KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Modbus

EtherNet/IP

PROFINET

EtherCAT

Others

DeviceNet

CANopen

PROFIBUS

Modbus

XM300 C
Pulse



XM220 C
Pulse



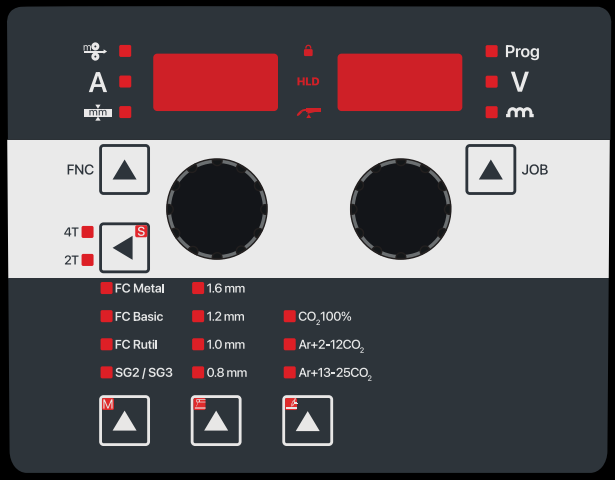
TECHNICAL SPECIFICATIONS

Input Voltage	400 V	230 V
Mains Voltage Tolerance	- 10 % / + 15 %	- 10 % / + 15 %
Minimum Welding Current	10 A	10 A
Maximum Welding Current	300 A	220 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	63 V - 82 V	63 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 (4 x 2.5 mm²)	5m Power Cable (4 x 2.5mm²)
	5m Earth Clamp (35 mm²)	5m Earth Clamp (35mm²)
	Gas Hose (1.5 m)	Gas Hose (1.5m)
Dimensions (W, L, H)	260mm x 650mm x 450mm	260mm x 650mm x 450 mm
Certification	CE	CE

Whether Manual Or Robotic. Experience 406* welding programs



Pulse

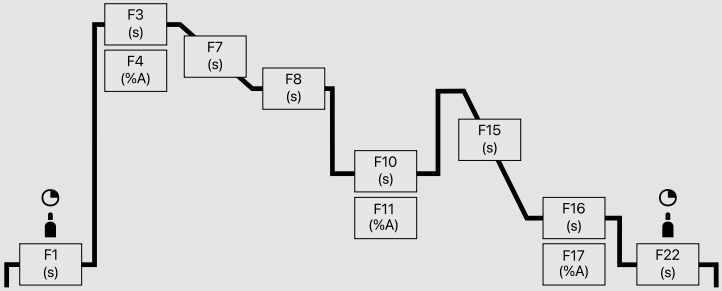


Synergic

Intuitive User Interface

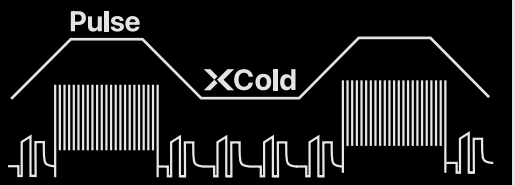
Standard - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO2	8	10	12	16
	Ar+10%CO2	18	20	22	26
	CO2 100%	28	30	32	36
CrNi 318 / 19 12 3	Ar+2.5%CO2	38	40	42	46
CrNi 316 / 19 12 3		68	70	72	76
CrNi 310 / 25 20			520	522	
CrNi 309 / 23 12		538	540	542	546
CrNi 308 / 19 9		58	60	62	66
CrNi 307 / 18 8		48	50	52	56
CrNi Duplex 22 9 3		78	80	82	86
	Ar+20%He+2%CO2	88	90	92	96
CuSi	Ar100%	178	180	182	186
	Ar+2.5%CO2	558	560	562	566
CuAl	Ar100%	188	190	192	196
CuSi Brazing	Ar100%	198	200	202	206
	Ar+2.5%CO2	208	210	212	216
CuAl Brazing	Ar100%	218	220	222	226
	Ar+2.5%CO2	228	230	232	236
AlMg4,5 Mn	Ar100%	118	120	122	126
	Ar+30%He	128	130	132	136
AlMg3	Ar100%		530	532	536
AlSi	Ar100%	138	140	142	146
	Ar+30%He	148	150	152	156
Al99	Ar100%	158	160	162	166
	Ar+30%He	168	170	172	176
Flux Cored		0.8	1.0	1.2	1.6
Steel / FC Metal	Ar+18%CO2	238	240	242	246
Steel / FC Rutil	Ar+18%CO2	248	250	252	256
	CO2 100%			262	266
Steel / FC Basic	Ar+18%CO2			602	
CrNi / FC Metal	Ar+2.5%CO2			272	276
CrNi / FC Rutil	Ar+18%CO2			282	286
CrNi / FC Rutil	CO2 100%			292	296
Steel / FC High Str.	Ar+18%CO2			592	
Steel / FC Rutil	Self Shielded		720	722	
Application					
MIG/MAG Manual		4			
TIG (Lift Arc)		5			
MMA		6			
Gouging		7			

XDeep - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO2	298	300	302	306
	Ar+10%CO2	308	310	312	316
CrNi 318 / 19 12 3	Ar+2.5%CO2		620	622	626
CrNi 316 / 19 12 3			640	642	646
CrNi 310 / 25 20			660	662	
CrNi 309 / 23 12			670	672	676
CrNi 308 / 19 9			320	322	326
CrNi 307 / 18 8				632	636
CrNi Duplex 22 9 3			650	652	656
AlMg4,5 Mn	Ar100%			332	336
AlSi	Ar100%			342	346
Al99	Ar100%			352	356
CrNi / FC Metal	Ar+18%CO2	608	610	612	616
XRoot - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO2		360	362	
	CO2 100%		370	372	
	Ar+10%CO2		500	502	
XCold - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO2	378	380	382	386
	CO2 100%	388	390	392	
	Ar+10%CO2		510	512	
CrNi 318 / 19 12 3	Ar+2.5%CO2	678	680	682	
CrNi 316 / 19 12 3		698	700	702	
CrNi 308 / 19 9		398	400	402	
CrNi 307 / 18 8		688	690	692	
CrNi Duplex 22 9 3		708	710	712	
AlMg4,5 Mn	Ar100%		410	412	
AlSi	Ar100%		420	422	
Al99	Ar100%		430	432	
CuSi Brazing	Ar100%	438	440	442	
CuAl Brazing	Ar100%	448	450	452	
AlSi Brazing	Ar100%		460	462	
ZnAl Brazing	Ar100%		470	472	
ZnAl (St to Al Welding)	Ar100%		490	492	
Mg / Mg	Ar+30%He			572	576
Cladding		0.8	1.0	1.2	1.6
NiCr-6625	Ar+30%He		100	102	106
	Ar+20%He+2%CO2		110	112	116
NiCr-6617	Ar+30%He			552	556
Co - Based	Ar100%			532	536



	Function	Description	Min	Max
MIG/MAG	F1	Gas pre-flow (s)	0	10
	F2	Start wire speed (m/min)	1.5	11
	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	1
	F24	Penetration stabilizer (m/min)	0	10

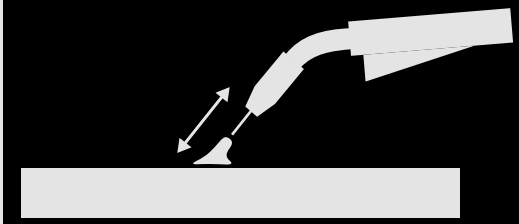
	Function	Description	Min	Max
MMA	F25	Hot start time (s)	0	10
	F26	Hot start current (%)	1	200
	F27	Arc force (-)	-50	+50
	F28	Antistick (s)	0	2
	F29	VRD function (-)	0	1
OTHERS	F34	Tack/stich mode (-)	0	2
	F35	Cooling mode (-)	0	4
	F36	Motor current (A)	0	-
	F37	Motor current limit (A)	0.7	7
	F38	Auto load default values (-)	0	1
	F39	Motor control firmware (-)	-	-
	F40	Power control firmware (-)	-	-
	F41	Arc on time (h)	0	-
	F42	Machine on time (h)	0	-
	F45	Wire speed correction (m/min)	-2	+2
	F48	Status light template	0	4
	F49	Working mode	0	9
	F50	RL cable calibration (mOhm)	0	30
TIG	F31	TIG V stop limit (V)	-	-
	F32	TIG comfort stop sensitivity (V)	-2	+2



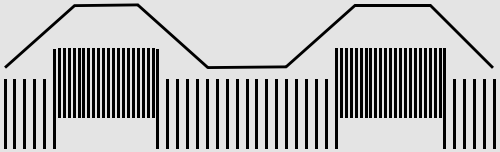
Position



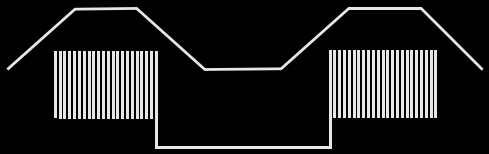
4x4 Rollers Wire Drive



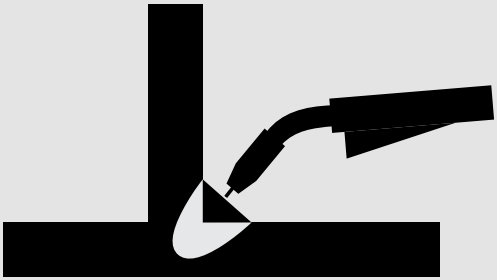
XStabil



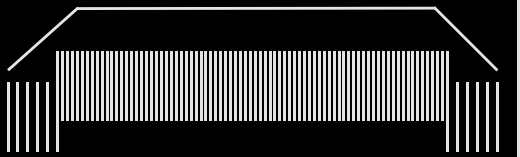
Duo Pulse



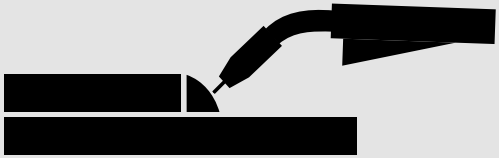
Twin



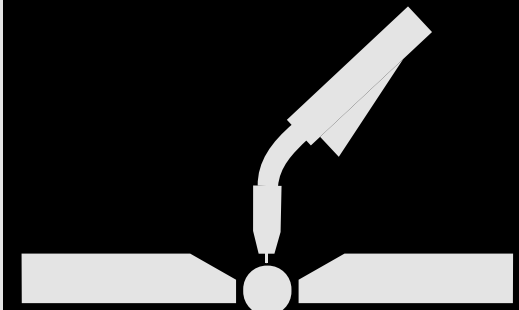
XDeep



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

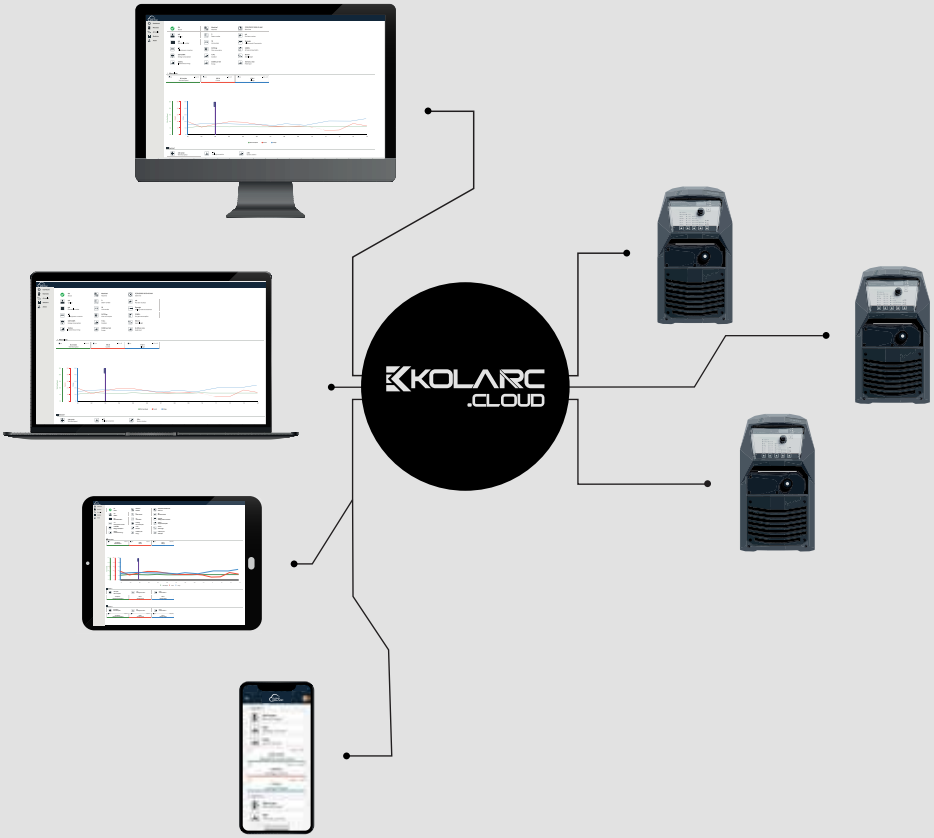
KOLARC .CLOUD

Wi Fi Bluetooth

LoRaWAN

Ethernet

USB Type-C



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