KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Modbus

EtherNet/IP

PROFINET

EtherCAT

Others

DeviceNet

CANopen

PROFIBUS

Modbus

MX300 C

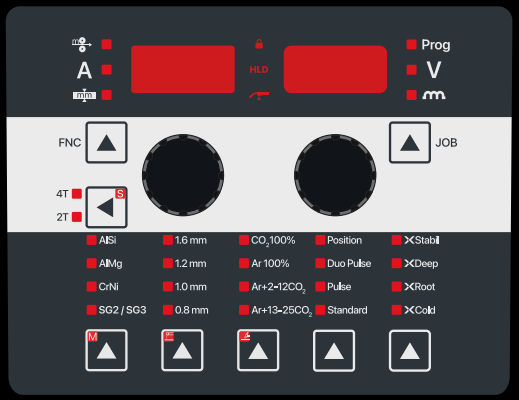


MX220 C



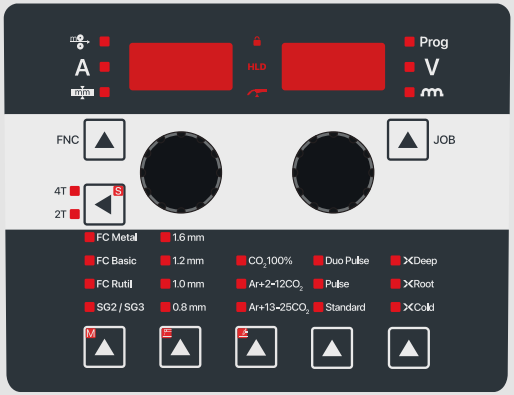
TECHNICAL SPECIFICATIONS

Input Voltage	400 V	400 V
Mains Voltage Tolerance	- 10 % / + 15 %	- 10 % / + 15 %
Minimum Welding Current	10 A	10 A
Maximum Welding Current	300 A	300 A
MIG Duty Cycle, 40°C	300 A %40, 230 A %60, 170 A %100	220 A %13, 90 A %100
TIG Duty Cycle, 40°C	300 A %40, 230 A %60, 170 A %100	220 A %13, 90 A %100
MMA Duty Cycle, 40°C	300 A %40, 230 A %60, 170 A %100	220 A %13, 90 A %100
Open – Circuit Voltage	68 V - 82 V	68 V - 82 V
Factory Delivered Roller	1.0 + 1.2 mm / Steel	1.0 + 1.2 mm / Steel
Weight	Air Cooled 21 kg	Air Cooled 21 kg
Standard Accessories	5m Power Cable (4x 1.5mm²)	5m Power Cable (4x 2.5mm²)
	5m Earth Clamp (35mm²)	5m Earth Clamp (35mm²)
Dimensions (W, L, H)	260mm x 650mm x 450mm	260mm x 650mm x 450mm
Certification	CE	CE



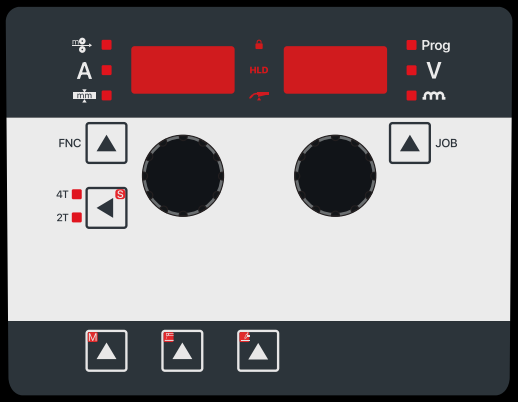
Pulse

For All Types of Metal Work (Steel, Cr, Cu & Al)



Synergic Pulse

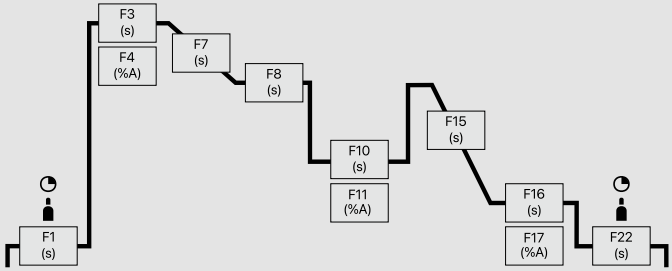
Flux-Cored Wire & Steel Solutions for Shipyards



Shipyard

Standard Panel for Shipyard Applications

Standard - Pulse			0.8	1.0	1.2	1.6
SG2 / SG3		Ar+18%CO_2	8	10	12	16
		Ar+10%CO_2	18	20	22	26
		CO_2 100%	28	30	32	36
CrNi	308 / 316 / 318 / 19 9 / 19 12 3	Ar+2.5%CO_2	68	70	72	76
CuSi		Ar100%	178	180	182	186
CuAl		Ar100%	188	190	192	196
AlMg4,5 Mn		Ar100%	118	120	122	126
AlSi		Ar100%	138	140	142	146
Flux Cored			0.8	1.0	1.2	1.6
Steel / FC Metal		Ar+18%CO_2	238	240	242	246
Steel / FC Rutil		Ar+18%CO_2	248	250	252	256
		CO_2 100%			262	266
Steel / FC Basic		Ar+18%CO_2			602	
CrNi / FC Metal		Ar+2.5%CO_2			272	276
CrNi / FC Rutil		Ar+18%CO_2			282	286
CrNi / FC Rutil		CO_2 100%			292	296
Steel / FC High Str.		Ar+18%CO_2			592	
Steel / FC Rutil		Self Shielded		720	722	
XDeep - Pulse			0.8	1.0	1.2	1.6
SG2 / SG3		Ar+18%CO_2	298	300	302	306
		Ar+10%CO_2	308	310	312	316
CrNi	308 / 316 / 318 / 19 9 / 19 12 3	Ar+2.5%CO_2		640	642	646
AlMg4,5 Mn		Ar100%			332	336
AlSi		Ar100%			342	346
XRoot - Pulse			0.8	1.0	1.2	1.6
SG2 / SG3		Ar+18%CO_2		360	362	
		CO_2 100%		370	372	
		Ar+10%CO_2		500	502	
XCold - Pulse			0.8	1.0	1.2	1.6
SG2 / SG3		Ar+18%CO_2	378	380	382	386
		CO_2 100%	388	390	392	
		Ar+10%CO_2		510	512	
CrNi	308 / 316 / 318 / 19 9 / 19 12 3	Ar+2.5%CO_2	398	400	402	
Application						
MIG/MAG Manual			4			
TIG (Lift Arc)			5			
MMA			6			
Gouging			7			



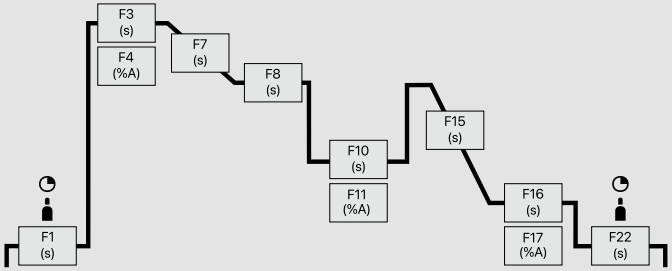
MIG/MAG	Function	Description	Min	Max
	F1	Gas pre-flow (s)	0	10
	F2	Start wire speed (m/min)	20	100
	F3	Start time (s)	0	10
	F4	Start current (%)	1	200
	F5	Start arc correction(V)	-9.9	+9.9
	F7	Start slope (s)	0	5
	F8	Duo peak time (s)	0.05	10
	F10	Duo base time (s)	0.05	10
	F11	Duo base amper (%)	1	100
	F12	Duo base arc correction (v)	-9.9	+9.9
	F15	End down slope (s)	0	10
	F16	End time (s)	0	10
	F17	End current (%)	1	200
	F18	End arc correction (V)	-9.9	+9.9
	F20	End burn back (-)	0	15
	F21	End wire cut mode (-)	0	2
	F22	Gas post-flow (s)	0	10
	F23	Smart trigger (-)	0	10
	F24	Penetration stabilizer (m/min)	0	10

MMA	Function	Description	Min	Max
	F25	Hot start time (s)	0	10
	F26	Hot start current (%)	1	200
	F27	Arc force (-)	0	+50
	F28	Antistick (s)	0	2
	F29	VRD function (-)	0	1

OTHERS	Function	Description	Min	Max
	F34	Tack/stich mode (-)	0	2
	F35	Cooling mode (-)	0	4
	F36	Motor current (A)	0	4
	F37	Motor current limit (A)	0.7	7
	F38	Auto load default values (-)	0	1
	F39	Motor control firmware (-)	-	-
	F40	Power control firmware (-)	-	-
	F41	Arc on time (h)	0	4
	F42	Machine on time (h)	0	4
	F45	Wire speed correction (m/min)	-2	+2
	F48	Status light template	0	4
	F49	Controller mode	0	9
	F50	RL cable calibration (mOhm)	0	30

TIG	Function	Description	Min	Max
	F31	TIG V stop limit (V)	18	18
	F32	TIG comfort stop sensitivity (V)	-2	+2

Standard - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO_2	8	10	12	16
	Ar+10%CO_2	18	20	22	26
	CO_2 100%	28	30	32	36
Flux Cored		0.8	1.0	1.2	1.6
Steel / FC Metal	Ar+18%CO_2	238	240	242	246
Steel / FC Rutil	Ar+18%CO_2	248	250	252	256
	CO_2 100%			262	266
Steel / FC Basic	Ar+18%CO_2			602	
Steel / FC High Str.	Ar+18%CO_2			592	
Steel / FC Rutil	Self Shielded		720	722	
XDeep - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO_2	298	300	302	306
	Ar+10%CO_2	308	310	312	316
XRoot - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO_2		360	362	
	CO_2 100%		370	372	
	Ar+10%CO_2		500	502	
XCold - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO_2	378	380	382	386
	CO_2 100%	388	390	392	
	Ar+10%CO_2		510	512	
Application					
MIG/MAG Manual		4			
TIG (Lift Arc)		5			
MMA		6			
Gouging		7			

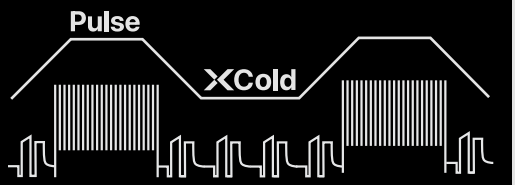


MIG/MAG	Function	Description	Min	Max
	F1	Gas pre-flow (s)	0	10
	F2	Start wire speed (m/min)	20	100
	F3	Start time (s)	0	10
	F4	Start current (%)	1	200
	F5	Start arc correction(V)	-9.9	+9.9
	F7	Start slope (s)	0	5
	F8	Duo peak time (s)	0.05	10
	F10	Duo base time (s)	0.05	10
	F11	Duo base amper (%)	1	100
	F12	Duo base arc correction (v)	-9.9	+9.9
	F15	End down slope (s)	0	10
	F16	End time (s)	0	10
	F17	End current (%)	1	200
	F18	End arc correction (V)	-9.9	+9.9
	F20	End burn back (-)	0	15
	F21	End wire cut mode (-)	0	2
	F22	Gas post-flow (s)	0	10
	F23	Smart trigger (-)	0	10

MMA	Function	Description	Min	Max
	F25	Hot start time (s)	0	10
	F26	Hot start current (%)	1	200
	F27	Arc force (-)	0	+50
	F28	Antistick (s)	0	2
	F29	VRD function (-)	0	1

OTHERS	Function	Description	Min	Max
	F34	Tack/stich mode (-)	0	2
	F35	Cooling mode (-)	0	4
	F36	Motor current (A)	0	4
	F37	Motor current limit (A)	0.7	7
	F38	Auto load default values (-)	0	1
	F39	Motor control firmware (-)	-	-
	F40	Power control firmware (-)	-	-
	F41	Arc on time (h)	0	4
	F42	Machine on time (h)	0	4
	F45	Wire speed correction (m/min)	-2	+2
	F48	Status light template	0	4
	F49	Controller mode	0	9
	F50	RL cable calibration (mOhm)	0	30

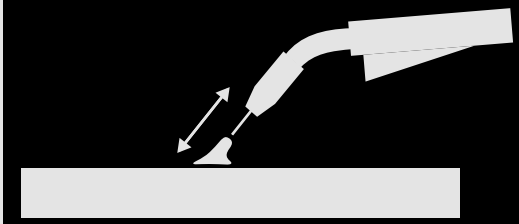
TIG	Function	Description	Min	Max
	F31	TIG V stop limit (V)	18	18
	F32	TIG comfort stop sensitivity (V)	-2	+2



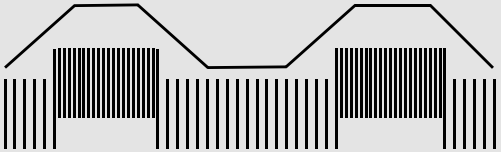
Position



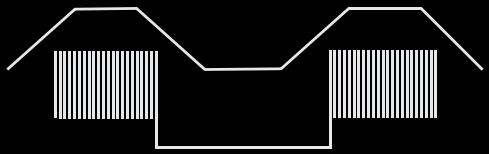
4x4 Rollers
Wire Drive



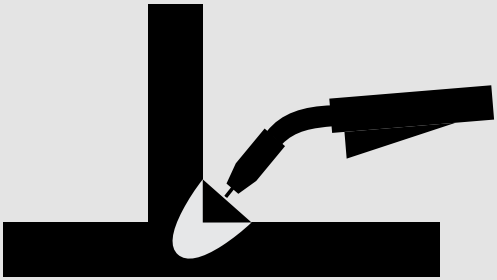
XStabil



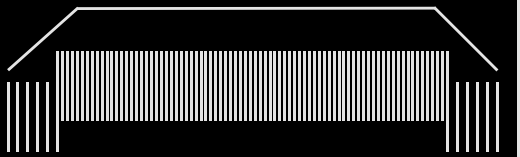
Duo Pulse



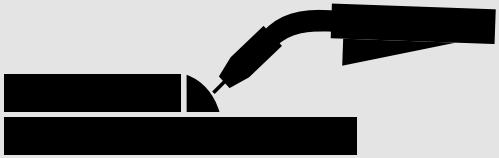
Twin



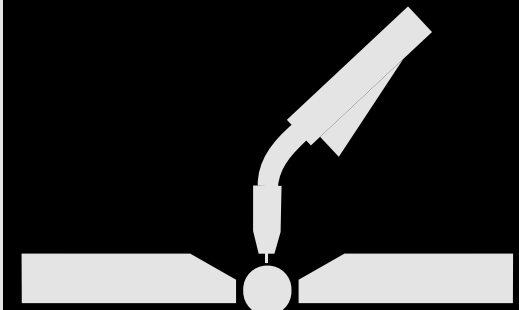
XDeep



Pulse



XCold



XRoot



25.000 PPS
Wire Speed Control
Perfect Feedibility

Wire Push
Pull-Back
Gas Testing



Spool Cover
With Wire
View

99

Program
Memory



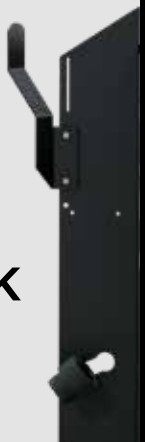
Intelligent
Cooling

RL

Torch and Cable
Calibration



Hose Pack
Support





Torch



Military
Connector

IP23 Design

Compact Wire Feeder

Industrial Wheels

Wire Feeder Wheels*

Ergonomic Robust Modular Design

Aluminum Gun Holder

Spatter Free Ignition

Wire Cut Function for Perfect Ignition

Wire Feeding Unit with LED Lighting

MMA Connection on Wire Feeder

Gas Saving System

Gas Filter

Coolant Liquid Filter

Extension Cable Holder

External Changable Couplings

Double Setscrew Plugs

Brass-Nut Sockets

*Optional

1 Efficiency

Cost Optimization 2

3 Maintenance

Quality 4

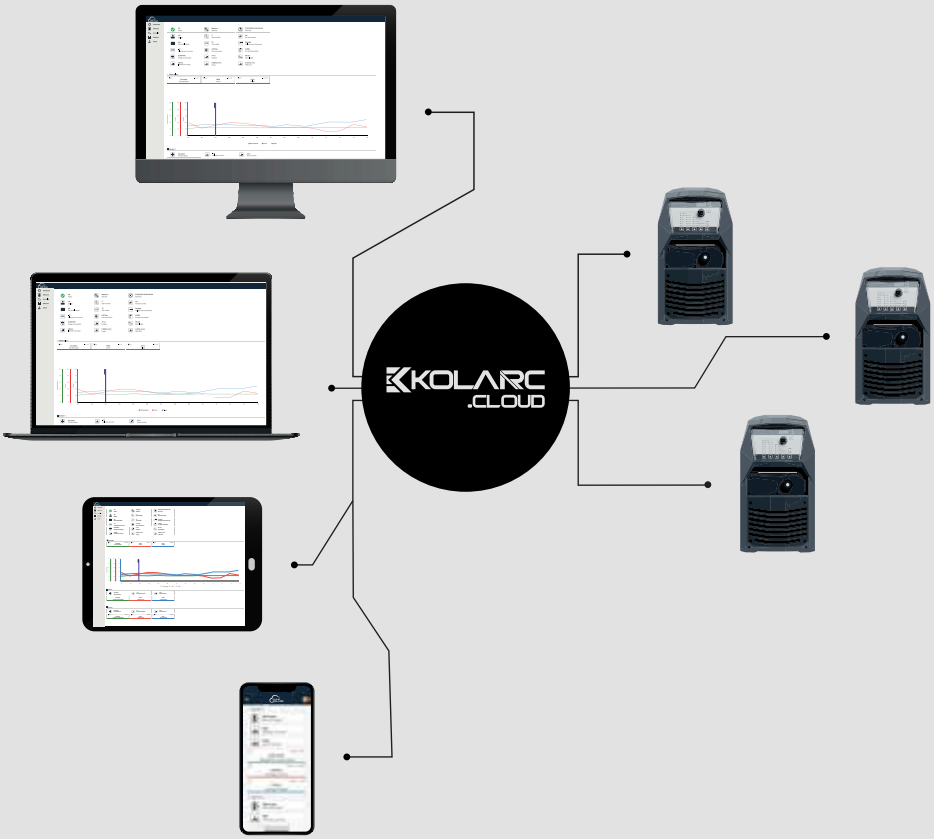
KOLARC .CLOUD

Wi Fi Bluetooth

LoRaWAN

Ethernet

USB Type-C



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