KOLARC

BUILDING THE FUTURE



## Robotic Interfaces

### Ethernet

Modbus

EtherNet/IP

PROFINET

EtherCAT

### Others

DeviceNet

CANopen

PROFIBUS

Modbus

# MX400 W

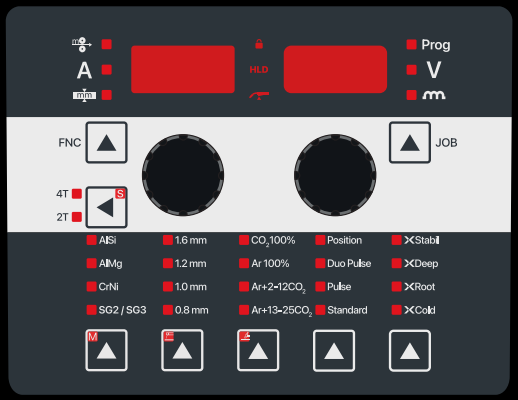


# MX400



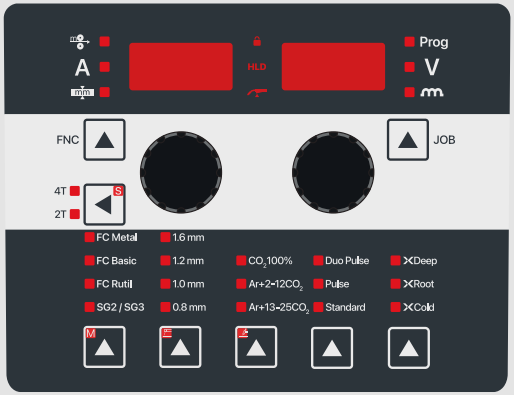
## TECHNICAL SPECIFICATIONS

| | MX400 W | MX400 |
|---|---|---|
| Input Voltage | 400 V | 400 V |
| Mains Voltage Tolerance | - 10 % / + 15 % | - 10 % / + 15 % |
| Minimum Welding Current | 10 A | 10 A |
| Maximum Welding Current | 400 A | 400 A |
| MIG Duty Cycle, 40°C | 400 A %40, 360 A %60, 300 A %100 | 400 A %40, 360 A %60, 300 A %100 |
| TIG Duty Cycle, 40°C | 400 A %40, 360 A %60, 300 A %100 | 400 A %40, 360 A %60, 300 A %100 |
| MMA Duty Cycle, 40°C | 400 A %40, 360 A %60, 300 A %100 | 400 A %40, 360 A %60, 300 A %100 |
| Open – Circuit Voltage | 63 V - 82 V | 63 V - 82 V |
| Factory Delivered Roller | 1.0 + 1.2 mm / Steel | 1.0 + 1.2 mm / Steel |
| Weight | Liquid Cooled , 94 kg | Air Cooled , 86 kg |
| Standard Accessories | 5m Power Cable ( 4 x 2.5mm² ) | 5m Power Cable ( 4 x 2.5mm² ) |
| | 5m Earth Clamp ( 50mm² ) | 5m Earth Clamp ( 50mm² ) |
| | Interconnection H.P ( 5m ) | Interconnection H.P ( 5m ) |
| Dimensions (W, L, H) | 532mm x 974mm x 1178mm | 532mm x 974mm x 940mm |
| Certification | CE | CE |



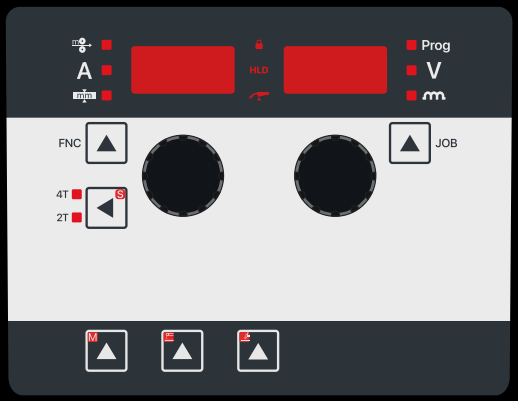

Pulse

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




Synergic Pulse

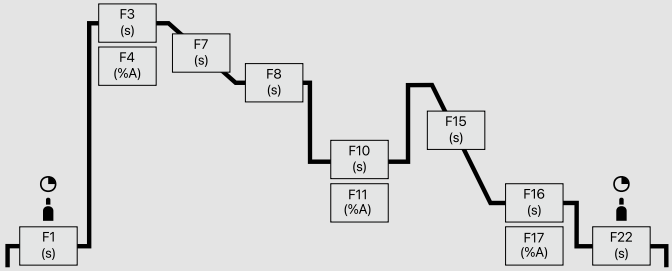
Flux-Cored Wire & Steel Solutions for Shipyards




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 | | | |



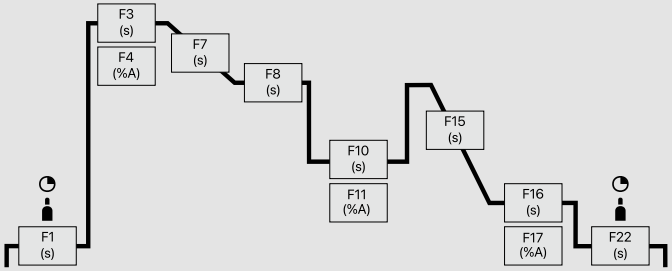

| MIG/MAG | Function | Description | Min | Max |
|---|---|---|---|---|
| | F1 | Gas pre-flow (s) | 0 | 10 |
| | F2 | Start wire speed (m/min) | 20 | 100 |
| | F3 | Start time (s) | 0 | 10 |
| | F4 | Start current (%) | 1 | 200 |
| | F5 | Start arc correction(V) | -9.9 | +9.9 |
| | F7 | Start slope (s) | 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 |
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| Application | | | | | |
| MIG/MAG Manual | | 4 | | | |
| TIG (Lift Arc) | | 5 | | | |
| MMA | | 6 | | | |
| Gouging | | 7 | | | |

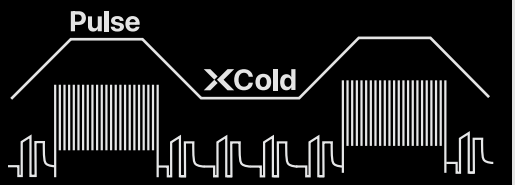



| MIG/MAG | Function | Description | Min | Max |
|---|---|---|---|---|
| | F1 | Gas pre-flow (s) | 0 | 10 |
| | F2 | Start wire speed (m/min) | 20 | 100 |
| | F3 | Start time (s) | 0 | 10 |
| | F4 | Start current (%) | 1 | 200 |
| | F5 | Start arc correction(V) | -9.9 | +9.9 |
| | F7 | Start slope (s) | 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 |

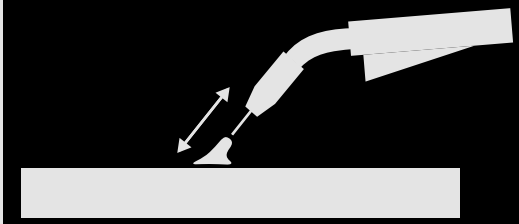
| TIG | Function | Description | Min | Max |
|---|---|---|---|---|
| | F31 | TIG V stop limit (V) | 18 | 18 |
| | F32 | TIG comfort stop sensitivity (V) | -2 | +2 |



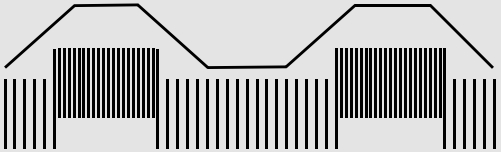

## Position



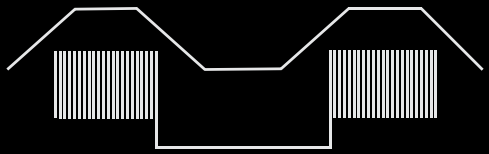
4x4 Rollers
Wire Drive



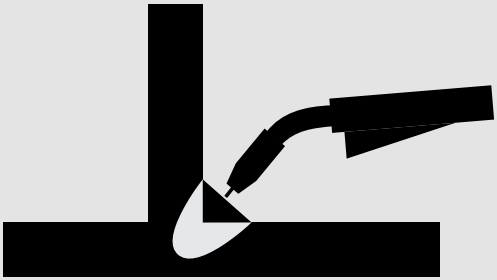
## XStabil



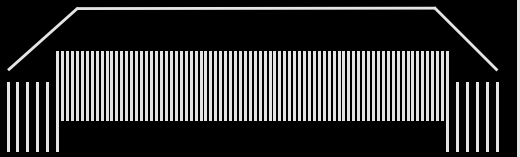
## Duo Pulse



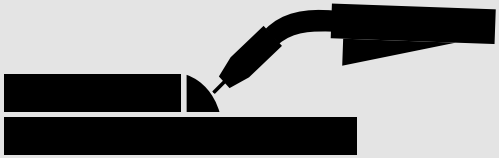
## Twin



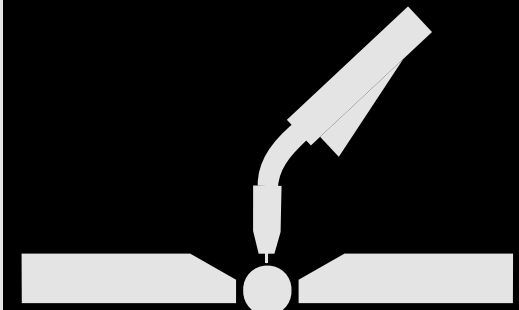
## XDeep



## 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



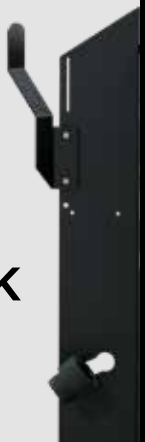

Intelligent
Cooling

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

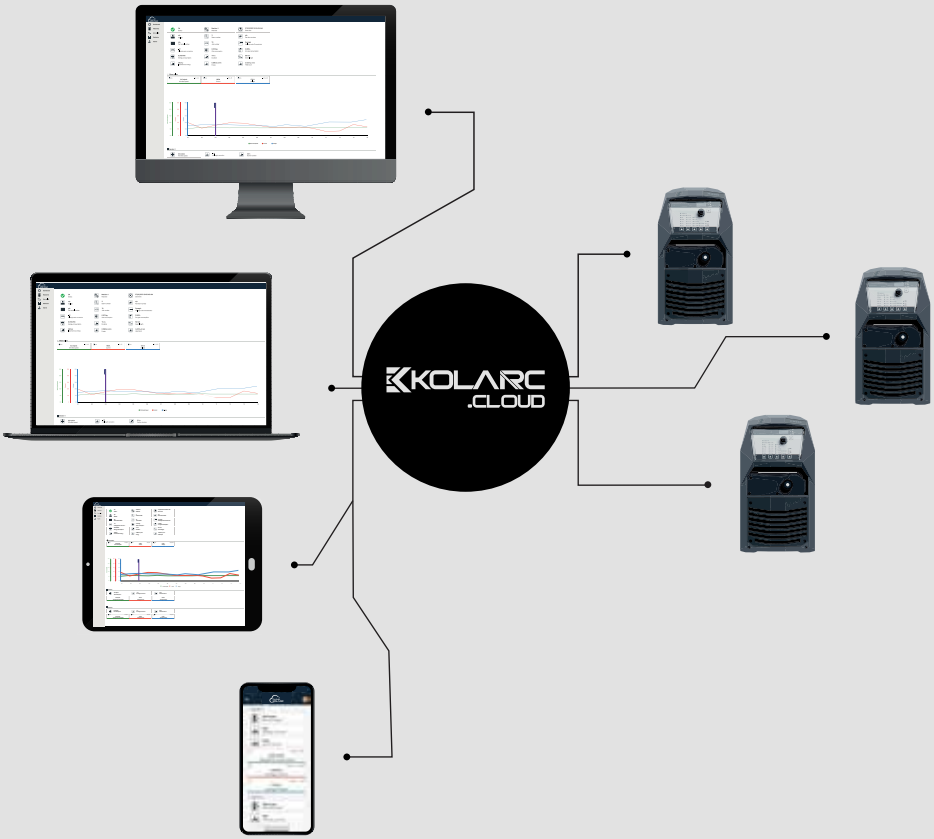
KOLARC .CLOUD

Wi Fi Bluetooth

LoRaWAN

Ethernet

USB Type-C




KOLARC

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