooled models that extend your regular reach with up to 25 meters, the X8 SuperSnake guarantees reliable distance wire feed, durable use and effortless maintenance.

The lightweight sub-feeder is easy to carry to wherever it is needed. Not only does this improve occupational safety by removing the need to carry heavy wire feeders, but it also improves productivity. By connecting the X8 Control Pad to the sub-feeder, the welder has access to a comprehensive user interface to make all the necessary parameter adjustments at a distance from the welding system.

The X8 SuperSnake is compatible with X8 Wire Feeders and X8 MIG Guns. The connection is established with Kemppi Gun Connectors that are known for their excellent mechanical and electrical properties and precise arc voltage measurement. New technology enables support for Kemppi's Wise special processes and ensures optimal arc characteristics in any welding application.

Technical specifications

X8 SuperSnake	
Output 40°C 60% ED	310 A
Wire feed mechanism	GT02X, 2-roll
Wire feed speed	0-25 m/min
Feeder body dimensions L x W x H	777 x 142 x 142 mm
Wire recommendations, 15 m	Fe/Ss 1.0-1.6 mm
	Al 1.2-1.6 mm
	FeMc/FeFc 1.2-1.6 mm
Cable diameter	50 mm2
Supply voltage	50 V DC
Protection class	IP 23S

The X8 SuperSnake features a two-roll version of the X8 Wire Feeder's powerful wire feed mechanism with firm locking. The consumables are interchangeable, and color-coded to ensure that you always use the correct combination.

Ordering information

X8 SuperSnake water-cooled	
GT02XW 10 m Fe	X8900501000
GT02XW 10 m Ss/Al	X8900501001
GT02XW 15 m Fe	X8900501500
GT02XW 15 m Ss/Al	X8900501501
GT02XW 20 m Fe	X8900502000
GT02XW 20 m Ss/Al	X8900502001
GT02XW 25 m Fe	X8900502500
GT02XW 25 m Ss/Al	X8900502501

Wire guide tubes	
Fe/FeMc/FeFc, metalli	SP014826
Al/Ss, DL Chili	SP015060

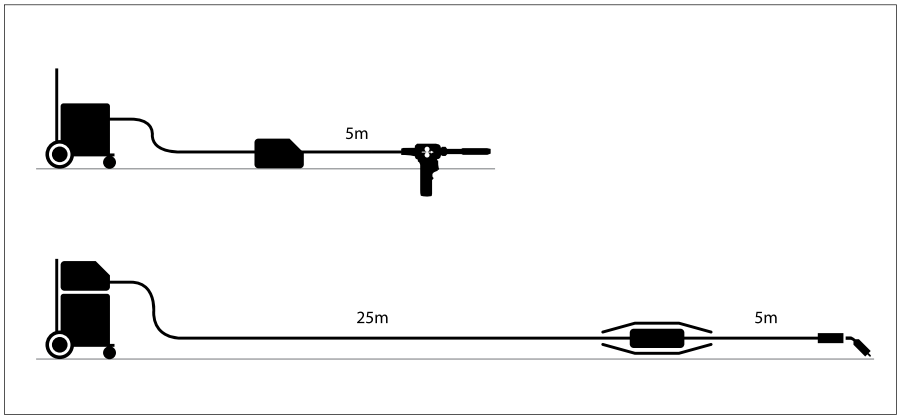
Parameter adjustments are easy to make on the X8 Control Pad's clear and large display.

Wire liners for X8 SuperSnake

Steel spirals Fe/FeMc/FeFc	Filler wire ø, mm	Order number, 10 m	Order number, 15 m	Order number, 20 m	Order number, 25 m
	1.0…1.6	W015509	W015511	W015513	W015515
DL liners Al / Ss	**Filler wire ø, mm**	**Order number, 10 m**	**Order number, 15 m**	**Order number, 20 m**	**Order number, 25 m**
DL Chili 5.9/1.5	1.0…1.6	W015510	W015512	W015514	W015516

Spare part Steel spirals and DL Chili liners are equipped with connectors. Both ends are locked in position in cable package set/subfeeder.

The lightweight sub-feeder is an ergonomic option for carrying heavy and large wire feeders, or welding with heavy push-pull welding guns that increase strain on the welder's wrist.



The protective frame and base plate are included as standard for maximum protection in even the toughest workshop conditions.

FastMig X Welding excellence

Energy efficient

- Multi-process power solution: MIG, 1-MIG, pulsed MIG, MMA, and TIG
- Arc Mobile Control brings flexible way to use and control the welding machine
- WiseRoot+ for optimized root welding
- WiseThin + for optimized sheet and position welding: Mixed gas quality with lower cost CO_2 shielding gas
- Precise arc voltage function measures and shows the actual arc voltage on the display
- Save time by combining two wire feeders on the same power source for alternative filler wires
- SuperSnake subfeeder connectivity for maximum reach

Applications

- Machine manufacturing
- Transportation
- Oil & gas sector: Offshore and onshore pipelines & rigs
- Power Industry
- Tanks & pressure vessels
- Steel structures

Intelligent, flexible, upgradable

Kemppi's FastMig X product series offers highly specialized welding solutions and superior welding quality for demanding industrial applications. It features three alternative high-end configuration recommentations for three different purposes: FastMig X Regular for robust workshop use a MIG/MAG pulse welding, mainly for welding thick plates, FastMig X Pipe for pipe and root welding and FastMig X Intelligent for demanding welding applications, for all metals and processes, including welding of thin sheets.

All three configuration options are fully upgradable and can be optimized for specific welding applications by choosing suitable software packages and applications.

All configurations are equipped with either the FastMig X 350 or the FastMig X 450 power source, which is a multi-process CC/CV power source that is ideal for synergic and pulsed MIG/MAG welding, MMA welding, and TIG welding. Used in configuration with WFX wire feeders, they form a welding system that easily meets every welding need and the quality management requirements of any metal fabrication workshop. Additionally, all three configurations come with the Cool X cooling unit.

FastMig X series is highly versatile. For example, it enables you to connect two wire feeders, allowing a very rapid change in welding processes, filler wire type, and wire size. The Wise solutions provide further flexibility for specific welding applications: for example, WiseRoot+ meets the special requirements of root welding, and exact arc voltage measurement provides easy and precise control of the device. Arc voltage measurement (available in all FastMig X models) ensures that the set WPS parameters are always kept, regardless of the length of the welding cables. Depending on your needs, you have the option to use and upgrade any of the software packages 1, 2 or 3, each packed with more features and functions.

The system is designed to fulfil the strict demands of the ISO 3834, NORSOK, ASME, and EN 1090 manufacturing standards. Combine your FastMig X welding quality and Kemppi's state-of-the-art quality management solutions to meet the highest welding standards in your production.

Software package 1 *Software package 2* *Software package 3 & Mobile Control*

FastMig X **Regular**

- Basic Pulse MIG/MAG welding
- Robust thick metal plates

FastMig X **Pipe**

- Specially designed for pipe welding
- Also suitable for plates, root welding from one side

FastMig X **Intelligent**

- For any metal and process
- Also for thin sheet
- Copy-paste settings from one welding machine to another
- Monitor, control, and adjust welding parameters and settings

FastMig X, WFX 200, 300, -AMC, -P

Ordering information

FastMig X		
FastMig X 450 power source		6103450
FastMig X 450 power source	No control panel	610345001
FastMig X 350 power source		6103350
FastMig X 350 power source	No control panel	610335001
FastMig X 350MV power source		6103353
WFX 200 wire feeder*	200 mm	6103520
WFX 300 wire feeder*	300 mm	6103530
WFX 200 P Fe wire feeder*	200 mm	6103521
WFX 200 P Ss wire feeder*	200 mm	6103522
WFX 300 P Fe wire feeder*	300 mm	6103531
WFX 300 P Ss steel wire feeder*	300 mm	6103532
WFX 200 AMC wire feeder*	200 mm	6103523
WFX 300 AMC wire feeder*	300 mm	6103533
WFX 200-T wire feeder *	200 mm	6103524
WFX 300-T wire feeder *	300 mm	6103534
WFX 300 P-T wire feeder *	300 mm	6103535

* Including WisePulseMig license and MMA process.

Software products		
MatchLog function	Included with WFX 200 & 300 AMC	9991017
MatchChannel function	Included with MatchLog licence	
WisePulseMig licence for pulse welding	Included with all WFX feeders	9990417
WiseFusion function	Included with all WFX feeders excluding T versions	9991014
WisePenetration function	Included with WFX 200 & 300 AMC	9991000
Steel welding program package	Included with WFX 200 & 300 P steel	99904274
Stainless steel welding program package	Included with WFX 200 & 300 P stainless	99904275
WiseRoot+ function	Included with WFX 200 & 300 P	9990418
WiseThin+ function	Included with WFX 200 & 300 AMC	9990419

NOTE: WiseRoot+ and WiseThin+ welding processes are not available with SuperSnake sub feeder.

Cables		
Earth return cable	5 m, 50 mm^2	6184511
Earth return cable	5 m, 70 mm^2	6184711
MMA welding cable	5 m, 50 mm^2	6184501
MMA welding cable	5 m, 70 mm^2	6184701

Interconnection cables, air-cooled		
FASTMIG X 70-1.8-GH	1.8 m	6260468
FASTMIG X 70-5-GH	5 m	6260469
FASTMIG X 70-10-GH	10 m	6260470
FASTMIG X 70-20-GH	20 m	6260471
FASTMIG X 70-30-GH	30 m	6260472

– For other lengths, please contact Kemppi.

Interconnection cables, liquid-cooled		
FASTMIG X 70-1.8-WH	1.8 m	6260473
FASTMIG X 70-5-WH	5 m	6260474
FASTMIG X 70-10-WH	10 m	6260475
FASTMIG X 70-20-WH	20 m	6260476
FASTMIG X 70-30-WH	30 m	6260477

– For other lengths, please contact Kemppi.

Remote controls		
GXR Gun Remote		GXR10
Remote control unit R20	5 m	6185419
Remote control unit R30 DataRemote	5 m	6185420
Remote control unit R30 DataRemote	10 m	618542001
Remote control extension cable	10 m	6185481
Remote X 37 control panel		6103800

FastMig X, WFX 200, 300, -AMC, -P

Ordering information

FastMig X	Regular	Pipe	Intelligent
Power source	FastMig X 350, FastMig X 450	FastMig X 350, FastMig X 450	FastMig X 350, FastMig X 450
Wire feeder	WFX 200	WFX 200 P Fe, WFX 200 P Ss	WFX 200 AMC
	WFX 300	WFX 300 P Fe, WFX 300 P Ss	WFX 300 AMC
Cooling unit	Cool X	Cool X	Cool X
Welding process	MMA	MMA	MMA
	MIG/MAG	MIG/MAG	MIG/MAG
	Syn MIG	Syn MIG	Syn MIG
	Pulse MIG	Pulse MIG (included Pipe stainless pack)	Pulse MIG
	Double Pulse	Double Pulse (included Pipe stainless pack)	Double Pulse
Software	WiseFusion	Wise Fusion	WiseFusion
		WiseRoot+	WisePenetration
		Match Log	WiseThin+
			Match Log
	WorkPack (21 pcs)	Pipe Steel pack Fe (25 pcs)	Steel Pack (14 pcs)
		Pipe Stainless steel pack Ss (17 pcs)	Steel Pack for WiseThin+ (8 pcs)
			Stainless steel Pack (12 pcs)
			Aluminium Pack (12 pcs)
Mobile Control			Arc Mobile Control

Accessories		
Cooling unit Cool X		6068200
Arc Mobile Control Adapter	Included with WFX 200 / 300 AMC	6103100
Cabinet heater KWF 200/300		6185288
Magnetic clamp (earth return cable)	600 A	9871570
Magnetic clamp (voltage sensing cable)	200 A	9871580
SuperSnake GT02S sub feeder	10 m	6153100
SuperSnake GT02S sub feeder	15 m	6153150
SuperSnake GT02S sub feeder	20 m	6153200
SuperSnake GT02S sub feeder	25 m	6153250
SuperSnake GT02S W sub feeder	10 m	6154100
SuperSnake GT02S W sub feeder	15 m	6154150
SuperSnake GT02S W sub feeder	20 m	6154200
SuperSnake GT02S W sub feeder	25 m	6154250
SuperSnake GT02S sub feeder synchronization unit for MXF and WFX wire feeders		W004030
KV 200 mounting plate for two wire feeders and TIG unit		6185249
Gun holder GH 30		6256030
Transport unit PM 500		6185291
Software installation device DataGun		6265023

FastMig X, WFX 200, 300, -AMC, -P

Technical specifications

FastMig X		**350**	**450**	**350MV – 230 V range**	**350MV – 400 V range**
Connection voltage	3~50/60 Hz	400 V (-15…+20 %)	400 V, -15…+20 %	220 V -10% … 230 V +10%	380 V -10% ... 440 V +10%
Rated power	60 % ED		22.1 kVA		
	80 % ED	16.0 kVA		16.0 kVA	16.0 kVa
	100 % ED	15.3 kVA	16.0 kVA	15.3 kVA	15.3 kVa
Output 40 °C	60 % ED		450 A	-	-
	80 % ED	350 A		350 A	350 A
	100 % ED	330 A	350 A	330 A	330 A
Welding current and voltage range	MMA	15 A/20 V – 350 A/46 V	15 A/20 V – 450 A/46 V	15 A/20 V – 350 A/46 V	15 A/20 V – 350 A/46 V
	MIG	20 A/12 V – 350 A/46 V	20 A/12 V – 450 A/46 V	20 A/12 V – 350 A/46 V	20 A/12 V – 350 A/46 V
Max. welding voltage MMA		46 V	46 V	46 V	46 V
Open circuit voltage	MMA	U0 = 70 – 98 V, Uav = 50 V	U_0 = 70 – 98 V, U_{av} = 50 V	U_0 = 70 – 98 V, U_{av} = 50 V	U_0 = 70 – 98 V, U_{av} = 50 V
	MIG/MAG, Pulse	U0 = 80 – 98 V	U_0 = 80 – 98 V	U_0 = 80 – 98 V	U_0 = 80 – 98 V
Open circuit power		100 W	100 W	100 W	100 W
Power factor at max. current		0.85	0.88	0.90	0.88 ... 0.82
Efficiency at max. current		87 %	87 %	83 %	85 %
Operating temperature range		-20…+40 °C	-20…+40 °C	-20…+40 °C	-20…+40 °C
Storage temperature range		-40…+60 °C	-40…+60 °C	-40…+60 °C	-40…+60 °C
EMC class		A	A	A	A
Degree of protection		IP23S	IP23S	IP23S	IP23S
External dimensions	L x W x H	590 x 230 x 430 mm	590 x 230 x 430 mm	590 x 230 x 580 mm	590 x 230 x 580 mm
Weight		38 kg	38 kg	49 kg	49 kg
Suitable for generator use					

FastMig X, WFX 200, 300, -AMC, -P

Technical specifications

WFX 300 / 300 AMC		
Output 40 °C	60 % ED	520 A
	100 % ED	440 A
Wire feed speed		1 – 25 m/min
Wire feed mechanism		DuraTorque
Diameter of feed rolls		32 mm
Filler wires	ø Fe, Ss	0.6 – 1.6 mm
	ø Cored wire	0.8 – 2.0 mm
	ø Al	0.8 – 2.4 mm
Wire spool	max. weight / max. ø	20 kg / 300 mm
External dimensions	L x W x H	625 x 243 x 476 mm
Weight		12.5 kg

WFX 200 / 200 AMC / WFX 200 P (Fe and Ss)		
Output 40 °C	60 % ED	520 A
	100 % ED	440 A
Wire feed speed		1 – 25 m/min
Wire feed mechanism		4 roll
Diameter of feed rolls		32 mm
Filler wires	ø Fe, Ss	0.6 – 1.6 mm
	ø Cored wire	0.8 – 2.0 mm
	ø Al	0.8 – 2.4 mm
Wire spool	max. weight / max. ø	5kg / 200 mm
External dimensions	L x W x H	510 x 200 x 310 mm
Weight		9.4 kg

WFX 300 P (Fe and Ss)		
Output 40 °C	60 % ED	520 A
	100 % ED	440 A
Wire feed speed		0.5 – 25 m/min
Wire feed mechanism		GT04
Diameter of feed rolls		32 mm
Filler wires	ø Fe, Ss	0.6 – 2.0 mm
	ø Cored wire	0.8 – 2.4 mm
	ø Al	0.8 – 2.4 mm
Wire spool	max. weight / max. ø	20 kg / 300 mm
External dimensions	L x W x H	590 x 240 x 445 mm
Weight		13.1 kg

FastMig M

Proven reliability from the top of welding technology

Energy efficient

3 Phase

MVU

CV CC

- Modular design
- Two package options: Regular and Synergic
- Multi-voltage power supply version available
- WiseFusion™ option for easy and efficient welding out of position
- All Wise™ optimisation products
- MasterTig LT 250 and ArcFeed connection in power source with optional AS kit
- SuperSnake sub feeder for extended reach
- MagTrac F 61 welding carriage for improved productivity

Applications

- Offshore and shipyards
- Metal workshops
- Construction

Top welding performance for industrial MIG/MAG welding

Welding equipment optimised to your production

FastMig M series is a combination of modularity, ease of use and wide range of usage.

These machines pack huge duty cycle performance into compact lean dimensions and weight, increasing productivity and work site mobility.

In industrial MIG/MAG welding, FastMig M is the well known high-technology alternative. Its control technology ensures excellent arc ignition and welding performance, so you spend more time welding and less time removing spatter.

There are two product package options from which you can select the optimal for your welding application: the synergic package for demanding advanced use, and the regular one for basic use.

Whenever your application changes, you can update your FastMig M setup to go along with your production needs.

Boost your welding performance with auxiliary options

Take a step onto a new level of welding productivity: Combine the welding power of your FastMig M with the speed and reliability of Kemppi's MagTrac F 61 welding carriage.

To take the welding productivity one step further, you can combine your FastMig M and MagTrac F 61 setup with the WiseFusion welding optimisation function. This is a welding combination that delivers quality welds with a very low heat input, resulting in significant reduction in straightening and other after work costs. It has been calculated that this solution can reduce your after work costs by up to 20 %.

Furthermore, the FastMig M solution offers a wide selection of remote control devices to make the welder's work more efficient and productive. And if you need more reach, you can connect the SuperSnake subfeeder, which gives you up to 30 meters wider work range.

FastMig M is a strong and reliable workhorse no matter which package you choose: Regular or Synergic.

You can choose either regular or synergic way of controlling the welding parameter values on your machine. Both control modes are available for any power source and wire feeder combination.

You can choose your wire feeder and control panel combination according to your present welding needs, and if your application changes later on, you can always refresh your FastMig M system with new power levels, wire feeder options and welding software.

Choice of wire feeders

You have a choice of three wire feeder models to go with your Regular or Synergic FastMig M package.

FastMig MXF 63 is a small and light version for 200 mm wire spools, whereas MXF 65 and MXF 67 models fit 300 mm wire spools. FastMig MXF 67 has an extra strong dual-skin plastic casing.

Both regular and synergic control panel options are available for all wire feeder models.

You can choose from three different wire feeder options for FastMIg M.: ***MXF 65****,* ***MXF 67*** *and* ***MXF 63,*** *from left to right****.***

Regular FastMig M packages contain an MR control panel, representing the regular way of controlling the welding parameters. This package is suitable for basic welding applications in professional industrial welding.

Synergic FastMig M packages contain an MS control panel, which includes easy-to-use synergic functionality and a rich selection of additional features for optimising your welding work. These packages are suitable for professional use in more demanding industrial applications.

FastMig M	Regular	Synergic
Power source	FastMig M 320	FastMig M 320
	FastMig M 420	FastMig M 420
	FastMig M 520	FastMig M 520
	FastMig M 420MV	FastMig M 420MV
Wire feeder	MXF 65	MXF 65 EL
	MXF 67	MXF 67 EL
	MXF 63	MXF 63 EL
Cooling unit	FastCool 10	FastCool 10
Panels	FastMig MR 200	FastMig MS 200
	FastMig MR 300	FastMig MS 300
Optional Software		WiseFusion
		WisePenetration
		WiseRoot
		WiseThin
		MatchLog
		MatchPIN

FastMig M

Technical specifications

		FastMig M 320	FastMig M 420	FastMig M 520
Connection voltage	3~, 50/60 Hz	400 V -15 %...+20 %	400 V -15 %...+20 %	400 V -15 %...+20 %
Rated power	60 % ED	-	20 kVA	27 kVA
	100 % ED	15 kVA	18 kVA	20 kVA
Output 40 °C	60 % ED	-	420 A	520 A
	100 % ED	320 A	380 A	430 A
Welding current and voltage range	MMA	15 A/20 V – 320 A/45 V	15 A/20 V – 420 A/44 V	15 A/20 V – 520 A/43 V
	MIG	20 A/12 V – 320 A/45 V	20 A/12 V – 420 A/44 V	20 A/12 V – 520 A/43 V
Max. welding voltage		45 V	45 V	45 V
Open circuit voltage MMA		U_0 = 48 – 53 V U_{av} = 50 V	U_0 = 48 – 53 V U_{av} = 50 V	U_0 = 48 – 53 V U_{av} = 50 V
Open circuit voltage MIG/MAG		U_0 = 50 – 58 V	U_0 = 50 – 58 V	U_0 = 50 – 58 V
Idle power		25 W	25 W	25 W
Efficiency at max. current		88 %	89 %	89 %
Power factor at max. current		0.80	0.87	0.90
Operating temperature range		-20 ... +40 °C	-20 ... +40 °C	-20 ... +40 °C
Storage temperature range		-40 ... +60 °C	-40 ... +60 °C	-40 ... +60 °C
Degree of protection		IP23S	IP23S	IP23S
EMC class		A	A	A
External dimensions		590 x 230 x 430 mm	590 x 230 x 430 mm	590 x 230 x 430mm
Weight		34 kg	35 kg	36 kg

		FastMig M 420MV – 400 V range	FastMig M 420MV – 230 V range
Connection voltage	3~, 50/60 Hz	380 V -10% ... 440 V +10%	220 V -10 % ... 230 V +10 %
Rated power	60 % ED	22kVa	21 kVa
	100 % ED	19 kVa	18 kVA
Output 40 °C	60 % ED	420 A	420 A
	100 % ED	380 A	380 A
Welding current and voltage range	MMA	15 A/20 V ... 420 A/44 V	15 A/20 V ... 420 A/48 V
	MIG	20 A/12 V ... 420 A/44 V	20 A/12 V ... 420 A/48 V
Max. welding voltage		44 V	48 V
Open circuit voltage MMA		U0 = 48 ... 53 V Uav = 50 V	U0 = 48 ... 53 V Uav = 50 V
Open circuit voltage MIG/MAG		U0 = 53 ... 58 V	U0 = 60 ... 65 V
Idle power		25 W	25 W
Efficiency at max. current		87 %	87 %
Power factor at max. current		0.82	0.85
Operating temperature range		-20 ... +40 °C	-20 ... +40 °C
Storage temperature range		-40 ... +60 °C	-40 ... +60 °C
Degree of protection		IP23S	IP23S
EMC class		A	A
External dimensions		590 x 230 x 580 mm	590 x 230 x 580 mm
Weight		49 kg	49 kg

FastMig M

Technical specifications

		FastMig MXF 63	FastMig MXF 65	FastMig MXF 67
Output 40 °C	60 % ED	520 A	520 A	520 A
	100 % ED	440 A	440 A	440 A
Wire feed speed		0 – 25 m/min	0 – 25 m/min	0 – 25 m/min
Wire feed mechanism		4-roll	4-roll	4-roll
Diameter of feed rolls		32 mm	32 mm	32 mm
Filler wires	ø Fe, Ss	0.6 – 1.6 mm	0.6 – 1.6 mm	0.6 – 1.6 mm
	ø Cored wire	0.8 – 1.6 mm	0.8 – 2.0 mm	0.8 – 2.0 mm
	ø Al	1.0 – 1.6 mm	1.0 – 2.4 mm	1.0 – 2.4 mm
Wire spool	max. weight / max. ø	5 kg / 200 mm	20 kg / 300 mm	20 kg / 300 mm
External dimensions	L x W x H	510 x 200 x 310 mm	620 x 210 x 445 mm	625 x 243 x 476 mm
Weight		9.4 kg	11.1 kg	12.5 kg

Ordering information

Power sources		
FastMig M 320		6132320
FastMig M 420		6132420
FastMig M 520		6132520
FastMig M 420MV		6132423
Wire feeders		
MXF 65 EL	To be used with MS panels	6152100EL
MXF 67 EL	To be used with MS panels	6152200EL
MXF 63 EL	To be used with MS panels	6152300EL
MXF 65	To be used with MR panels	6152100
MXF 67	To be used with MR panels	6152200
MXF 63	To be used with MR panels	6152300
Panels for wire feeders		
FastMig MR 200	Regular panel	6136100
FastMig MR 300	Regular panel	6136200
FastMig MS 200	Synergic panel	6136300
FastMig MS 300	Synergic panel	6136400
Accessories		
Earth return cable	5 m, 50 mm^2	6184511
Earth return cable	5 m, 70 mm^2	6184711
Cable for MMA welding	5 m, 50 mm^2	6184501
Cable for MMA welding	5 m, 70 mm^2	6184701
Remote control unit R10	5m	6185409
Remote control unit R10	10m	618540901
Remote control unit R20	5m	6185419
R30 DataRemote	5m	6185420
R30 DataRemote	10m	618542001
GXR10 Gun Remote		GXR10
Remote control cable	10m	6185481
AS KIT including panel		6264263
Cooling unit FastCool 10		6068100
Gun holder GH 30		6256030
KV 401 Swing boom arm (PM 500)		6185248
GG200/300 gas guard		6237406
MXFSuperSnake synchronisation kit		W004030

Interconnection cable, gas-cooled	1.8 m, 70 mm^2	6260401
Interconnection cable, gas-cooled	5 m, 70 mm^2	6260405
Interconnection cable, gas-cooled	10 m, 70 mm^2	6260326
Interconnection cable, gas-cooled	15 m, 70 mm^2	6260325
Interconnection cable, gas-cooled	20 m, 70 mm^2	6260327
Interconnection cable, gas-cooled	30 m, 70 mm^2	6260330
Interconnection cable, water-cooled	1.8 m, 70 mm^2	6260410
Interconnection cable, water-cooled	5 m, 70 mm^2	6260407
Interconnection cable, water-cooled	10 m, 70 mm^2	6260334
Interconnection cable, water-cooled	15 m, 70 mm^2	6260335
Interconnection cable, water-cooled	20 m, 70 mm^2	6260337
Interconnection cable, water-cooled	30 m, 70 mm^2	6260340
WiseFusion welding function		9991014
WisePenetration welding function		9991000
WiseRoot welding process		6265011
WiseThin welding process		9991013
WiseSynergicMig license for upgrading Regular package to Synergic (for FastMig M)		9990420
MatchLog		9991017
MatchPIN		6265026
Transport unit PM 500		6185291
Transport unit T10		6185231
KV 200 mouting plate		6185249
MXF 65 hanging kit		W001694
MXF 63 hanging frame		6185285

SuperSnake

GT02S/GT02SW

The ultimate distance and access solution

- Suitable for Fe/Ss/Al/FCW/MCW filler wires
- Includes voltage and wire speed adjustment
- Large, clear meter display
- Brights™ LED cabinet lighting
- 10-, 15-, 20-, 25-meter air- and water-cooled models
- Visible safety with tough, bright orange sheathing
- Gun remote control option

Applications

- Heavy and medium-heavy metalfabrication workshops
- Shipyards and offshore industry
- Installation and site work

Weld predator

If distance and access are your problem, then take a look at **SuperSnake GT02S and GT02SW.** SuperSnake extends the reach of standard Euro MIG welding guns, providing simple distance wire feeding for a variety of filler wires up to 30m from the wire feed unit. Negotiating its terrain with ease, SuperSnake is the ultimate predator of the welding world.

The SuperSnake GT02S/GT02SW removes the need to carry large and heavy wire feed units, reducing personnel fatigue, improving safety, and increasing productivity. The SuperSnake connects easily to FastMig MXF wire feed units, bringing quality welding to locations that other welding brands just can't reach.

SuperSnake GT02S/GT02SW is compatible with FastMig X, FastMig M, FastMig KMS, FastMig Pulse, Kemppi Pro equipment.

Technical specifications

SuperSnake			
Output 40 °C	60 % ED	270 A	
Wire feed mechanism		2-roll	
Wire feed speed		0…25 m/min	
Feeder body (GT02SW) dimensions L x W x H		102 x 371 x 138 mm	
Wire recommendations, 25 m		Solid Fe/Ss	ø 1.0…1.6 mm
		Al alloys	ø 1.2…1.6 mm
		FCW/MCW	ø 1.2…1.6 mm
Cable diameter		50 mm²	
Supply voltage		50 VDC	
Protection class		IP23S	

Ordering information

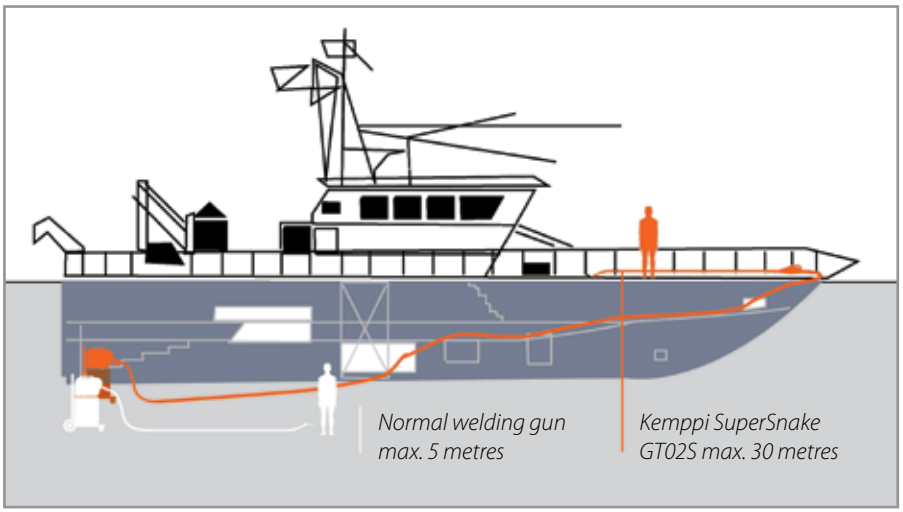
SuperSnake	
GT02S, 10 m	6153100
GT02S, 15 m	6153150
GT02S, 20 m	6153200
GT02S, 25 m	6153250
GT02SW, 10 m	6154100
GT02SW, 15 m	6154150
GT02SW, 20 m	6154200
GT02SW, 25 m	6154250
MXF synchronisation kit	W004030
SuperSnake protection frame	6185276

SuperSnake guide tubes	
Fe metal	SP004083
DL teflon	SP004185

Wire liners for SuperSnake

Steel spirals Fe / FCW / MCW	Filler wire ø, mm	Order number, 10 m	Order number, 15 m	Order number, 20 m	Order number, 25 m
	1.0…1.6	W004214	W004216	W004217	W004218
DL liners Al / Ss	**Filler wire ø, mm**	**Order number, 10 m**	**Order number, 15 m**	**Order number, 20 m**	**Order number, 25 m**
DL Chili 5.9/1.5	1.0…1.6	W004145	W004219	W004220	W004221

Spare part Steel spirals and DL liners are equipped with connectors. Both ends are locked in position in cable package set/sub feeder.



Liberate your welding team by giving greater freedom of movement.

Traditional motor pistols and spool gun designs increase weight and strain on the operator's wrist and are limited by their distance, filler wire, or volume welding capability. The SuperSnake GT02S resolves all of these issues, while reducing the weight and strain on the operator's wrist by using standard welding guns.

The sturdy steel frame effectively protects the SuperSnake from worksite hazards, such as blows and crashes.

When connected with Kemppi FastMig equipment, SuperSnake is compatible with the GXR10 Gun Remote, making real-time power management or remote channel selection easy and convenient.

Kempact RA

Switch on the new standard

Energy efficient

MVU

CV

1 Phase

3 Phase

- Modern, energy efficient power source
- Excellent welding performance with mixed or $C0_2$ shielding gas
- Precise, clean arc ignition
- Maximum output at 35 % duty cycle
- Large, clear LCD display
- WireLine™ service indicator
- GasMate™ chassis design featuring floor level cylinder loading
- Brights™ cabinet lighting
- HotSpot™ heat treatment function
- 2T/4T gun switch latching
- Spot and cycle arc timer
- Parts storage trays
- 3.5 m FE welding gun
- Kemppi 2+ warranty

New standards
in compact MIG/MAG class

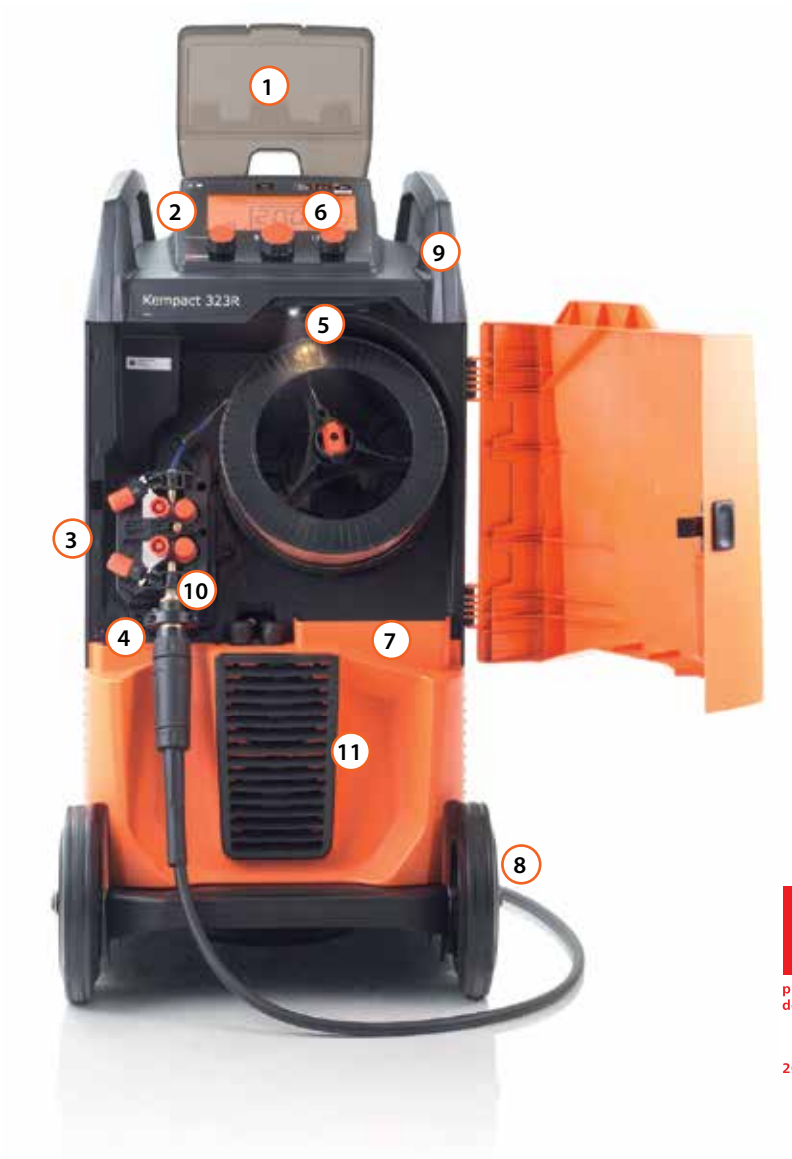
Designed for the modern welding workshop, Kempact RA expresses stylish and purposeful design through high build quality and functional user benefits, making weld tasks productive, accurate and efficient.

Kempact RA is built on Kemppi's latest power source platform, ensuring optimal welding performance and excellent power cost efficiency. Eleven model options include 250 and 320 ampere power sources, including a choice of either Regular (R) or Adaptive (A) control panel interface, which serve the wide ranging needs of metal fabrication workshops. Delivery specification includes welding gun and earth return lead pack.

New technology features include reduced energy costs of more than 10 % when compared to conventional step controlled power sources, Brights™ cabinet lighting for easy wire loading in low light conditions, WireLine™ service alert function that signals routine wire-path maintenance needs, plus the integrated GasMate™ chassis design, making gas cylinder loading and machine movement easy and safe. Whichever model you select, Kempact RA ensures you get the most from every welding task.

Design features:

1. Tough Plexiglas cover and lens plate provide added protection and style.
2. Choose either Regular (R models) or Adaptive (A models) control panel interface.
3. 2-roll (251 models) or 4-roll (253 and 323 models) wire drive systems.
4. Inverted gun connection improves wire feeding and gun life.
5. Brights™ wire cabinet lighting for low light conditions.
6. WireLine™ service symbol alerts drive system maintenance needs.
7. Integrated storage trays for wire drive and gun parts.
8. GasMate™ chassis design makes cylinder loading and machine movement easy and safe.
9. Strong pressed steel and moulded plastic construction.
10. Easy change welding polarity terminals.
11. Particle filter option for dusty fabrication shops.



product design award 2012

Kempact RA is accurate and efficient; designed for use with a variety of filler materials.

The large and clear LCD control panels make parameter setting and reference easy. Parts trays provide convenient storage and access.

GasMate chassis design makes gas cylinder collection, storage and movement easy. Gas cylinders are floor level loaded and secured with a strong fabric webbing system.

Kempact Adaptive (A) models include special features, including power setting by plate thickness control, filler materials selection and memory channels.

Kempact RA

Technical specifications

Kempact		**251R, 251A**
Connection voltage	1~, 50/60 Hz	240V (±15 %)
Rated power at max. current	30 % ED I1max (250 A)	8.5 kVA
Supply current	30 % ED I1max (250 A)	36 A
	100 % ED I1eff (150 A)	17 A
Connection cable	H07RN-F	3G2.5 (2.5 mm^2, 5 m)
Fuse	Type C	20 A
Welding range		10 V / 20 A – 29 V / 250 A
Power factor at max.	250 A / 26.5 V	0.99
Efficiency at 100% ED	150 A / 21.5 V	0.82
Wire feed speed adjustment range		1.0-18.0m/min
Voltage adjustment range		8.0-29.0V
External dimensions	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg
EMC class		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10, IEC 61000-3-12		

Kempact		**253R, 253A**		**323R, 323A**
Connection voltage	3~, 50/60 Hz	400V (±15 %)	3~, 50/60 Hz	400V (±15 %)
Rated power at max. current	35 % ED I1max (250 A)	8.5 kVA	35 % ED I1max (320 A)	12 kVA
Supply current	35 % ED I1max (250 A)	11.9 A	35 % ED I1max (320 A)	17.2 A
	100 % ED I1eff (150 A)	6.1 A	100 % ED I1eff (190 A)	8.2 A
Connection cable	H07RN-F	4G1.5 (1.5 mm^2, 5 m)	H07RN-F	4G1.5 (1.5 mm^2, 5 m)
Fuse	Type C	10A	Type C	10A
Welding range		10 V / 20 A – 31 V / 250 A		10 V / 20 A – 32.5 V / 320 A
Power factor at max.	250 A / 26.5 V	0.93	320 A / 30 V	0.94
Efficiency at 100% ED	150 A / 21.5 V	0.88	190 A / 23.5 V	0.86
Wire feed speed adjustment range		1.0-18.0m/min		1.0-20.0m/min
Voltage adjustment range		8.0-31.0V		8.0-32.5V
External dimensions	L x W x H	623 x 579 x 1070 mm	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg		44 kg
EMC class		A		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10				

Kempact 251 models include the GT02C, two roll wire drive unit.

Kempact 253/323 models include the Dura-Torque four roll wire drive unit.

Kempact RA

Technical specifications

Kempact		253 AMV		323 RMV/AMV
Connection voltage	3~, 50/60 Hz	230 V -15%…400 V +15%	3~, 50/60Hz	230 V -15%…400 V +15%
Rated power at max. current	40% ED I1max (250 A)(230V)	9 kVA	35% ED I1max (320A)(230V)	13.5 kVA
	40% ED I1max (250A)(400V)	8.5 kVA	35% ED I1max (320A)(400V)	12.5 kVA
Supply current	40% ED I1max (250A)(230V)	22.2 A	35% ED I1max (320A)(230V)	33.3 A
	40% ED I1max (250A)(400V)	12.3 A	35% ED I1max (320A)(400V)	17.8 A
	100% ED I1eff (150A)(230V)	10.8 A	100% ED I1eff (190A)(230V)	14.8 A
	100% ED I1eff (150A)(400V)	6.2 A	100% ED I1eff (190A)(400V)	8.3 A
Connection cable	H07RN-F	4G1.5 (1.5 mm^2, 5 m)	H07RN-F	4G1.5 (1.5 mm^2, 5 m)
Fuse	Type C (230V)	16 A	Type C (230V)	16 A
	Type C (400V)	10 A	Type C (400V)	10 A
Welding range	10V/20A - 31V/250A		10V/20A - 32.5V/320A	
Power factor at max.	250A/26.5V (230V)	0.94	320A/30V (230V)	0.94
	250A/26.5V (400V)	0.93	320A/30V (400V)	0.94
Efficiency at 100% ED	150A/21.5V (230V)	0.79	190A/23.5V (230V)	0.80
	150A/21.5V (400V)	0.82	190A/23.5V (400V)	0.83
Wire feed speed adjustment range		1.0-18.0m/min		1.0-20.0m/min
Voltage adjustment range		8.0-31.0V		8.0-32.5V
External dimensions	L x W x H	623 x 579 x 1070 mm	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg		44 kg
EMC class		A		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10				

Ordering information

Kempact RA		
Kempact 251R, GX 253 G, 3.5m	P2203GX	
Kempact 251R, GX 253 G, 5m	P2204GX	
Kempact 251A, GX 253 G, 3.5m	P2205GX	
Kempact 251A, GX 253 G, 5m	P2206GX	
Kempact 253R, GX 303 G, 3.5m	P2207GX	
Kempact 253R, GX 303 G, 5m	P2208GX	
Kempact 253A, GX 303 G, 3.5m	P2209GX	
Kempact 253A, GX 303 G, 5m	P2210GX	
Kempact 323R, GX 403 G, 3.5m	P2211GX	
Kempact 323R, GX 303 G, 3.5m	P2229GX	Only 300A/35% range
Kempact 323R, GX 403 G, 5m	P2212GX	
Kempact 323R, GX 303 G, 5m	P2230GX	Only 300A/35% range
Kempact 323A, GX 403 G, 3.5m	P2213GX	
Kempact 323A, GX 303 G, 3.5m	P2231GX	Only 300A/35% range
Kempact 323A, GX 403 G, 5m	P2214GX	
Kempact 323A, GX 303 G, 5m	P2232GX	Only 300A/35% range
Kempact 253AMV, GX 303 G, 3.5m	P2217GX	
Kempact 253AMV, GX 303 G, 5m	P2218GX	
Kempact 323RMV, GX 403 G, 3.5m	P2219GX	
Kempact 323RMV, GX 303 G, 3.5m	P2233GX	Only 300A/35% range
Kempact 323RMV, GX 403 G, 5m	P2220GX	
Kempact 323RMV, GX 303 G, 5m	P2234GX	Only 300A/35% range
Kempact 323AMV, GX 403 G, 3.5m	P2221GX	
Kempact 323AMV, GX 303 G, 3.5m	P2235GX	Only 300A/35% range
Kempact 323AMV, GX 403 G, 5m	P2222GX	
Kempact 323AMV, GX 303 G, 5m	P2236GX	Only 300A/35% range
Carbon electrode holder	9592106	
Carbon electrode 10-100	4192160	

MinarcMig Evo 200/170

An adaptive tool for the mobile welder

Energy efficient

1 Phase

CV

- Precise weld quality and arc ignition
- 200 A / 170 A of MIG/MAG welding power from a 16 A supply
- Choose either Automatic or Manual model
- Use with Fe, Fe FCW, Ss, Al, CuSi filler wires, 1 kg and 5 kg spools
- Just set the plate thickness and weld with 200 A model
- Large graphical display guides user
- Designed for use with long supply cables of 100m+
- A 3-meter gun, cable set and carrying strap included
- Suitable for mains network or generator use
- Kemppi 2+ warranty for parts and labour

Easier welding than ever

MinarcMig Evo machines pack huge MIG/MAG welding capacity and quality into their portable, compact size. Choose from either 200 A or 170 A models, delivering their welding power at 35 % duty cycle from a 16 A, 1-phase mains supply. MinarcMig Evo delivers premium results wherever your work takes you.

MinarcMig Evo 200 offers Automatic and Manual mode set-up for precise welding quality and arc ignition, monitored and controlled by Kemppi's adaptive arc regulation system. MinarcMig Evo 170 offers manual setting only, with separate controls for voltage and wire feed speed. Each model features a large graphical interface guiding the user during set-up and with MinarcMig Evo 200 you can simply set the plate thickness and weld, including materials selection for ferrous, stainless steel, aluminum and CuSi brazing filler wires, satisfying a wide variety of industrial applications.

PFC power source technology offers the ultimate energy economy with a power factor of 0.99. MinarcMig Evo can also be used efficiently with extra long power supply cables of more than 100 meters long, allowing for optimum welding utility in site welding environments.

Technical specifications

MinarcMig Evo		170	200
Connection voltage	1~ , 50/60 Hz	230 V (± 15 %)	230 V (± 15 %)
Connection voltage (AU)	1~ , 50/60 Hz	240 V (± 15 %)	240 V (± 15 %)
Rated power at max. current	35 % ED	170 A/4.8 kVA	200 A/6.2 kVA
Supply current	35 % ED I_{1max}	20,3 A	26.2 A
	100 % ED I_{1eff}	10,1 A	13.2 A
Connection cable	H07RN-F	3G1.5 (1.5 mm^2, 3 m)	3G1.5(1.5 mm^2, 3 m)
Fuse	type C	16 A	16 A
Output 40 °C	35% ED	170 A/24 V	200 A/24 V
	60% ED	140 A/21 V	160 A/22 V
	100% ED	100 A/20 V	120 A/20 V
Welding range		20 A/15 V – 170 A/ 24 V	20 A/15 V – 200 A/ 26 V
No-load voltage		74 V	74 V
Idle power		12 W fan off, 21 W fan on	12 W fan off, 26 W fan on
Voltage steps		0.1 V	0.1 V
Power factor at max. current		0.99	0.99
Efficiency at 100 % ED		80 %	82 %
Filler wires ø	Fe solid wire	0.6…1.0 mm	0.6…1.0 mm
	Fe cored wire	0.8…1.0 mm	0.8…1.0 mm
	Ss		0.8…1.0 mm
	Al		1.0 mm
	CuSi		0.8…1.0 mm
Wire feed speed adjustment range		1…12 m/min	1…13 m/min
Wire spool	max. ø	200 mm / 5 kg	200 mm / 5 kg
Shielding gases		CO_2, Ar + CO_2 mixed	CO_2, Ar, Ar + CO_2 mixed
External dimensions	L x W x H	450 x 227 x 368 mm	450 x 227 x 368 mm
Weight (incl. gun and cables 3.0 kg)		13 kg	13 kg
Temperature class		F (155 °C)	F (155 °C)
EMC class		A	A
Degree of protection		IP23S	IP23S
Operating temperature range		-20…+40 °C	-20…+40 °C
Storage temperature range		-40…+60 °C	-40…+60 °C
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10, IEC 61000-3-12			

Ordering information

MinarcMig Evo (incl. gun, cables, gas hose and shoulder strap)		
MinarcMig Evo 170		61008170
MinarcMig Evo 170 AU*		61008170AU
MinarcMig Evo 200		61008200
MinarcMig Evo 200 AU*		61008200AU
Welding gun MMG22	3 m	6250220
Earth return cable	3 m, 25 mm^2	6184004
Shielding gas hose	4.5 m	W001077
Shoulder strap		9592163
MinarcMig Evo 170 (no plug)		61008170NP
MinarcMig Evo 200 (no plug)		61008200NP
MST 400 transport unit		6185294
Euro adapter kit		W008366

* The AU model is for the Australian and New Zealand markets. They have different mains plugs.

Applications

- Thin sheet metal fabrication workshops
- Installation and set-up
- Repair and maintenance

Quality welding, wherever work takes you. MinarcMig Evo suits a variety of welding fabrication tasks.

Optional adapter for MinarcMig allows you to use any euro -compatible MiG/MAG welding gun

MinarcMig Evo 170 and 200 models include LCD control panels. MinarcMig Evo 200 also includes material type, plate thickness and weld shape selection.

Kempact MIG 2530/Pulse 3000

Combine the economy of cost, size, weight, and performance

- Basic MIG/MAG model
- Synergic pulsed model
- 4-roll wire drive system
- Electronic power regulation
- Maximum output at 40 % duty cycle
- Light weight: 22 kg
- Suitable for power generator use

Applications

- Thin sheet metal fabrication workshops
- Car repair
- Agriculture
- Shipyards and offshore industry
- Installation and set-up
- Repair and maintenance

Plenty of welding power per kilogram

Kempact 2530 is 70 % lighter in weight than traditional step regulated machines. Electronic control of voltage and wire speed allows arc tuning during the weld process, so you can quickly establish the desired weld settings. Includes gun trigger latching and wire inch function.

Kempact Pulse 3000 features synergic, pulsed and double-pulsed welding. Standard programs suit a variety of materials including Fe, FeMc, FeFc, St/St, Alu, CuSi3, CuAl8 fillers wires. Simply select the filler wire type, size and plate thickness and weld. For those regular welding jobs there's even a 100 channel memory function.

When the heat is on, keep your gun cool with KempactCool 10. Optional fit for Kempact Pulse 3000 only.

Technical specifications

Kempact		MIG 2530	Pulse 3000
Connection voltage	3~, 50/60 Hz	380 – 440V ±10%	400 V (±15 %)
Rated power		12 kVA	12 kVA
Connection cable	H07RN-F	4G1.5 (5 m)	4G1.5 (5 m)
Fuse, delayed		16 A	16 A
Output 40 °C	40 % ED	250 A/26.5 V	250 A/26.5 V
	60 % ED	207 A/24 V	207 A/24 V
	100 % ED	160 A/22 V	160 A/22 V
Open circuit voltage		30…45 V	56 V
Power factor at max. current		0.64	0.69
Efficiency at max. current		87 %	84 %
Welding range		20A/15 V – 250A/26.5 V	20A/15 V – 250A/26.5 V
Wire feed speed		1…18 m/min	
Wire spool	max. ø	300 mm	300 mm
Wire feed mechanism		4-roll	4-roll
Filler wires ø (mm)	Fe, Ss	0.6…1.0	0.6…1.2
	Cored wire	0.9…1.2	0.9…1.2
	Al	0.9…1.2	0.9…1.2
	CuSi	0.8…1.0	0.8…1.2
External dimensions (mm)	L x W x H	580 x 280 x 440	580 x 280 x 440
Weight		20 kg	22 kg

KempactCool 10		
Operating voltage	50/60 Hz	400 V (-15…+10 %)
Rated power	100 % ED	250 W
Cooling power		1.0 kW
Maximum pressure		450 kPa
Recommended cooling liquid		20–40 % ethanol/water
Tank volume		3 l
External dimensions (mm)	L x W x H	580 x 280 x 300 mm
Weight		13 kg

Ordering information

Kempact MIG 2530 (Incl. earth return cable (5 m, 35 mm²) and gas hose 6 m)		621853002
Gun holder	GH 30	6256030
Earth return cable	5 m, 35 mm²	6184311
Transport units	ST 7 (power source + gas cylinder)	6185290
KFH 1000 feeder hanger		6185100
Wire feeder hanging device		4298180
Kempact Pulse 3000		**621830002**
KempactCool 10		6218600
Earth return cable	5 m, 35 mm²	6184311

Ideal pulsed MIG/MAG solution for sheet metal fabrication and automotive repair.

Best arc characteristics

Kempact MIG machines have superb arc performance. Excellent arc ignition assisted by burn back time technology guarantee satisfaction. Electronic arc dynamics control offers the best arc performance in all situations.

Memory channels add usability

Kempact Pulse 3000 includes 100 memory channels to store welding values for later use. This makes it quick and easy to start welding without needing to adjust the settings once more.

Kempact Pulse 3000 control panel.

FitWeld Evo 300

Big power, small package, multi-voltage

Energy efficient

GT WireDrive Series

brights

QuickARC

GasGuard

- 300 A at 30 % Duty cycle
- Ideal for limited working space
- Portable at 15 kg
- Much faster than MMA in tacking
- Exceptional ignition quality
- For 220 V and 380-440 V 3-phase input voltage
- Digital metering guarantees accurate parameters for WPS conformity
- Integral shielding gas flow regulation and GasGuard™
- Heavy duty plastic case for tough working conditions

Applications

- Shipyards and offshore industry
- Metal fabrication workshops
- Installation and setup
- Car repair
- Agriculture

Speed, quality and economy for professionals

FitWeld Evo 300 MIG/MAG machine is the solution for tacking and welding in heavy industry. QuickArc™ ignition techniques, the latest GT WireDrive™ mechanics and Brights™ cabinet lighting, combine with other features to make welding faster, easier and safer. Offering real economy of size and weight, FitWeld Evo 300 also saves up to 57% on input power and increases tack and welding speed to twice that of traditional MMA equipment.

- Portable 14.5 kg/300 A genuine welding tool for tacking, installation, mounting or even production welding for applications with restricted space for the welding device.
- Welds perfectly with 1.2 mm flux cored or solid wires and other common fillers used in production.
- Operates everywhere including 220 V to 440 V 3-phase input voltages.
- Digital parameter display guarantees fast setting and accurate adjustment to follow the specified WPS.

Power to weld accurately with clean results

FitWeld Evo 300 features a generous welding voltage range from 11 V to 32 V, which means you have adequate power for a wide range of applications. It delivers excellent welding performance at 300A @ 30% duty cycle.

Special arc ignition control techniques called QuickArc are used during the ignition cycle, ensuring very clean and precise arc initiation. QuickArc delivers clean, crisp and stable results, even with 1.2 mm filler wire.

Display and metering

Power control is set via simple, panel mounted control knobs. The digital display guarantees fast and accurate preset voltage and wire feed speed parameters setting. Actual parameters are displayed during welding and remain in the post welding display.

Strong cabinet with LED lights and optional heater

The strong fibreglass impregnated plastic case makes the machine body very strong and impact resistant.

The wire feed mechanism features a durable cast aluminium GT WireDrive and to make wire spool change and adjustment easy and safe in low light conditions, Brights cabinet lighting delivers the solution. In addition, an FitWeld Evo 300 can be ordered with cabinet heating, helping to control the wire cabinet temperature fluctuations that result in condensation and filler wire surface oxidation.

GasGuard™

Fitted as standard to FitWeld Evo 300, Kemppi Gas Guard eliminates the possibility to weld without shielding gas, helping to prevent unnecessary rework and damage to the welding gun.

FitWeld LED display

FitWeld Evo 300 control panel

FitWeld Evo 300 mounted on ST7 transport unit.

Technical specifications

FitWeld Evo 300			
Connection voltage	3 ~, 50/60 Hz	220-230 V ±10%	380-440 V ±10%
Rated power at max. current		10.9 kVA	
Supply current	I_{1max}	230V: 30A	400V: 16A
	I_{1eff}	230V: 14A	400V: 6,2A
Output 40 °C	30 % ED	300 A / 29 V	
	40 % ED	250 A / 26.5 V	
	60 % ED	210 A / 24.5 V	
	100 % ED	170 A / 22.5 V	
Connection cable	H07RN-F	4G1.5 (5 m)	
Fuse (delayed)		230V: 20A	400V: 10A
Open circuit voltage		45 V DC	
Power factor at max. current		230V: 0,92	400V: 0,95
Efficiency at max. current		230V: 82,7%	400V: 86,3%
Welding range		13-32 V	
Wire spool (max. ø)		200 mm	
Wire feed mechanism		2-roll feed	
Filler wires	Fe solid	0.8 - 1.2 mm	
	Fe cored	0.8 - 1.2 mm	
	Ss	0.8 - 1.2 mm	
	Al	1.0 - 1.2 mm	
External dimensions	L x W x H	457 x 226 x 339 mm	
Weight		14.5 kg	
EMC class		A	
Degree of protection		IP23S	

Ordering information

FitWeld Evo 300		
FitWeld Evo 300	GX 303 G, 3.5 m	P2103GX
FitWeld Evo 300	GX 303 G, 5 m	P2104GX
Earth return cabel, 5 m, 35 mm^2		6184311
Shield gas hose, 6 m		W000566

X3 MIG Welder

Energy-efficient MIG/MAG welding and carbon arc gouging

Energy efficient

3 Phase

CV

- Powerful system for gas-cooled MIG/MAG welding and carbon arc gouging (not in AU/NZ)
- Built with reliable and energy-efficient IGBT inverter technology
- Connects to any 380-440 V
- 3-phase mains supply
- A 110-volt auxiliary voltage supply is available for an optional CO_2 shielding gas heater
- Accepts a wide range of wire di ameters from 0.8 up to 1.6 mm, and with cored wires up to 2.0 mm
- Excellent arc stability reduces spatter and the need for post-weld grinding
- Special functions available for fine-tuning the start and end of welds
- Simple user interface with presets for Argon/CO_2 or pure CO_2 shield ing gas
- Wire inch function is included as standard
- Clear presentation of welding parameters on a large back-lit LCD display
- Lightweight and easy to move, optional wheel sets available

Tough and reliable

Suitable for gas-cooled MIG/MAG welding and carbon arc gouging, the X3 MIG Welder is a smart investment for professional welders. It is packed with energy-efficient inverter technology and delivers up to 500 A at a 60% duty cycle. The system includes several special functions for fine-tuning the start and end of your welds. The X3 MIG Welder's stable arc guarantees high-quality welds, even with inexpen-sive CO_2 shielding gas.

Designed and manufactured in Finland, the X3 MIG Welder is a dura-ble choice for tough welding conditions, whether you work at a con-struction site, shipyard, or metal fabrication workshop. The system's wire feeder features a fully enclosed and impact-resistant dual-skin cabinet to protect the wire spool and feed mechanism. The simple two-knob control panel is easy to use and isn't afraid of rough han-dling.

The X3 MIG Welder welding system consists of an X3 Power Source available in 400 and 500 A models, an X3 Wire Feeder for 300 mm wire spools, and Kemppi's GX403G welding gun with a Euro connection. Different cable lengths and wheel sets are available as an option.

Available in Australia, India, China, Russia, and the following distributor markets: CIS countries, Southeast Asia, Middle East, Africa, and Latin America.

Technical specifications

X3 Power Source		400	500
Mains connection voltage 3~ 50/60 Hz		380 – 440 V (-10…+10 %)	380 – 440 V (–10…+10 %)
Open circuit voltage	Uav	52 – 57 V	57 – 62 V
Fuse		25 A	32 A
Output	60 % ED	400 A / 34 V	500 A / 39.0 V
	100 % ED	310 A / 29 V	390 A / 33.5 V
Welding current and voltage range		25 A/15 V - 400 A/38V	25 A/15 V - 500 A/43 V
Operating temperature range		-20…+40 °C	-20…+40 °C
EMC class		A	A
Degree of protection		IP 23S	IP 23S
External dimensions L x W x H		629 x 230 x 414 mm	629 x 230 x 414 mm
Standards		IEC 60974-1, EC 60974-10	IEC 60974-1, EC 60974-10

X3 Wire Feeder 300		
Gun connection		Euro
Wire feed mechanism		4-roll
Filler wires	Fe	0.6…1.6 mm
	MC/FC	0.8…2.0 mm
Wire feed speed		0…25 m/min
Wire spool weight (max)		20 kg
Wire spool diameter (max)		300 mm
Operating temperature range		-20…+40 °C
Degree of protection		IP 23S
External dimensions L x W x H		590 x 240 x 445 mm
Standards		IEC 60974-5, IEC 60974-10

Using the P 20 transport unit and the X3 Wire Feeder mounting kit you can move the welding set and the gas cylinder conveniently as a whole.

Ordering information

Power sources	
X3 Power Source 400	X31004000
X3 Power Source 400 AU	X31004000AU
X3 Power Source 500	X31005000
X3 Power Source 500 AU	X31005000AU
Wire feeder	
X3 Wire Feeder 300	X31003000
Transport units	
P 20 transport unit	6185261
Accessories	
X3 Wire Feeder mounting plate	X37000003
X3 Wheel Set	X37000001
X3 Four Wheel Set	X37000002
MIG guns	
Flexlite GX 403G35, 3,5 m	GX403G35
Flexlite GX 403G5, 5 m	GX403G5

Cables	
Interconnection cable 50-1,8-G	6260508
Interconnection cable 70-1,8-G	6260518
Interconnection cable 50-5-G	6260500
Interconnection cable 70-5-G	6260501
Interconnection cable 50-10-G	6260513
Interconnection cable 70-10-G	6260514
Interconnection cable 50-15-G	6260515
Interconnection cable 70-15-G	6260516
Interconnection cable 70-20-G	6260523
Interconnection cable 70-30-G	6260633
Extension cable 70-10-G	6310710
Extension cable 70-15-G	6310715
Extension cable 50-10-G	6310510
Extension cable 50-15-G	6310515
Earth return cable 50 mm^2 5m	6184511
Earth return cable 70 mm^2 5m	6184711

Applications

- Steel structures
- Mechanical engineering
- Shipbuilding

The X3 Power Source weighs less than similar equipment and delivers power-ful welding performance without any compromises on quality. Ergonomically positioned handles and optional wheel sets facilitate the system's easy transfer from one site to another. The less valu-able production time is used to move hardware, the more productive your welding will be.

The X3 MIG Welder's MIG/MAG process has been carefully tuned to give the arc outstanding stability, which makes it easy to manage and creates a minimum amount of spatter – also when using inexpensive CO2 shielding gas. When the need for post-weld grinding is reduced, welders can focus on productive weld-ing.

Crater fill function reduces the voltage level at the end of the weld and ensures the best arc control right to the finish. The end of the weld is nice and clean, which makes it easy to start the next weld without wasting welder's tie in grinding.


93A
93A

TIG welding

Precise ignition and smooth, stable current flow are the baseline for every model in our TIG welding equipment range. Optional remote control units can be selected to suit either workshop or site conditions, allowing welders to concentrate on quality.

MasterTig

Far from the ordinary

Energy efficient

- Choose from traditional touch button control panels or the full color 7" TFT control panel, including Weld Assist and 99 memory channels per process
- Weld Assist guides every welder towards accurate, productive welding by recommending the best parameters for different welding applications
- Several useful features available for enhanced TIG welding
- Easy, fast and convenient coolant filling and cleaning
- MasterTig transport units feature floor level cylinder loading, removing the need for heavy lifting
- Compatible with Flexlite TX TIG torches
- Foot pedal, on-torch and hand remote controls available
- Option for connecting the equipment to WeldEye cloud service

The new master of AC and DC TIG welding, MasterTig sets new standards for weld quality, usability and power efficiency.

Designed for professional user groups, MasterTig product family offers a choice of power variants in 230A, 300A, 400A* and 500A* models, featuring impressive size and weight specifications.

The modular design philosophy allows you to build the specification that best meets your needs, including alternative control panels, wireless remote controls and transport cart options.

Stylish, practical and robust, MasterTig absorbs the knocks and impact of everyday welding life. Light in weight and compact in size, MasterTig is constructed from tough injection molded plastic, featuring impact bridge protection structures, establishing your reliable partner for workshop or site use.

*) Models launch to market 2020

Excellent ergonomy and enhanced welding

Personalize

Upload your company logo or favorite image to personalize your MasterTig screen saver.

Modular design

Choose from a range of MasterTig power models, alternative user interface, remote control options, transport carts and torches, to ensure your machine exactly meets your needs.

Impact bridge

MasterTig is designed and constructed from strong, energy absorbing, recyclable plastics, incorporating impact bridge structures that better protect the power source from the everyday knocks of welding life.

Pivotsafe

MasterTig transport units feature floor level cylinder loading, removing the need for heavy lifting. The P45MT transport unit integrates an innovative pivoting cylinder plate, achieving safe cylinder loading.

Torch parts storage

Quickly access frequently used TIG torch parts from the convenient, handle mounted storage tray.

UI control panels

Choose either traditional touch button control panels or the full color 7" TFT control system allowing easy, fast and accurate parameter setting. Protected by a 3mm armor shield plate, the 7"TFT display panel is both impact and scratch resistant.

Weld assist

Setting your machine first time, every time with Weld Assist. Follow simple on-screen steps, selecting material, thickness, joint type and position, and Weld Assist sets the best parameters, guiding every welder towards accurate, productive welding. Weld Assist also gives recommendations for electrode size, filler wire, gas flow, groove type, pass profile and travel speed. Perfect for pWPS creation.

Autocool

Dynamic gas and water cooling ensures optimal temperature control and power efficiency. Depending on the welding power level and duration, the power source cooling fans moderate air flow and cooler motor run time between 15 seconds and 4 minutes, reducing electrical power consumption and localized noise levels.

Bluetooth

The magic of cordless remote control. Cancel remote cable repairs and improve work site safety by using Bluetooth wireless remotes. Select either hand or foot pedal modules and enjoy wireless power control from a distance of up to 15 or even 100 meters, depending on the work site. Simply make life easy.

Clear, accurate and easy

For fast and accurate parameter setting, choose traditional touch button control panels or the full color 7" TFT control system, including Weld Assist.

MTP23X

MTP33X

MTP35X

Technical data

		MASTERTIG 235ACDC GM	MASTERTIG 235ACDC GM (VRD locked on)
Mains connection voltage	1~ 50/60 Hz	110 / 220 ... 240 V	110 / 240 V
Fuse		16 A	15 A
Open circuit voltage (average)	MMA	50 V	23 V (locked to VRD)
Rated maximum output at 40 °C (240 V)	40 % TIG	230 A / 19.2 V	230 A / 19.2 V
Rated maximum output at 40 °C (110 V)	40 % TIG	130 A / 15.2 V	130 A / 15.2 V
Range of output (240 V)	TIG	3 A / 1 V…230 A / 31 V	3 A / 1 V…230 A / 31 V
Range of output (110 V)	TIG	3 A / 1 V…130 A / 24 V	3 A / 1 V…130 A / 24 V
Operating temperature range		-20…+40 °C	-20…+40 °C
EMC class		A	A
Degree of protection		IP23S	IP23S
External dimensions	LxWxH	544 x 205 x 443 mm	544 x 205 x 443 mm
Weight without accessories		19.1 kg	19.1 kg
Recommended generator power (min)	Sgen	8 kVA	8 kVA
Stick electrode diameters	ø mm	1.6…5.0 mm	1.6…5.0 mm
Standards		IEC 60974-1,-3,-10 IEC 61000-3-12	IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006

		MASTERTIG 325DC	MASTERTIG 325DC G	MASTERTIG 325DC GM
Mains connection voltage	3~ 50/60 Hz	380 ... 460 V	380 ... 460 V	220 ... 230 460 V; 380 ... 460 V
Fuse		16 A	16 A	20 A
Open circuit voltage (average)	MMA	50 V	50 V	50 V
Rated maximum output at 40 °C	40 % TIG	300 A / 22 V	300 A / 22 V	300 A / 22 V
Range of output	TIG	3 A / 1 V…300 A / 38 V	3 A / 1 V…300 A / 38 V	3 A / 1 V…300 A / 27 V (@ 220 V)
Operating temperature range		-20…+40 °C	-20…+40 °C	-20…+40 °C
EMC class		A	A	A
Degree of protection		IP23S	IP23S	IP23S
External dimensions	LxWxH	544 x 205 x 443 mm	544 x 205 x 443 mm	544 x 205 x 443 mm
Weight without accessories		21.0 kg	21.5 kg	21.5 kg
Recommended generator power (min)	Sgen	20 kVA	20 kVA	20 kVA
Stick electrode diameters	ø mm	1.6…6.0 mm	1.6…6.0 mm	1.6…6.0 mm
Standards		IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *	IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *	IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *

* Applies only to the power source model versions where the Voltage Reduction Device (VRD) function is locked on.

		MASTERTIG 335ACDC	MASTERTIG 335ACDC G	MASTERTIG 335ACDC GM
Mains connection voltage	3~ 50/60 Hz	380 ... 460 V	380 ... 460 V	220 ... 230 V; 380 ... 460 V
Fuse		16 A	16 A	20 A
Open circuit voltage (average)	MMA	50 V	50 V	50 V
Rated maximum output at 40 °C	40 % TIG	300 A / 22 V	300 A / 22 V	300 A / 22 V
Range of output	TIG	3 A / 1 V…300 A / 38 V	3 A / 1 V…300 A / 38 V	3 A / 1 V…300 A / 27 V (@ 220 V)
Operating temperature range		-20…+40 °C	-20…+40 °C	-20…+40 °C
EMC class		A	A	A
Degree of protection		IP23S	IP23S	IP23S
External dimensions LxWxH	mm	544 x 205 x 443	544 x 205 x 443	544 x 205 x 443
Weight without accessories	kg	22.0 kg	22.5 kg	22.5 kg
Recommended generator power (min)	Sgen	20 kVA	20 kVA	20 kVA
Stick electrode diameters	ø mm	1.6…6.0 mm	1.6…6.0 mm	1.6…6.0 mm
Standards		IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *	IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *	IEC 60974-1,-3,-10 IEC 61000-3-12 AS 60974.1-2006 *

* Applies only to the power source model versions where the Voltage Reduction Device (VRD) function is locked on.

	MASTERTIG COOLER M
Recommended coolant	MPG 4456 (Kemppi mixture)
Tank volume	3.0 l
Operating temperature range *	-20…+40 °C
Weight without accessories	12.5 kg
	* With recommended coolant

FLEXLiTE TIG TORCHES		TX 135GF	TX 165GF	TX 165GS	TX 165G	TX 225G	TX 225GS	TX 255WS	TX 305WF	TX 355W
Type of cooling		Gas	Gas	Gas	Gas	Gas	Gas	Liquid	Liquid	Liquid
Type of connection	Current-gas	R1/4	R1/4	R1/4	R1/4	R1/4	R1/4	R1/4	R1/4	R1/4
Load capacity @ 40 % (Argon)	A	130	160	160	160	220	220	250	300	350
Load capacity @ 100 % (Argon)	A	-	-	-	-	-	-	200	200	250
Remote control		Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional
Neck type		Flexible	Flexible	Rotating	70° angle	70° angle	Rotating	Rotating	Flexible	70° angle
	These equipment comply with standard IEC 60974-7.									

Ordering information

Equipment	Description	Ordering code
MasterTig 235ACDC GM	Power source: 230 A AC/DC, generator and multi-voltage use	MT235ACDCGM
	Power source: 230A AC/DC, generator and multi-voltage use, VRD locked on	MT235ACDCGMAU
MasterTig 325DC	Power source: 300 A DC	MT325DC
MasterTig 325DC G	Power source: 300 A DC, generator use	MT325DCG
	Power source: 300 A DC, generator use, VRD locked on	MT325DCGAU
MasterTig 325DC GM	Power source: 300 A DC, generator and multi-voltage use	MT325DCGM
MasterTig 335ACDC	Power source: 300 A AC/DC	MT335ACDC
MasterTig 335ACDC G	Power source: 300 A AC/DC, generator use	MT335ACDCG
	Power source: 300 A AC/DC, generator use, VRD locked on	MT335ACDCGAU
MasterTig 335ACDC GM	Power source: 300 A AC/DC, generator and multi-voltage use	MT335ACDCGM
MasterTig Cooler M	Cooling unit, multi-voltage use	MTC1KWM
MTP23X	Control panel: Membrane panel, DC	MTP23X
MTP33X	Control panel: Membrane panel, AC/DC	MTP33X
MTP35X	Control panel: 7" TFT panel, DC, AC/DC	MTP35X
HR43	Wired remote *	HR43
HR45	Wireless remote *	HR45
FR43	Wired foot pedal remote	FR43
FR45	Wireless foot pedal remote	FR45
P43MT	Transport unit, 4 wheel undercarriage	P43MT
T25MT	Transport unit, 2 wheel cart	T25MT
P45MT	Transport unit, 4 wheel cart	P45MT

* Available in January 2020.

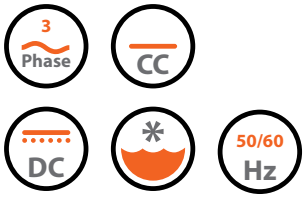

P43MT


T25MT


P45MT

MasterTig MLS 4000

Some tools simply feel better to use than others



- DC TIG and MMA power output
- Compact size ensures effortless mobility
- Excellent ignition quality, even with long TIG torches
- Quick pulse function increases welding speed and quality
- Suitable for use with power generators

Applications

- Installation and site work
- Repair and maintenance
- Thin sheet metal fabrication workshops
- Chemical and power industry

DC equipment
for industrial applications

MasterTig MLS DC range has become an industry standard for many users, offering precise welding performance and lightweight, portable design. A popular choice for welding professionals, options include 300 and 400 amp power sources with 30% duty cycle at maximum output current.

Choose from four control panel options, allowing you to select exactly the parameter control that's right for your welding application.

MTL/MTX/MTM/MTZ control panel options contain basic and specialist functions required for quality DC TIG and MMA welding. Features can include: HF or contact ignition, pre-gas and post-gas control, torch switch latching 2T/4T, remote control and setup options, welding current upslope and downslope timer, MMA ignition pulse, MMA arc dynamics, pulse and synergic pulse TIG, spot timer, 4T log and memory channel function.

This model is compatible with K5-level Flexlite TX torches only, please see the full available range of TIG torches on Welding guns and torches catalogue. Available remote control models are on page 96.

Technical specifications

MasterTig MLS™		4000
Connection voltage	3~ 50/60 Hz	380-440V ±10%
Rated power at 100 % ED	TIG	13.8 kVA
	MMA	15 kVA
Fuse, delayed		16 A
Output 40 °C	30 % ED TIG	400 A/26 V
	60 % ED TIG	320 A/22.8 V
	100 % ED TIG	270 A/20.8 V
	40 % ED MMA	350 A/34 V
	60 % ED MMA	285 A/31.4 V
	100 % ED MMA	220 A/28.8 V
Welding range	TIG	5 A/10 V…400 A/26 V
	MMA	10 A/20.5 V …350 A/34 V
Open circuit voltage		80 V DC
Power factor at 100% ED		0.95
Efficiency at 100% ED		86 %
Stick electrode	ø	1.5…6.0 mm
External dimensions	L x W x H	500 x 180 x 390 mm
Weight		23 kg

MasterCool 10		
Connection voltage	50/60 Hz	400 V (-15…+20 %)
		230 V (-15…+10 %)
Cooling power	100 % ED	1.0 kW
Rated power	100 % ED	250 W
External dimensions	L x W x H	500 x 180 x 260 mm
Weight		10 kg

Ordering information

Power Sources	
MasterTig 4000 MLS	6114400
MasterTig 4000 MLS VRD	6114400VRD
Cooling units	
MasterCool 10	6122350
Control panels	
MTL	6116000
MTX	6116005
MTM	6116010
MTZ	6116015
Transport units	
T 130	6185222

MasterTig MLS options

MTL

MTX

MTZ

MTM

MasterTig MLS equipment is lightweight and portable for site use, but delivers high welding current and duty cycle.

MasterTig ACDC 3500W

Powerful, dependable and reassuringly economic

Energy efficient

3 Phase | CC | ACDC

MasterTig ACDC 3500W mounted to T 22 transport unit.

- Automatic AC balance increases the quality and speed of welding
- Precise penetration control based on AC frequency adjustment
- Reliable arc ignition and functionality
- A choice of three control panels suiting different customer needs
- Energy efficient and excellent for limited fused supplies

Applications

- Fabrication workshops
- Chemical and process industry
- Installation and set-up
- Repair and maintenance

Powerful ACDC TIG equipment with a small appetite

MasterTig ACDC 3500W only requires a 20 amp 3-phase power supply, some small indication of the economy offered by this modern power source design. A maximum power output of 350 amp at 60 % duty cycle ensures you have enough power and the integral water cooling unit keeps torches cool during high duty production welding.

MasterTig ACDC 3500W control panels provide all of the necessary functions needed for TIG welding. Simply choose the control level that suits your particular needs. Options include pulsed and basic versions with large clear meter displays. Standard features include: pre and post gas time control, upslope and downslope control, arc shape AC balance control, torch switch latching, remote control selection and MMA process. Safety codelock feature prevents unauthorised use of the equipment.

Technical specifications

MasterTig ACDC 3500W		
Connection voltage	3~, 50/60 Hz	400 V (±10 %)
Rated power, max.	TIG	11.7 kVA
	MMA	15.7 kVA
Fuse, delayed	400 V	20 A
Output 40 °C	60 % TIG AC	350 A/24 V
	100 % TIG AC	280 A/21.2 V
	60 % MMA DC	350 A/34 V
	100 % MMA DC	280 A/31.2 V
Welding range	TIG DC	3 A/10 V…350 A/24 V
	AC	10 A/10 V…350 A/24 V
	MMA	10 A/20 V…350 A/34 V
Open circuit voltage	AC, DC	70 V DC
Power ratio at max. current		0.9
Efficiency at max. current		80 %
External dimensions	L x W x H	690 x 260 x 870 mm
Weight		74 kg

Ordering information

MasterTig ACDC 3500W	6163505
Control panels	
ACDC basic panel	6162801
ACDC Minilog panel	6162802
ACDC Pulse panel	6162803
Transport unit T 22	6185256

This model is compatible with K3-level Flexlite TX torches only, please see the full available range of TIG torches on Welding guns and torches catalogue. Available remote control models are on n page 96.

MasterTig ACDC 3500W has earned its reputation as a dependable, quality welding equipment

Choose from three control panel options:

ACDC

ACDC Minilog

ACDC Pulse

MinarcTig Evo 200MLP/200

The finest TIG welding quality

Energy efficient

1 Phase | CC | DC

- 200 A DC @ 35% duty cycle, 1-phase, 230 V
- Smooth welding quality
- Refined arc ignition from 5 A
- Pre and post gas timer
- Slope in/out timer
- Torch switch latching
- MLP and Pulse welding option
- Remote current controls options
- PFC technology for ultimate energy efficiency
- Mains networks or generator use
- Kemppi 2+ warranty for parts and labour

Smooth, **refined and powerful**

MinarcTig Evo is just what you'd expect from a Kemppi TIG welding machine. Accurate and refined HF ignition and the necessary control, power and work capacity to reliably complete a variety of professional welding tasks. MinarcTig Evo is the ideal DC TIG welding solution for light industrial manufacturing, installation, repair and maintenance applications. The lightweight and compact size is a real bonus for welding professionals on the move.

Models include either the MinarcTig Evo 200 or the MinarcTig Evo 200MLP. The powerful PFC power source design combines useful performance advantages, including excellent energy efficiency and the ability to reliably perform on extra long power supply cables of more than 100 meters long.

MinarcTig Evo models include large LED metering displays and feature a range of functions including pre and post gas time control, slope current time controls and remote control options. MLP models are equipped with additional functions including Minilog control and semi-automatic arc pulse function. MinarcTig Evo is a dual-process machine that also provides quality MMA welding for a range of DC electrode types.

This model is compatible with K5-level Flexlite TX torches only, please see the full available range of TIG torches on Welding guns and torches catalogue. Available remote control models are on n page 96.

Technical specifications

MinarcTig Evo 200/200MLP			
Connection voltage	1~, 50/60 Hz		230 V ±15 % (AU 240 V ±15 %)
Rated power at max. current	TIG	35 % ED	200 A/4.9 kVA
	MMA	35 % ED	170 A/5.7 kVA
Supply current, I_{1max}	TIG		21.1 A
	MMA		24.8 A
Supply current, I_{1eff}	TIG		12.7 A
	MMA		14.7 A
Connection cable	H07RN-F		3G1.5 (1.5 mm², 3 m)
Fuse	type C		16 A
Output 40 °C	TIG	35 % ED	200 A /18 V
		60 % ED	160 A /16.4 V
		100 % ED	140 A /15.6 V
	MMA	35 % ED	170 A /26.8 V
		60 % ED	130 A /25.2 V
		100 % ED	110 A /24.4 V
Welding range	TIG		5 A /10.2 V…200 A /18.0 V
	MMA		10 A /20.4 V…170 A /26.8 V
Open circuit voltage			95 V (VRD 30 V, AU VRD 12 V)
Idle power	TIG		10 W
	MMA		30 W
Power factor at 100 % ED	TIG		0.99
	MMA		0.99
Efficiency at 100 % ED	TIG		77 %
	MMA		83 %
Striking voltage			6…12 kV
Stick electrodes, MMA	ø		1.5…4.0 mm
External dimensions	L × W × H		449 × 210 × 358 mm
Weight (without cables)			11 kg
Temperature class			F (155 °C)
Degree of protection			IP23S
EMC class			A
Operating temperature range			-20…+40 °C
Storage temperature range			-40…+60 °C
Standards: IEC 60974-1, IEC 60974-3, IEC 60974-10, IEC 61000-3-12			

Ordering information

MinarcTig Evo 200		MinarcTig Evo 200 MLP	
TX 225 G, 4 m	P0640TX	TX 225 G, 4 m	P0642TX
VRD, TX 225 G, 4 m	P0672TX	* AU, TX 225 G, 4 m	P0674TX
VRD, TX 225 G, 8 m	P0673TX	* AU, TX 225 G, 8 m	P0675TX
TX 225 G, 8 m	P0641TX	TX 225 G, 4 m	P0643TX
TX 225 G S, 4 m	P0645TX	TX 225 G S, 8 m	P0647TX
TX 165 G S, 4 m	P0648TX	TX 165 G S, 4 m	P0650TX
TX 165 G S, 8 m	P0649TX	TX 165 G S, 8 m	P0651TX
TX 135 G F, 4 m	P0652TX	TX 135 G F, 4 m	P0654TX
TX 135 G F, 8 m	P0653TX	TX 135 G F, 8 m	P0655TX
TX 165 G F, 4 m	P0656TX	TX 165 G F, 4 m	P0658TX
TX 165 G F, 8 m	P0657TX	TX 165 G F, 8 m	P0659TX
TX 225 G S, 4 m	P0644TX	TX 165 G S, 16 m	P0671TX
TX 165 G S, 16 m	P0670TX	TX 225 G S, 4 m	P0646TX
TX 305 W F 4 m, COOLER	P0676TX	TX 305 W F 4 m, COOLER	P0678TX
TX 305 W F 8 m, COOLER	P0677TX	TX 305 W F 8 m, COOLER	P0679TX
TX 255 W S 4 m, COOLER	P0687TX	TX 255 W S 4 m, COOLER	P0689TX
TX 255 W S 8 m, COOLER	P0688TX	TX 255 W S 8 m, COOLER	P0690TX
TX 355 W 4 m, COOLER	P0691TX	TX 355 W 4 m, COOLER	P0693TX
TX 355 W 8 m, COOLER	P0692TX	TX 355 W 8 m, COOLER	P0694TX
MST 400 transport unit		6185294	

* The AU model is for the Australian and New Zealand markets.

Applications

- Installation and set-up
- Repair and maintenance
- Thin sheet metal fabrication workshops
- Chemical and process industry

Minilog function is a very easy-to-use pulsing feature: you just set the pulse time and current average and start welding.

MinarcTig Evo cooler extends the welding capability of MinarcTig Evo 200 models and enables the use of small and compact liquid cooled torches. Product code: 6162901.

MinarcTig Evo 200
MinarcTig Evo 200 MLP with Pulse function

MinarcTig 250MLP/250

Powerful, portable and compact

- Excellent low current ignition
- Clear parameter display
- Pre and post gas timer
- Slope in/out timer
- Torch switch latching
- Pulse welding option
- Suitable for mains or power generator use

Applications

- Installation and set-up
- Repair and maintenance
- Thin sheet metal fabrication workshops
- Chemical and process industry

Refined TIG welding quality for precise applications

MinarcTig 250 is the ideal DC TIG welding solution for installation, repair and maintenance applications. The 250 amp model suits high quality work and the lightweight and compact size is a real bonus for professionals on the move around site.

MinarcTig 250 is a dual-process machine, providing an impressive DC TIG and MMA welding experience. In addition to the basic 250 machine there is the 250MLP model, equipped with special features, such as Minilog and pulsed arc function. High 35 % duty cycle and light weight combine real performance advantages, plus exceptional control in low current ignition means refined TIG welding quality for precise applications.

This model is compatible with K5-level Flexlite TX torches only, please see the full available range of TIG torches on Welding guns and torches catalogue. Available remote control models are on n page 96.

Technical specifications

MinarcTig 250MLP/250			
Connection voltage	50/60 Hz		3~, 400 V (-20…+15 %)
Rated power at maximum current	TIG		7.2 kVA
	MMA		8.2 kVA
Connection cable	H07RN-F		4G1.5 (5 m)
Fuse, slow			10 A
Output 40° C	TIG	30 % ED	250 A / 20.1 V
		60 % ED	180 A / 17.2 V
		100 % ED	160 A / 16.4 V
	MMA	35 % ED	220 A / 28.8 V
		60 % ED	170 A / 26.8 V
		100 % ED	150 A / 26.0 V
Welding range	TIG		5 A / 10.2 V – 250 A / 20.1 V
	MMA		10 A / 20.4 V – 220 A / 28.8 V
Open circuit voltage			95 V
Power factor at maximum current	TIG		0.92
	MMA		0.91
Efficiency at maximum current	TIG		80 %
	MMA		86 %
Stick electrode	ø		1.5–5.0 mm
External dimensions	L x W x H		400 x 180 x 340 mm
Weight (without cables)			11 kg

MinarcTig 250 shown on optional 2-wheel transport unit MST400.

Ordering information

MinarcTig 250		MinarcTig 250MLP	
TX 165 G F, 4 m	P0607TX	TX 165 G F, 4 m	P0611TX
TX 165 G F, 8 m	P0608TX	TX 165 G F, 8 m	P0612TX
TX 225 G, 4 m	P0609TX	TX 225 G, 4 m	P0613TX
TX 225 G, 8 m	P0610TX	TX 225 G, 8 m	P0614TX
TX 165 G S, 4 m	P0625TX	TX 135 G F, 4 m	P0615TX
TX 165 G S, 4 m	P0626TX	TX 135 G F, 8 m	P0616TX
TX 225 G S, 4 m	P0632TX	TX 165 G S, 4 m	P0617TX
TX 225 G S, 8 m	P0633TX	TX 165 G S, 8 m	P0618TX
TX 135 G F, 4 m	P0636TX	TX 225 G S, 4 m	P0634TX
TX 135 G F, 8 m	P0637TX	TX 225 G S, 8 m	P0635TX
TX 165 G S, 16 m	P0668TX	TX 165 G S, 16 m	P0669TX
Accessories			
Welding cable	5 m, 25 mm^2	6184201	
Earth return cable	5 m, 25 mm^2	6184211	
MST 400 transport unit		6185294	

MinarcTig 250 is an ideal machine for thin sheet fabrication tasks. The low current ignition and stable arc, make quality welding easy.

MinarcTig can be used in the production and maintenance of many metal products. In the workshop or site, MinarcTig 250 is a dependable and portable welding partner.

MinarcTig 250 panel

MinarcTig 250MLP panel


KEMPPI

MMA welding

Compact, lightweight and capable. Kemppi MMA welding equipment meets professional welding demands in every respect. Arc ignition and stability dynamic control ensure that every electrode burns effortlessly to produce quality welds. All models are power generator compatible and able to operate in a wide range of conditions from subzero temperatures to desert heat.

Minarc Evo 180

Wherever work takes you

Energy efficient

1 Phase

CC

- Premium welding performance
- Use with all electrode types
- Use with long supply cables
- PFC technology for ultimate energy efficiency
- High current output and duty cycle
- Lightweight and portable
- Robust and durable
- Precise lift TIG technology
- Mains network or generator use
- Optional remote control
- Kemppi 2+ year warranty for parts and labour

Applications

- Metal workshops
- Construction industry
- Agriculture
- Repair and maintenance

More powerful and affordable than ever before

The little MMA giant is back, stronger than ever. Minarc Evo 180 is the latest MMA model from the popular Minarc Evo family. It has all the great qualities of its predecessor, and then some. Upgraded, improved and more powerful, it serves the agile welder better than ever with greater welding capacity.

Outstanding welding performance is no overstatement. Every element of Minarc Evo 180 is designed to meet the needs of professional welders on the move. Where size, weight and welding quality are concerned, there is no equal.

Ideal for site use, you can use Minarc Evo 180 from mains or generator power supplies, even with extra long supply cables. Minarc Evo is easy to carry, so you can normally take everything you need in one journey.

Large voltage reserves and automatic arc force control provide excellent arc stability in all welding positions and for a wide range of electrode types, making sure you get quality welding results every time.

The large and clear meter display makes accurate current setting simple and easy, and precise lift TIG ignition ensures high quality DC TIG welding. Connect a remote control unit and you can adjust welding parameters at distance during welding, for the ultimate convenience and weld pool control.

Technical specifications

Minarc Evo 180		
Connection voltage	1~ 50/60 Hz	230 V ±15 % (AU 240 V ± 15 %)
Rated power at max. current	30 % ED MMA	170 A / 5.7 kVA
	35 % ED TIG	180 A / 4.0 kVA
Output (40 °C) MMA	30 % ED	170 A / 26.8 V (140AU: 28 % ED 140A / 25.6 V)
	60 % ED	140 A / 25.6 V
	100 % ED	115 A / 24.6 V (140 AU: 80 A/23.2 V)
Output (40 °C) TIG	35 % ED	180 A / 17.2 V
	60 % ED	150 A / 15 V
	100 % ED	130 A / 15.2 V
Open circuit voltage		90 V (VRD 30 V; AU VRD 12 V)
Power factor at 100 % ED		0.99
Efficiency at 100 % ED (MMA)		84 %
Stick electrodes	ø	1.5…4 mm
External dimensions	L x W x H	361 x 139 x 267 mm
Weight (with connection cable)		5.85 kg
EMC class		A
Norms IEC 60974-1, -10, IEC 61000-3-12		

Lightweight, compact and super portable

Large and clear meter display

Ordering information

Minarc Evo 180 (incl. earth return and welding cables (3 m) and shoulder strap)		
Minarc Evo 180		61002180
Minarc Evo 140 AU*		61002140AU
Minarc Evo 180 AU*		61002180AU
Minarc Evo 180 VRD		61002180VRD
Earth return cable	5 m, 16 mm²	6184015
Welding cable	5 m, 16 mm²	6184005
Shoulder strap		9592163
Optional: TIG torch Flexlite TX 163 GVD94	4 m	TX163GVD94
BETA 90X electronic welding helmet		9873047
R10 Hand held remote control	5 m	6185409

Minarc Evo 180 includes electrode holder and welding cable set.

* The AU model is for the Australian and New Zealand markets. They have different mains plugs.

Master MLS 2500/3500

Premium MMA welding quality

- Specific design for MMA welding
- Compact and portable
- Control panel choice for varied applications
- Designed for all electrode types
- MMA and TIG welding function
- Suitable for use with power generators

Applications

- Installation and set-up
- Repair and maintenance
- Chemical and process industry
- Shipyards and offshore industry

Excellent arc control, durable design.

Master MLS machines offer the best choice in MMA welding refinement. Combine either the 250 or 350 amp power source with the basic MEL or advanced MEX control panels for outstanding welding performance. High 40 % duty cycle ensures you have the work capacity to get the job done; whilst the compact and lightweight design makes work around site easy.

Control panel options MEL and MEX include all of the necessary parameter functions for high quality MMA welding. MEL panel includes process selection for MMA or basic TIG welding, large, clear meter display, hot start and arc force control, plus remote control function. MEX panel offers a more diverse selection of parameter controls including: Electronic electrode type selector, arc gouging, or broken arc welding technique and memory channel function. High quality TouchArc function provides a credible DC TIG welding facility.

Technical specifications

Master MLS™		**2500**	**3500**
Connection voltage	3~, 50/60 Hz	400 V (-15…+20 %)	400 V (-15…+20 %)
Rated power at max. current	MMA	9.4 kVA	15 kVA
	TIG	8.4 kVA	13.8 kVA
Fuse, delayed		10 A	16 A
Output 40 °C	40 % ED	250 A/30 V (300 A/22 V TIG)	350 A/34 V (400 A/26 V TIG)
	60 % ED	205 A / 28.2 V	285 A / 31.4 V
	100 % ED	160 A / 26.4 V	220 A / 28.8 V
Welding range	MMA	10 A/20.5 V…250 A/30 V	10 A/20.5 V…350 A/34 V
	TIG	5 A/10 V…300 A/22 V	5 A/10 V…400 A/26 V
Open circuit voltage		80 V	80 V
Power factor at 100% ED		0.95	0.95
Efficiency at 100% ED		86 %	86 %
Stick electrode	ø	1.5…5.0 mm	1.5…6.0 mm
External dimensions	L x W x H	500 x 180 x 390 mm	500 x 180 x 390 mm
Weight		20 kg	21 kg

Ordering information

Master MLS™ 2500		**6104250**
Welding cable	5 m, 35 mm^2	6184301
Earth return cable	5 m, 35 mm^2	6184311
Electric plug 16 A	5-poles	9770812
Master MLS™ 3500		**6104350**
Master MLS™ 3500 VRD		6104350C1
Welding cable	5 m, 50 mm^2	6184501
Earth return cable	5 m, 50 mm^2	6184511
Electric plug 16 A	5-poles	9770812
Electric plug 32 A	5-poles	9770813
Control panels		
MEL		6106000
MEX		6106010

Master MLS is designed for professional use in demanding conditions.

Master MLS options

MEL

MEX

Minarc 150 Classic

Little giant of the MMA welding world

4 kg

1 Phase

CC

- Excellent welding quality and ignition
- Automatic dynamics feature
- Light weight and high power
- Excellent work duty performance
- Scratch TIG feature
- Ready to weld packages

Applications

- Metal workshops
- Construction industry
- Agriculture
- Repair and maintenance

Lightweight, compact **and super portable.**

Minarc 150 Classic is a lightweight MMA welding machine ideal for workshop and site environments. Designed for portability and professional welding, Minarc 150 Classic features well-protected control knobs, durable impact resistant casing, and shoulder strap.

Minarc's superior arc performance is based on high voltage reserves and automatic Arc Force control. These features guarantee the arc will remain stable in all welding positions, with any selected welding current, even when connected with extra long welding and power cables, up to 100m.

Automatic Hot Start gives perfect ignition in all conditions and the Anti-sticking function decreases the risk of the MMA electrode sticking to the base material and aids short arc control. Protection against overload, over voltage, humidity and dust ingress, gives excellent reliability, and TIG welding is made possible with the scratch -TIG function. Minarc 150 Classic is also available with VRD function (Voltage Reduction Device), lowering the open circuit voltage for welding environments that may present wet, damp or humid conditions. Minarc 151 Classic is designed to be used with 110V site transformers.

Technical specifications

Minarc 150 Classic			
Connection voltage	1~, 50 /60 Hz	230 V ±15 %	110 V ±15 %
Rated power	35 % ED MMA	140 A/7.5 kVA	140 A
	50 % ED MMA	-	100 A
	100 % ED MMA	100 A/5.1 kVA	150 A
	35 % ED TIG	150 A/5.0 kVA	110 A
	50 % ED TIG	-	3G6 (2 m)
	100 % ED TIG	110 A/3.3 kVA	32 A
Connection cable	H07RN-F	3G2.5 (3.3 m)	10 A/20.5 V–140 A/ 25.6 V
Fuse, delayed		16 A	10 A/10.5 V – 150 A/15.6 V
Welding range	MMA	10 A/20.5 V–140 A/25.6 V	85 V
	TIG	10 A/10.5 V – 150 A/15.6 V	0.60
Plug type		Schuko	0.80
Open circuit voltage		85 V (30 V/VRD)	1.5–3.25
Power factor at max current		0.60	320 x 123 x 265
Efficiency at max current		80 %	4.4
Stick electrode	ø mm	1.5–3.25	1.5–3.25
External dimensions	L x W x H, mm	320 x 123 x 265	320 x 123 x 265
Weight	kg	4	4

Minarc 150 Classic features an impact resistant case and controls protection.

Ordering information

Minarc 150 Classic		
Minarc 150, incl. earth and welding cable (3 m), connection cable with Schuko		6102150
Minarc 151, incl. earth and welding cable (3 m), connection cable		6101151
Minarc 150 VRD, incl. earth and welding cable (3 m), connection cable with Schuko		6102150VRD
Accessories		
Earth return cable	5 m, 16 mm^2	6184015
Welding cable	5 m, 16 mm^2	6184005
Carrying straps		9592162
TIG torch Flexlite TX 163 GVD94		TX163GVD94

Minarc 150 Classic is durable, ease to carry to site, with enough power to get the job done. Package includes electrode holder and welding cable set.

Minarc 220

Powerful, portable and compact

- Excellent welding quality and ignition dynamics
- Light weight, high power and duty cycle
- Ready to weld packages

Applications

- Metal workshops
- Construction industry
- Agriculture
- Repair and maintenance

For welding on the move

Minarc 220 is a three phase, 220A DC MMA welding power source, offering a truly portable specification for welding technicians on the move.

Ignition performance is excellent with all MMA electrode types and the TIG welding TouchArc function provides reliable DC TIG welding capability when combined with the Flexlite TX 223GVD134 TIG torch. Remote control for MMA and TIG is also possible with either the R10 remote control unit or the RTC10 torch control unit.

Technical specifications

Minarc 220			
Connection voltage	3~, 50/60 Hz		400 V -20 %…+15 %
Rated power	MMA	35 % ED	220 A
		100 % ED	150 A
Output 40 °C	MMA	35 % ED	220 A / 28.8 V
		60 % ED	170 A / 26.8 V
		100 % ED	150 A / 26.0 V
	TIG	35 % ED	220 A / 18.8 V
		60 % ED	180A / 17.2 V
		100 % ED	160 A / 16.4 V
Connection cable	H07RN-F		4G1.5 (5 m)
Fuse, delayed			10 A
Welding range	MMA		10 A / 20.4 V-220 A / 28.8 V
	TIG		10 A / 10.4 V-220 A / 18.8 V
Open circuit voltage			85 V (30 V/VRD)
Power factor at maximum current	MMA		0.91 (TIG 0.92)
Efficiency at max current			0.86 (TIG 0.80)
Stick electrode	ø		1.5–5.0 mm
External dimensions	L x W x H		400 × 180 × 340 mm
Weight			9.2 kg

Exceptional welding performance and compact size makes Minarc 220 ideal for maintenance workshops repairing heavy equipment.

Ordering information

Minarc 220, incl. earth return and welding cable (5 m), connection cable		6102220
Accessories		
Earth return cable	5 m, 25 mm^2	6184211
Welding cable	5 m, 25 mm^2	6184201
Carrying straps		9592162
TIG torch Flexlite TX 223GVD134		TX223GVD134

Minarc 220 for MMA site welding

Minarc 220 is easy to set. Electrode type selection ensures the best welding quality and you can also use an optional remote control to make fine current adjustments during welding.

Master S 400/500

Powerful, efficient, quality, value

Energy efficient

CE

- Powerful
- Compact
- Portable
- Reliable
- Easy to use

Special technology features

- **Hot start** and **arc force** adjustment for optimised starts and arc control with alternative electrode types, guaranteeing flawless and stable weld pool control every time.
- **Antifreeze** cuts off the power and protects the electrode if sticking occurs during welding
- **Contact ignition** (Lift TIG) in DC TIG
- **Arc gouging**
- **Parent power supply CC/CV** for Kemppi voltage-sensing wire feed systems and in-line TIG solutions.
- Including cellulose welding characteristics

A master of sites

Master S series MMA power sources are designed for high-performance professional welding. They offer a compact, robust and portable MMA power source with optimum energy efficiency. It is a perfect partner for heavy-duty welding work where the ease of use, reliability and durability are paramount.

- Powerful and portable MMA power source for professional workshop and site use
- Models available for all electrode types, including cellulosic electrodes
- Efficient output at 400/500 A 60% ED
- Robust structure for heavy-duty site use

Master S series are all about ease-of-use and performance. The powerful 400 or 500 amp power source provides great welding results with pleasurable welding experience. Mains and generator powered with wide voltage network tolerance. Integrated Voltage Reduction Device (VRD) increases safety at work. All this and more in a compact and lightweight design to make transportation and site management easy.

Technical specifications

Master S		S 400	S 500
Connection voltage	3~50/60 Hz	380 – 440 V (-10 %…+10 %)	380 – 440 V (-10 %…+10 %)
Rated power at max. current	60 % ED	20 kVA	26 kVA
Fuse (delayed)		25 A	35 A
Output at 40 °C MMA	60 % ED	400 A / 36 V	500 A / 40 V
	100 % ED	310 A / 32.4 V	390 A / 35.6 V
Output at 40 °C TIG	60 % ED	400 A / 26 V	500 A / 30 V
	100 % ED	310 A / 22.4 V	390 A / 25.6 V
Max. welding voltage		400 A / 48 V	500 A / 46V
Open circuit voltage		55 – 65 V	55 – 65 V
Stick electrodes		ø 1.6…6.0 mm	ø 1.6…7.0 mm
Welding current control		stepless	stepless
Power factor at 100 %		0.90	0.90
Efficiency at 100 %		0.89	0.89
Degree of protection		IP23S	IP23S
Operating temperature range		-20…+50 °C	-20…+50 °C
EMC class		A	A
External dimensions	L x W x H	570 x 270 x 340 mm	570 x 270 x 340 mm
Weight (without cables)		20.5 kg	23.5 kg

Ordering information

Master S		
Master S 400		632140001
Master S 500		632150001
Master S 500 offshore	For extreme conditions	632150001C1
Master S 400 AU*		6321400AU
Master S 500 AU*		6321500AU
Welding cable	5 m, 50 mm^2	6184501
	10 m, 50 mm^2	6184502
	5 m, 70 mm^2	6184701
	10 m, 70 mm^2	6184702
Earth return cable	5 m, 50 mm^2	6184511
	10 m, 50 mm^2	6184512
	5 m, 70 mm^2	6184711
	10 m, 70 mm^2	6184712
R10 Remote control	5m	6185409
	10m	618540901
R11-T Wireless remote control		6185442
Slide bars		SP007023

* The AU models are for the Australian and New Zealand markets.

Clear and easy to use interface including LCD display, plus selection of Arc dynamics and Hot start values.

R10

R11-T wireless remote control units can be used simply by touching the electrode

Gouging

If you are in need of a heavy duty carbon arc gouging solution, meet the KempGouge ARC 800. This mobile unit offers a fast, effective, and safe way to open roots or faulty welds, prepare welding grooves, cut metals, pierce holes, clean casts and remove excess metal.

KempGouge ARC 800

Mobile, heavy duty carbon arc gouging power

Energy efficient

50/60 Hz | 3 Phase | CC

- Designed specifically for carbon arc gouging
- Extremely power efficient
- Compact and easy to move
- Panel or remote current adjustment

Applications

- Shipyards
- Metal fabrication workshops
- Foundries

The heavy-duty gouging specialist

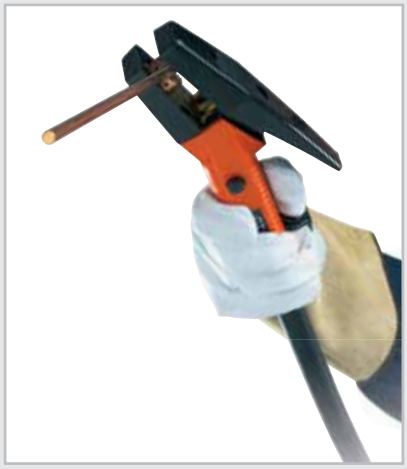
KempGouge offers 800 amps of gouging power with 50% duty cycle. The characteristics curve is specifically designed for carbon arc gouging, so gouging properties are optimised and noise levels kept very low. Package includes power source, control panel, and transport unit for easy mobility. KempGouge lets you open roots or faulty welds, prepare welding grooves, cut metals, pierce holes, clean casts and remove excess metal.

KempGouge ARC 800 gives productivity and convenience to gouging work. When equipped with the optional R10 remote control unit, gouging current adjustment can be made directly from the work site, removing the need to move between the work piece and the power source. The carbon arc gouging electrode holder GT4000 is designed for use with the KempGouge and suits either round or flat electrodes. The air pressure used for gouging can be adjusted via the control mounted on the holder itself.

KempGouge ARC 800 is a fast, effective, and safe way to:

- Open root welds
- Remove faulty welds and cracks
- Prepare welding grooves
- Cut metal
- Pierce holes

KempGouge ARC 800 makes easy work of carbon arc gouging tasks.



The carbon arc gouging electrode holder GT4000 is designed for use with the KempGouge and suits either round or flat electrodes.

KempGouge ARC 800 can be equipped with a R10 remote control unit, which enables gouging current adjustment directly from the work site.

A mobile, heavy duty carbon arc gouging power source for multiple type metals removal and cutting tasks.

Technical specifications

KempGouge™ ARC 800		
Connection voltage	3~, 50/60 Hz	400 V, -15…+20 %
Rated power at max. current	50 % ED	44 kVA
Output	50 % ED	800 A/44 V
	100% ED	600 A/44 V
Fuse		63 A delayed
Welding range		20 A/20 V…800 A/44 V
Connection cable	H07RN-F	4G16 (16 mm)
Open circuit voltage		50 V
Power ratio at 100 % ED		0.9
Efficiency at 100 % ED		0.90
External dimensions	L x W x H	700 x 660 x 1400 mm
Weight with transport unit		115 kg

Ordering information

Power Sources		
KempGouge ARC 800 (includes transport unit)		6284000
Cables		
Connection cable (incl. 63 A plug)	5 m, 4 x 16 mm^2	W000869
Connection cable (incl. 63 A plug)	10 m, 4 x 16 mm^2	W003408
Earth return cable	5 m, 120 mm^2	61841201
Earth return cable	10 m, 120 mm^2	61841202
Gouging electrode holder		
GT 4000 with 2.1 m cable		6285400
Remote control units		
R10 5 m		6185409
R10 10 m		618540901
Remote control extension cable for R10 10 m		6185481


KEMPPI
ArcValidator
L 650

Equipment validation

Kemppi reserves the right to change the information in this catalogue.
For the most up-to-date information, please check the offering at www.kemppi.com.

Welding equipment validation is required to make sure that the standardized level of accuracy and quality is maintained. ArcValidator is a systematic and accurate validation solution that links workshop and office based processes, meeting both local quality control and validation standards requirements to EN 50504.

ArcValidator

- Fast and accurate with all welding machine makes and models *
- Fully automated for the most sophisticated Kemppi equipment
- Step-by-step process guidance
- Includes PC software and certificate creation
- Integrated wire speed measurement
- Supports EN 50504 standards requirements

* Measuring accuracy up to 550 A

TIG MMA MIG

WELDING PROCESS COMPATIBLE

The complete solution for welding equipment validation

Next step solution

Kemppi ArcValidator is an automated and universal solution for validating arc welding equipment accuracy. ArcValidator solution speeds up the validation process up to 80 %.

Systematic and accurate welding equipment validation

ArcValidator brings a streamlined solution, supporting local quality control through standardised current and voltage validation measures. ArcValidator supports MMA, MIG/MAG as well as TIG welding processes and is universally compatible with almost any standard welding equipment with absolute unit meters.

Efficient, solution-oriented approach

ArcValidation guides and coaches the engineer throughout the validation process, using clear on-screen instructions. All validation data is recorded at the ArcValidator DataStick and used in creating the final validation reporting and the official certificate done on the ArcValidation PC software.

Each validation has a unique reference number, providing a valuable system asset when working at large scale sites, with welding machine fleets, or multiple small site customer service visits per working day.

Controlling quality made accurate and comparable

ArcValidator meets the very latest standards requirements, measuring the necessary components and making sure your welding equipment can meet the necessary standards for accurate setting to stated WPS/Quality process values.

ArcValidator RC records all individual validation process data for later transfer to the PC software.

ArcValidator load bank is easy to move around and a universal solution for multi-branded fleet validation.

ArcValidator PC software manages both the ‚pre and post' validation process and ensures easy pass certificate creation and accurate customer record keeping.

Why is arc equipment validation necessary?

Welding equipment validation is required to make sure that the standardised level of accuracy and quality is maintained. For example in MIG/MAG welding equipment, this is done by measuring the accuracy and consistency of the welding output - current, voltage as well as wire feed speed. Also the repeatability in setting of these parameters must be confirmed.

ArcValidator is founded on the requirements defined in the European Standard EN 50504 for validating arc welding equipment. ArcValidator's compliance with the validation standard is ensured by annual calibration and this can be completed by your Kemppi service workshop.

Clear and consistent reporting tools

are responsible for guaranteeing that validation data is recorded and presented clearly and accurately, and creating certificates is highly automised. Kemppi ArcValidation software for PC is simple to use, featuring clear and concise layouts, plus features a 'help and guidance' section for first time operators.

Automatic welding validation

With a range of advanced Kemppi FastMig and KempArc equipment, an automatic validation mode is also available. ArcValidator automatically controls and operates the validated equipment – a power source or a wire feeder – through the remote control connection during the validation process.

The user can choose either standard validation (normal accuracy) or precision validation (higher level of accuracy) according to European Standard EN 50504.

EN 1090 is the European standard you need to follow in order to get the CE marking required for steel structure manufacturing and construction. The requirements for arc welding equipment accuracy are defined in EN 60974-1.

Application software

Kemppi reserves the right to change the information in this catalogue.
For the most up-to-date information, please check the offering at www.kemppi.com.

Kemppi application software is designed to make the welding equipment perform optimally in any welding situation. Wise special processes and functions provide excellent welding process techniques and influence the efficiency of welding performance.

Wise Processes

Manage welding skill, **productivity and quality**

Finding the best solutions to problematic welding cases, Wise™ software product family has been developed and tested together with industrial partners, and proved inside production environments. Wise products are welding software solutions, enabling levels of welding performance that otherwise would be impossible to achieve with standard MIG/MAG welding process. Use Wise products for enhanced root closure, constant power management, automated arc length control and precise thin sheet welding.

	Order code	FastMig M	FastMig Pulse	FastMig X	X8 MIG Welder
WiseRoot	6265011	●	●		
WiseRoot+	9990418			●	●
WiseThin	9991013	●	●		
WiseThin+	9990419			●	●
WisePenetration	9991000	●	●	●	
WisePenetration+	X8500002				●
WiseFusion	9991014	●	●	●	●
WiseSteel	X8500001				●

- Produces high quality root welds
- Allows wide root gap tolerance
- No need for backing ring or ceramics
- Three times faster than TIG welding
- Easy to learn and use
- Saves rework costs
- Can decrease joint volume in thick materials, reducing filler materials volume and cost

WiseRoot

WiseRoot is a highly efficient and unique tailored cold arc process for manual and automated root pass welding in ferrous and stainless steel materials. Designed for the effective closure of root joints and tolerance of gaps created by poor joint fit-up, WiseRoot is three times faster in root welding than TIG process, is easy to learn and use and saves time on rework costs. Traditionally, welding engineers have been reluctant to employ the standard MIG/MAG process for quality root welding, due to known quality issues. However Kemppi WiseRoot is everything but traditional and is now a proven and accepted root welding solution.

- Best root pass welding on the market
- Produces premium root welds
- Allows wide root gap tolerance
- No need for backing ring or ceramics
- Three times faster than TIG welding
- Very easy to learn and use
- Saves rework costs
- Can decrease joint volume in thick materials, reducing filler materials volume and cost
- Excellent CO_2 welding characteristics

WiseRoot+

WiseRoot+ is a highly efficient and unique tailored arc process for manual and automated root pass welding in ferrous and stainless steel materials. WiseRoot+ process is based on a precise voltage measurement and current control. Specific voltage sensing cable ensures getting actual information from the arc. Only two parameter regulations needed. Wire feed speed and fine tuning. Excellent welding characteristics also with longer cables (up to 30 m). High efficient process » 10% faster than normal MAG welding.

WiseThin

WiseThin is a tailored cold arc process for manual and automated thin sheet welding and brazing. Typical applications include automotive manufacturing and quality light plate fabrication in ferrous and stainless steel materials.

- Reduces spatter with all materials including zinc-coated plates
- Provides 10–25 % lower heat input than normal MIG/MAG welding, reducing post weld material distortion
- Excellent weld pool control with varying joint geometry and fit-up
- Reduced post weld rework
- Increased welding speed in many applications

WiseThin+

WiseThin+ is a tailored cold arc process for manual and automated thin sheet welding. WiseThin+ process is based on precise voltage measurement and current control Mixed gas welding characteristics with pure CO_2. Expands the parameter window and thus reduces the need to use smaller wire diameters. Soft pleasant arc characteristics Excellent welding characteristics for welding plate thicknesses 0.8…3.0 mm. Reduces heat input and thus also deformation. Excellent arc ignition for tack and intermittent welds.

- Excellent CO_2 welding characteristics
- Saves welding costs
- Down hand and all positional welding
- Reduces the amount and size of spatters
- Easy to use
- Produces high quality welds
- Reduced post weld rework
- Higher welding speed than in traditional shot arc welding
- Stable arc for positional welding for thicker plate thicknesses

WisePenetration

WisePenetration delivers consistent power to the weld pool regardless of distance changes and deviations between the welding gun nozzle and work piece. Suitable for both manual and automated synergic MIG/MAG welding, WisePenetration solves some age old problems.

- Reduces the risk for lack of fusion
- Reduces the need for welding parameter adjustments
- Saves rework time and cost through reductions in weld defects
- Easy to use and deploy into production
- Suitable for use with long or short cable sets
- Can reduce welding time and filler materials costs

WisePenetration+

WisePenetration+ is a welding function for synergic and pulsed MIG/MAG welding. It ensures weld penetration regardless of variation in the contact-tip-to-work distance and keeps the welding power stabilized in all situations.

- Exceptionally stable and intense welding arc
- Enables the welding of deep, narrow grooves
- Ensured penetration even in case of limited visibility or accessibility
- Improved weld quality with less spatter
- Less rework required
- Savings in filler material costs

WiseFusion

WiseFusion creates and maintains an optimal short-circuit characteristic in pulsed MIG/MAG and spray-arc welding applications. Keeping the arc length optimally short for manual and automated welding, WiseFusion ensures consistent weld quality in all positions, and once set, eliminates the need for regular parameters adjustments.

- Automatic arc length regulation for pulsed MIG/MAG and spray-arc welding
- Excellent weld pool control for out-of position welding
- Narrow and energy-dense arc
- Improved weld quality and appearance
- Increased welding speed

WiseSteel

WiseSteel is a welding function especially designed to tackle the challenges of globular transfer. It alternates short arc transfer with spray transfer, which reduces spatter by up to 30%, and produces high-quality welds characterized by a regular fish-scale pattern. In the spray arc mode it increases travel speed up to 30%.

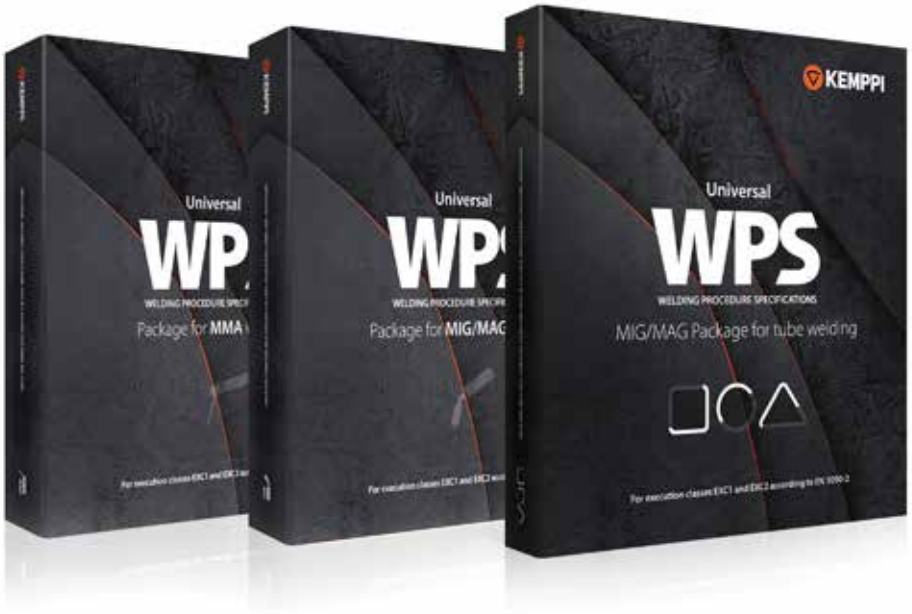
- Easy and efficient MIG welding of carbon steels
- Easier weld pool control in the PF position
- Precise heat input control on the weld pool sides
- Higher travel speed increases productivity
- Less distortion with high-energy-density arc
- Reduced droplet size enables welding in vertical and overhead positions
- Savings in grinding and straightening costs


WPS
KEMPPI

Welding procedure specifications

To meet the requirements of the EN 1090-2 standard, Kemppi offers Universal WPS packages for workshops and on-site projects. Our welding procedure specifications for both the MIG/MAG and stick (MMA) welding are compatible with all welding machine brands and comply with the standards ISO 15612 and EN 1090-2.

Universal WPS
For all welding equipment brands



Get the jump on EN 1090 with Kemppi

Benefits

- The most comprehensive solution on the market, covering workshop as well as on-site work for both MIG/MAG and MMA welding.
- All three packages can be used with all brands of welding machines.
- MIG/MAG package offers support for solid, flux-cored and metal-cored wires, and it contains 84 qualified and tested MIG/MAG WPSs.
- MIG/MAG package for tube welding contains 28 WPSs for structural tubes and pipes.
- MMA contains 28 WPSs and includes practical information for welding of truss connections.
- All packages are valid also when impact-strength requirements apply. For more information on filler material classification, visit www.kemppi.com/wps.
- Tailored WPSs available on request to fit specific production needs.

Kemppi Universal WPS packages

From 1 July 2014, all structural steel and aluminium products within EU must be CE marked, as stated in the Construction Products Regulation (CPR). This will bring great change in the life of workshops manufacturing structural steel buildings and their site erection process, because they must comply with the EN 1090-2 standard.

A comprehensive solution for workshop and on-site work and all welding equipment brands
To meet the requirements of the EN 1090-2 standard, we offer universal WPS (welding procedure specifications) packages for workshop and project-site use. These WPSs apply to both MIG/MAG and MMA welding. Kemppi is the first welding machine manufacturer in the world to offer Universal WPS package sets that support the constantly changing environments of workshops and construction sites, where there is a strong need for clear and simple instructions.

Kemppi Universal WPSs are compatible with all brands of welding machines
Kemppi WPSs for both MIG/MAG and MMA welding are compatible with all welding machine brands. Having a versatile fleet of welding machines is not a problem; Kemppi WPSs can be used with all of them. The universal welding procedure specifications comply in full with EN ISO 15612 and can be used for steel structures in execution classes EXC1 and EXC2 according to EN 1090-2.

Just one WPS package needed per site
You won't have to buy a separate licence for each welding machine. Our WPSs are valid in workshops and sites running under the same technical and quality control.

Universal WPSs for MIG/MAG welding in workshops
This comprehensive package contains 84 MIG/MAG WPSs that are compatible with all MIG/MAG welding machines. They cover some of the most used solid, metal cored and flux cored wires.

Universal WPSs for MIG/MAG tube welding
This new package with 28 WPSs is developed specifically for MIG/MAG butt welding of structural tubes and pipes. They cover some of the most used solid and flux cored wires. As a bonus, the package contains eight WPSs for Kemppi WiseRoot+ welding process.

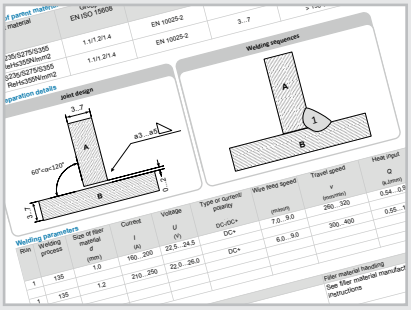
Universal WPSs for MMA welding on work sites
Kemppi's universal WPS package for MMA welding is based on customer needs. It contains all necessary welding procedure specifications, compatible with all MMA welding machines.

Welding Procedure Qualification Records (WPQR)
You and your auditor can see all Welding Procedure Qualification Records (WPQRs) associated with the Welding Procedure Specifications right after you've purchased the WPS package and registered your user account on our WPS Service site.

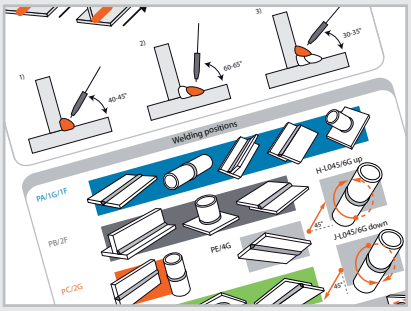
Contents of the Kemppi Universal WPS package
The WPS packages contain a binder and a USB memory stick. The binder contains the End User License Agreement (EULA), instructions for use and registration, serial number of the package and the laminated WPS documents (84 for MIG/MAG, 28 for MIG/MAG tube welding and 28 for MMA) in English. The USB memory stick contains the official PDF documents to verify the validity of Kemppi's standard WPS documents and the access to WPS administration site and to different language versions of the WPS documents.

Kemppi WPS Service site for registration, administration and updates
Kemppi WPS online service helps you register and manage your WPSs and WPQRs (Welding Procedure Qualification Records). It also provides an access to latest language versions and revisions of the WPS documents. The WPSs are available in many different languages.

Where to buy
Providing you hold an active Kemppi trading account, you can buy the Universal WPS packages directly fromKemppi Channel or from dealers and distributors.



Clear and easy-to-read welding instructions



Every WPS sheet has detailed illustrations of welding positions and angles described on the backside

WPS USB stick containing documents and web links is delivered together with the WPS packages

Ordering codes

Package type	Ordering code
Universal WPS package for MIG/MAG	6800003
Universal WPS package for MMA	6800002
Universal WPS package for MIG/MAG tube welding	6800005

For more information, please visit our WPS Service Site at
http://www.kemppi.com/wps

You can also contact our experts directly at
weldingservices@kemppi.com

Accessories

Remote controls, electrode holders, transport units, protection sliders... you name it. Kemppi accessories complement your equipment for an outstanding welding experience.

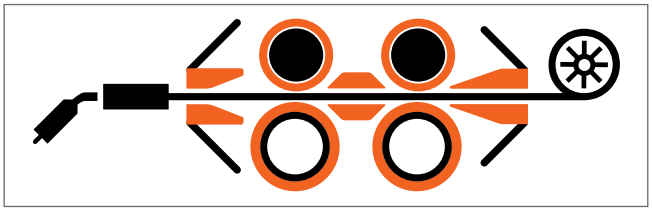
Wire feed mechanism consumable kits

Kemppi wire feeder with original consumables guarantees trouble-free operation in all your demanding application. With high quality consumables you gain excellent stability and exact start and stop accuracy of welding wire.

Kemppi wire feeder consumable kits include consumables that need periodic replacement to keep the wire feeder running and suitable for various welding jobs.

For more information on suitability of consumables, please visit Kemppi Kit Selector at www.kemppi.com.

F000318	Fe	0.8-0.9	V	HD
↑	↑	↑	↑	↑
Kit	**Material**	**Size**	**Groove**	**Feed Roll**
1	2	3	4	5



Typical wire feed mechanism

1 Contents of the kit *

2	Lower feed roll (Metal)	
2	Upper feed roll (Metal)	
1	Middle guide tube (Plastic)	
1	Outlet guide tube (Metal)	
1	Inlet guide tube (Metal)	

* This is an example of a typical consumable kit. The number of feed rolls depends on the wire feeder type.

2 Material of the wire

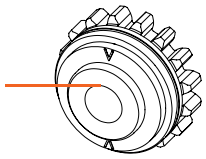
Fe	Steel	**MC**	Metal-cored wire
Al	Aluminium	**Cu**	Copper
FC	Flux-cored wire	**Ss**	Stainless steel

3 Size of the wire (mm)

	1	ø 0.6
	1	ø 0.8-0.9
	1	ø 1.0
	1	ø 1.2
	1	ø 1.4
	1	ø 1.6
	1	ø 2.0
	1	ø 2.4

4 Groove type

U	U Groove	U
V	Plain V Groove	V
VK	Knurled V Groove	V≡
T	Trapezoid groove	



5 Feed Roll

-	Standard, plastic feed roll
HD	Heavy duty, metal feed roll

For more information on suitability of consumables, please visit Kemppi **Kit Selector** at kitselect. kemppi.com.

Wire feed mechanism consumable kits

FastMig MF 29

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD
F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD
F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-
F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

FastMig MF 33
ArcFeed 200/300/300P/300RC

F000292	Al	1.0/1.2	U	-
F000293	Al	1.2	T	-
F000294	Al	1.2/1.6	U	-
F000295	Al	1.4	T	-
F000296	Al	1.6	T	-
F000297	Al	2.0	T	-
F000298	Al	2.4	T	-
F000276	Fe	0.6/0.8	V	-
F000277	Fe	0.8	V	-
F000278	Fe	1.0	V	-
F000279	Fe	1.0/1.2	V	-
F000280	Fe	1.2	V	-
F000281	Fe	1.4-1.6/2.0	V	-
F000282	Fe	1.6	V	-
F000283	Fe	2.4	V	-
F000284	Fe	3.2	V	-
F000299	MC/FC	1.0/1.2	VK	-
F000300	MC/FC	1.2	VK	-
F000301	MC/FC	1.4-1.6/2.0	VK	-
F000302	MC/FC	1.6	VK	-
F000303	MC/FC	2.4	VK	-
F000304	MC/FC	3.2	VK	-
F000285	Ss	0.8	V	-
F000286	Ss	1.0	V	-
F000287	Ss	1.0/1.2	V	-
F000288	Ss	1.2	V	-
F000289	Ss	1.4-1.6/2.0	V	-
F000290	Ss	1.6	V	-
F000291	Ss	2.4	V	-

FastMig MSF 53, 55, 57

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD
F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD

U = U Groove
V = Plain V Groove
VK = Knurled V Groove
T = Trapezoid Groove
- = Standard (contains plastic feed roll)
HD = Heavy Duty kit (contains metal feed rolls)
MC/FC = Metal/Flux Cored

For more information, open **Consumable Kit Selector** on kitselect.kemppi.com.

F000318	Fe	0.8-0.9	V	HD
↑	↑	↑	↑	↑
Package	**Material**	**Size**	**Groove**	**Feed Roll**

F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-
F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

FastMig MXF 63, 65, 67 WFX 200, WFX 300

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000365	Al	1.4	U	-
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD
F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD
F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-
F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

Wire feed mechanism consumable kits

FastMig WFX 300 P

F000273	Al	1.0	U	-
F000274	Al	1.2	U	-
F000365	Al	1.4	U	-
F000275	Al	1.6	U	-
F000342	Fe	0.8-0.9	V	-
F000260	Fe	0.8-0.9	V	HD
F000338	Fe	0.8-0.9	V	HD
F000343	Fe	1.0	V	-
F000261	Fe	1.0	V	HD
F000339	Fe	1.0	V	HD
F000344	Fe	1.2	V	-
F000262	Fe	1.2	V	HD
F000340	Fe	1.2	V	HD
F000345	Fe	1.6	V	-
F000263	Fe	1.6	V	HD
F000341	Fe	1.6	V	HD
F000346	Fe	2.0	V	-
F000347	Fe	2.4	V	-
F000252	Fe, Cu	0.6	V	-
F000253	Fe, Cu	0.8-0.9	V	-
F000254	Fe, Cu	1.0	V	-
F000255	Fe, Cu	1.2	V	-
F000256	Fe, Cu	1.4	V	-
F000257	Fe, Cu	1.6	V	-
F000258	Fe, Cu	2.0	V	-
F000259	Fe, Cu	2.4	V	-
F000342	MC/FC	0.8-0.9	V	-
F000260	MC/FC	0.8-0.9	V	HD
F000343	MC/FC	1.0	V	-
F000261	MC/FC	1.0	V	HD
F000264	MC/FC	1.0	VK	-
F000269	MC/FC	1.0	VK	HD
F000344	MC/FC	1.2	V	-
F000262	MC/FC	1.2	V	HD
F000265	MC/FC	1.2	VK	-
F000270	MC/FC	1.2	VK	HD
F000266	MC/FC	1.4-1.6	VK	-
F000271	MC/FC	1.4-1.6	VK	HD
F000345	MC/FC	1.6	V	-
F000263	MC/FC	1.6	V	HD
F000346	MC/FC	2.0	V	-
F000347	MC/FC	2.4	V	-
F000267	MC/FC	2.0	VK	-
F000272	MC/FC	2.0	VK	HD
F000268	MC/FC	2.4	VK	-
F000252	Ss	0.6	V	-
F000253	Ss	0.8-0.9	V	-
F000338	Ss	0.8-0.9	V	HD
F000254	Ss	1.0	V	-
F000339	Ss	1.0	V	HD
F000255	Ss	1.2	V	-
F000340	Ss	1.2	V	HD
F000256	Ss	1.4	V	-
F000257	Ss	1.6	V	-
F000341	Ss	1.6	V	HD
F000258	Ss	2.0	V	-
F000259	Ss	2.4	V	-

FitWeld Evo 300

F000335	Fe	0.8/0.9	V	-
F000336	Fe	1.0	V	-
F000245	Fe	1.0	V	HD
F000348	Fe	1.0	V	HD
F000337	Fe	1.2	V	-
F000246	Fe	1.2	V	HD
F000349	Fe	1.2	V	HD
F000334	Fe, Cu	0.8/0.9	V	-
F000243	Fe, Cu	1.0	V	-
F000244	Fe, Cu	1.2	V	-
F000335	MC/FC	0.8/0.9	V	-
F000336	MC/FC	1.0	V	-
F000245	MC/FC	1.0	V	HD
F000248	MC/FC	1.0	VK	-
F000250	MC/FC	1.0	VK	HD
F000337	MC/FC	1.2	V	-
F000246	MC/FC	1.2	V	HD
F000249	MC/FC	1.2	VK	-
F000251	MC/FC	1.2	VK	HD
F000334	Ss	0.8/0.9	V	-
F000243	Ss	1.0	V	-
F000348	Ss	1.0	V	HD
F000244	Ss	1.2	V	-
F000349	Ss	1.2	V	HD

Kempact MIG 2530

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD
F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD
F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-

U = U Groove
V = Plain V Groove
VK = Knurled V Groove
T = Trapezoid Groove
- = Standard (contains plastic feed roll)
HD = Heavy Duty kit (contains metal feed rolls)
MC/FC = Metal/Flux Cored

For more information, open **Consumable Kit Selector** on kitselect.kemppi.com.

F000318	Fe	0.8-0.9	V	HD
↑	↑	↑	↑	↑
Package	**Material**	**Size**	**Groove**	**Feed Roll**

F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

Kempact Pulse 3000

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD
F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD
F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-
F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

Kempact Pulse 3000 MVU

F000223	Al	1.0	U	-
F000226	Al	1.0	U	HD
F000224	Al	1.2	U	-
F000227	Al	1.2	U	HD
F000225	Al	1.6	U	-
F000228	Al	1.6	U	HD

Wire feed mechanism consumable kits

F000322	Fe	0.8-0.9	V	-
F000210	Fe	0.8-0.9	V	HD
F000318	Fe	0.8-0.9	V	HD
F000323	Fe	1.0	V	-
F000211	Fe	1.0	V	HD
F000319	Fe	1.0	V	HD
F000324	Fe	1.2	V	-
F000212	Fe	1.2	V	HD
F000320	Fe	1.2	V	HD
F000325	Fe	1.4	V	-
F000326	Fe	1.6	V	-
F000213	Fe	1.6	V	HD
F000321	Fe	1.6	V	HD
F000327	Fe	2.0	V	-
F000328	Fe	2.4	V	-
F000202	Fe, Cu	0.6	V	-
F000203	Fe, Cu	0.8-0.9	V	-
F000204	Fe, Cu	1.0	V	-
F000205	Fe, Cu	1.2	V	-
F000206	Fe, Cu	1.4	V	-
F000207	Fe, Cu	1.6	V	-
F000208	Fe, Cu	2.0	V	-
F000209	Fe, Cu	2.4	V	-
F000322	MC/FC	0.8-0.9	V	-
F000210	MC/FC	0.8-0.9	V	HD
F000323	MC/FC	1.0	V	-
F000211	MC/FC	1.0	V	HD
F000214	MC/FC	1.0	VK	-
F000219	MC/FC	1.0	VK	HD
F000324	MC/FC	1.2	V	-
F000212	MC/FC	1.2	V	HD
F000215	MC/FC	1.2	VK	-
F000220	MC/FC	1.2	VK	HD
F000325	MC/FC	1.4	V	-
F000216	MC/FC	1.4-1.6	VK	-
F000221	MC/FC	1.4-1.6	VK	HD
F000326	MC/FC	1.6	V	-
F000213	MC/FC	1.6	V	HD
F000327	MC/FC	2.0	V	-
F000217	MC/FC	2.0	VK	-
F000222	MC/FC	2.0	VK	HD
F000328	MC/FC	2.4	V	-
F000218	MC/FC	2.4	VK	-
F000202	Ss	0.6	V	-
F000203	Ss	0.8-0.9	V	-
F000318	Ss	0.8-0.9	V	HD
F000204	Ss	1.0	V	-
F000319	Ss	1.0	V	HD
F000205	Ss	1.2	V	-
F000320	Ss	1.2	V	HD
F000206	Ss	1.4	V	-
F000207	Ss	1.6	V	-
F000321	Ss	1.6	V	HD
F000208	Ss	2.0	V	-
F000209	Ss	2.4	V	-

Kempact RA 181A, 251 R, 251 A

F000241	Al	1.0	U	-
F000242	Al	1.2	U	-
F000333	Cu	0,6	V	-
F000236	Cu	0.8-0.9	V	-
F000237	Cu	1.0	V	-
F000238	Cu	1.2	V	-
F000333	Fe	0,6	V	-
F000236	Fe	0.8-0.9	V	-
F000237	Fe	1.0	V	-
F000238	Fe	1.2	V	-
F000239	MC/FC	1.0	VK	-
F000240	MC/FC	1.2	VK	-
F000333	Ss	0.6	V	-
F000236	Ss	0.8-0.9	V	-
F000237	Ss	1.0	V	-
F000238	Ss	1.2	V	-

Kempact RA 253R, 253A, 253RMW, 253AMV, 323R, 323A, 323RMV, 323AMV

F000234	Al	1.0	U	-
F000235	Al	1.2	U	-
F000330	Fe	0.8-0.9	V	-
F000331	Fe	1.0	V	-
F000332	Fe	1.2	V	-
F000329	Fe, Cu	0.6	V	-
F000229	Fe, Cu	0.8-0.9	V	-
F000230	Fe, Cu	1.0	V	-
F000231	Fe, Cu	1.2	V	-
F000330	MC/FC	0.8-0.9	V	-
F000331	MC/FC	1.0	V	-
F000332	MC/FC	1.2	V	-
F000232	MC/FC	1.0	VK	-
F000233	MC/FC	1.2	VK	-
F000329	Ss	0.6	V	-
F000229	Ss	0.8-0.9	V	-
F000230	Ss	1.0	V	-
F000231	Ss	1.2	V	-

X8 Wire Feeder

F000451	Al	1.0	U	-
F000452	Al	1.2	U	-
F000453	Al	1.4	U	-
F000454	Al	1.6	U	-
F000421	Fe	0.8-0.9	V	-
F000427	Fe	0.8-0.9	V	HD
F000439	Fe	0.8-0.9	V	HD
F000422	Fe	1.0	V	-
F000428	Fe	1.0	V	HD
F000440	Fe	1.0	V	HD

U = U Groove
V = Plain V Groove
VK = Knurled V Groove
T = Trapezoid Groove
- = Standard (contains plastic feed roll)
HD = Heavy Duty kit (contains metal feed rolls)
MC/FC = Metal/Flux Cored

For more information, open **Consumable Kit Selector** on kitselect.kemppi.com.

F000318	Fe	0.8-0.9	V	HD
↑	↑	↑	↑	↑
Package	**Material**	**Size**	**Groove**	**Feed Roll**

F000423	Fe	1.2	V	-
F000429	Fe	1.2	V	HD
F000463	Fe	1.2	V	HD
F000424	Fe	1.6	V	-
F000430	Fe	1.6	V	HD
F000441	Fe	1.6	V	HD
F000425	Fe	2,0	V	-
F000426	Fe	2,4	V	-
F000431	Fe, Cu	0.6	V	-
F000432	Fe, Cu	0.8-0.9	V	-
F000433	Fe, Cu	1.0	V	-
F000434	Fe, Cu	1.2	V	-
F000435	Fe, Cu	1.4	V	-
F000436	Fe, Cu	1.6	V	-
F000437	Fe, Cu	2.0	V	-
F000438	Fe, Cu	2.4	V	-
F000421	MC/FC	0.8-0.9	V	-
F000427	MC/FC	0.8-0.9	V	HD
F000422	MC/FC	1.0	V	-
F000428	MC/FC	1.0	V	HD
F000442	MC/FC	1.0	VK	-
F000447	MC/FC	1.0	VK	HD
F000423	MC/FC	1.2	V	-
F000429	MC/FC	1.2	V	HD
F000443	MC/FC	1.2	VK	-
F000448	MC/FC	1.2	VK	HD
F000444	MC/FC	1.4-1.6	VK	-
F000449	MC/FC	1.4-1.6	VK	HD
F000424	MC/FC	1.6	V	-
F000430	MC/FC	1.6	V	HD
F000425	MC/FC	2,0	V	-
F000426	MC/FC	2,4	V	-
F000445	MC/FC	2.0	VK	-
F000450	MC/FC	2.0	VK	HD
F000446	MC/FC	2.4	VK	-
F000431	Ss	0.6	V	-
F000432	Ss	0.8-0.9	V	
F000439	Ss	0.8-0.9	V	HD
F000433	Ss	1.0	V	-
F000440	Ss	1.0	V	HD
F000434	Ss	1.2	V	-
F000463	Ss	1.2	V	HD
F000435	Ss	1.4	V	-
F000436	Ss	1.6	V	-
F000441	Ss	1.6	V	HD
F000437	Ss	2.0	V	-
F000438	Ss	2.4	V	-

X8 SuperSnake GT02XX/M

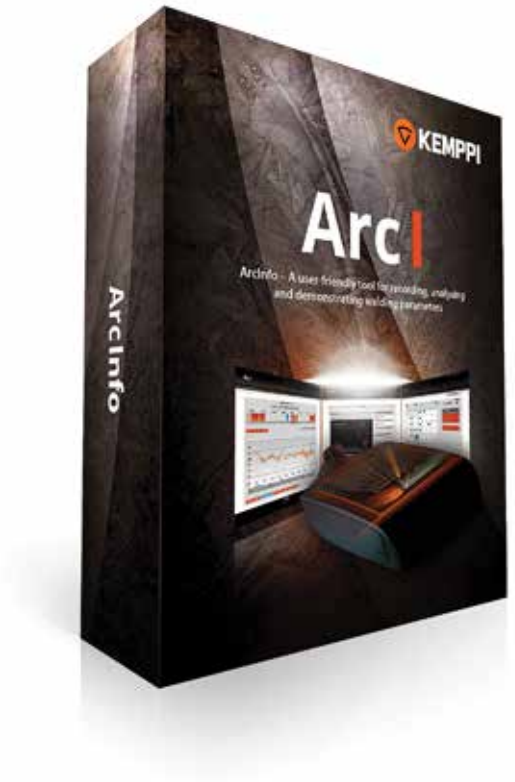
F000464	Fe	1.0	V	-
F000465	Fe	1.2	V	-
F000466	Fe	1.6	V	-
F000466	Fe	1.6	V	HD
F000468	Fe	1.2	V	HD
F000469	Fe	1.6	V	HD
F000470	Ss	1.0	V	-
F000471	Ss	1.2	V	-
F000472	Ss	1.4	V	-
F000473	Ss	1.6	V	-
F000474	Ss	1.0	V	HD
F000475	Ss	1.2	V	HD
F000476	Ss	1.6	V	HD
F000478	MC/FC	1.2	VK	-
F000479	MC/FC	1.4-1.6	VK	-
F000481	MC/FC	1.2	VK	HD
F000482	MC/FC	1.4-1.6	VK	HD
F000484	Al	1.2	U	-
F000485	Al	1.4	U	-
F000486	Al	1.6	U	-

SuperSnake for FastMig X/M

W004280	Al	1.2	U	-
W010104	Al	1.6	U	-
W004276	Fe	0.8-0.9	V	-
W004277	Fe	1.0	V	-
W004278	Fe	1.2	V	-
W004279	Fe	1.6	V	-
W004281	MC/FC	1.2	VK	-
W006608	MC/FC	1.6	VK	-

ArcInfo

Weld data analysing tool



Benefits

- Easy-to-use web based service
- Illustrative presentation of welding values
- Great value for schools and workshops
- Improves welding training and research
- Provides factual basis for cost calculation
- Facilitates welding procedure qualification test

The quick way of analysing welding data

Recording parameters

Welding parameters are a crucial factor in the welding quality. Welding current, welding voltage, wire feed rate, welding speed and heat input during the weld, among other parameters, also affect welding efficiency and costs. ArcInfo converts the raw data into a format that is easy to understand and take in. Usability and visual clarity are the cornerstones of its design.

Online service

The ArcInfo online service gives a visual presentation of the measuments. The reports are accurate and indisputable but also visually clear and impressive. Processing and storing data is easier than ever.

Use the data to create your own WPSs

You can load a pWPS (Preliminary Welding Procedure Specification) template from ArcInfo and use the ArcInfo welding data you have gathered to create your own WPS after successful qualification of the pWPS.

How does ArcInfo work?

For the data collection, the DataCatch device is connected to a welding machine, either FastMig Pulse, FastMig KMS, FastMig X or FastMig M. After welding, DataCatch is connected to a computer and the data can be accessed straight away on the internet. ArcInfo being a web-based service, there is no need to worry about program updates, with the latest version always automatically available.

New dimension of learning

ArcInfo boosts the learning process. Trainers can now make the teaching of welding techniques more illustrative and motivating, adding new depth to the learning process. ArcInfo also guides the trainees to more information on the internet.

FastMig **DataCatch** **Laptop Computer** **ArcInfo cloud service**

Just "Connect and Click" to collect welding data from your machine and transfer it into the ArcInfo cloud.

Keep DataCatch attached to the welding machine from which you want to collect welding data. Connect DataCatch to your computer and click to transfer the data into the ArcInfo service. Start analysing the welding data.

1. Easy-to-understand timeline presentation of the welds
2. Illustrative view on the welding values of each weld.
3. Plenty of useful information about some of the most common weld defects.

Ordering information

ArcInfo	6265032

DataCatch device enables data collection

View and assess data on your computer

Remote controls

C100C R10 R20 11T R30

Increase welding quality, work efficiency, comfort and safety with appropriate, easy to use remote controls. Gun remotes, hand-held and pedal control units reduce the need for movement between workplace and power source, increasing work efficiency and reducing fatigue.

Remote controls	C100C	C100C	R10	R10	R20	R11T	R30	R30
Length (m)	5	10	5	10	5		5	10
Order code	6185410	6185411	6185409	618540901	6185419	6185442	6185420	618542001
FastMig M			●	●	●		● (MXF)	● (MXF)
FastMig X							●	●
Minarc 220			●	●				
MinarcTig			●	●				
MasterTig MLS			●	●		●		
MasterTig MLS ACDC			●	●				
MasterTig ACDC	●	●						
Master MLS			●	●		●		
KempGouge ARC 800			●	●				
Master S			●	●		●		

C100F R11F FR43 FR45

Remote controls	C100F	R11F	FR43	FR45
Length (m)	5	5	5	
Order code	6185405	6185407	FR43	FR45
New MasterTig			●	●
MinarcTig		●		
MasterTig MLS		●		
MasterTig MLS ACDC		●		
MasterTig 3500 ACDC	●			

Ancillary products

Earth clamps/Connection		Order code
Kemppi 200, 200A	25…35 mm, cable shoe connection ø 6 mm	9871531
Kemppi 300, 300A	50…70 mm, cable shoe connection ø 6 mm, copper braid between the connector jaws	9871540
Kemppi 500, 500A	70…95 mm, cable shoe connection ø 8 mm, copper braid between the connector jaws	9871541
Kemppi G- 600, 600A	35…120 mm, cable connection with hex screw, brass frame, screw-type	9871560

Electrode holders	60/35 % ED, current rating	Weight (g) / cable size (mm^2)	Order code
KEMPPI 300	150/200, 300 A	321/16–25	9871021
KEMPPI 400	200/250, 400 A	421/16–25	9871031
URANIA 5	250/300, 500 A	500/35–50	9871041
URANIA 6	300/400, 600 A	855/50–70	9871051
MYKING 200	200 A	285/10–25	9871060
MYKING 450	450 A	485/35–70	9871070
MYKING 600	600 A	535/50–70	9871080

All have a copper alloy frame and cable connection with a hex screw

Cable connectors		Order code	Order code
Current durability A	Cable mm^2	Male	Female
200	10…25	9771650	9771626
250	35	9771671	9771628
315	50	9771670	9771627
400	70	9771680	9771629
500	95		9771630
600	95	9771681	
Branch connector (1 male and 2 female connections)	70/90		9771637

Ancillary products

	Ordering code	MXF 63	MXF 65	MXF 67	WFX 300 P	WFX 300/300 AMC	ArcFeed	X8 Welder
KV 401 swing boom arm	6185248		●	●	●	●	●	
MXF 63 hanging frame	6185285	●						
KFH 1000	6185100	●	●	●	●	●	●	
KWF 300 protection sliders	6185287				●			
MF 65 hanging kit	W001694		●					
KWF 200/300 cabinet heater	6185288	●	●	●	●	●		
KV 200	6185249	●	●	●	●	●	●	
Gas guard 200/300	6237406	●	●	●	●	●		
Wire Feeder Rotating Plate	X8702010000							●
Double Wire Feeder Rotating Plate	X8702020000							●
Wire Feeder Counterbalance Arm	X8702030000							●
Wire Feeder Hanger For Boom	X8702040000							●
Cable Rack	X8701030000							●
Accessory Tray	X8701040000							●

Euro adapter for MinarcMig and MinarcMig Evo	
Euro adapter kit	W008366
Wire liner, 0.6–0.8 mm for Euro adapter	SP008578
Red wire liner, 0.9–1.0 mm for Euro adapter	SP008856

Gun holders	
GH 10 Gun Holder	6256010
GH 20 Gun Holder	6256020
GH 30 Gun Holder	6256030

EURO ADAPTER FOR MINARCMIG AND MINARCMIG EVO

GH 10 GUN HOLDER

GH 20 GUN HOLDER

GH 30 GUN HOLDER

GAS GUARD 200/300

Gun holders are primarily intended to be attached to welding machines, but they can also be attached to transport units and welding tables.

KWF 200/300 CABINET HEATER

KV 401 SWING BOOM ARM

KV 200 MOUNTING PLATE FOR TWO WIRE FEEDERS

MXF 63
HANGING FRAME

MF 65 HANGING KIT

KFH 1000

KWF 300
PROTECTION SLIDERS

WIRE FEEDER
ROTATING PLATE

DOUBLE WIRE
FEEDER ROTATING
PLATE

COUNTER BALANCE
ARM

WIRE FEEDER
HANGER FOR BOOM

CABLE RACK

ACCESSORY
TRAY

2-wheel transport units

MST 400*

ST 7*

T 10

T 110*

T 130

T 25MT

* Recommended for smaller gas bottle sizes

	Order code	Weight, kg	Master MLS 2500, 3500	MasterTig MLS 2000	MasterTig MLS 3000, 4000	MasterTig MLS 3000, 4000 MasterCool 10	MasterTig ACDC 3500W	FastMig M + X (T 10 installation set W002085)	FastMig M + X (T 120 installation set W003053)	FitWeld 300	Kempact Pulse 3000	MinarcMig and MinarcMig Evo	Minarc Tig and MinarcTig Evo	Minarc 220
MST 400	6185294	11.8										●	●	●
ST 7	6185290	17								●				
T 10	6185231	18						●						
T 110	6185251	18	●	●	●									
T 130	6185222	23	●	●	●	●						●*		
T25MT	T25MT	31		●	●	●								

* Bracket W015944 is required.

4-wheel transport units

P 20

PM 500

T 22

X8 Gas Cylinder Cart

X8 MIG Welder wheel set

PM 501

P45MT

	Order code	Weight kg	Kempact Pulse 3000 + KempactCool 10	FastMig M + X	FastMig M + X auxiliary unit PSL 55	MasterTig ACDC 3500W	X8 MIG Welder	MasterTig
P 20	6185261	25	●					
PM 500	6185291	23		●*				
PM 501	6185292	25			●			
P45MT	P45MT	30,5						●
T 22	6185256	25				●		
X8 Gas Cylinder Cart	X8701020000						●	
X8 Wheel Set (included in power source)	X8701010000						●	

* Bracket W002731 is required in MV models.

Transport units for wire feeders and compact power sources

P 501

P 43MT

	Order code	Weight kg	FastMig MXF65, MXF67, WFX 300, WFX 300 AMC	MasterTig
P 501	6185269	6.5	●	
P43MT	P43MT	13,5		●

Check mounting kit requirements for wire feed units

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Kemppi is the pioneering company within the welding industry. It is our role to develop solutions that make you win business. Headquartered in Lahti, Finland, Kemppi employs over 800 welding experts in 17 countries and has a revenue of more than 150 MEUR. Our offering includes welding solutions - intelligent equipment, welding management software and expert services - for both demanding industrial applications and ready-to-weld needs. Local expertise is available via our global partner network covering over 60 countries.

www.kemppi.com

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