KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Modbus

EtherNet/IP

PROFINET

EtherCAT

Others

DeviceNet

CANopen

PROFIBUS

Modbus

XM350 CW
Pulse



XM350 C
Pulse



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	350 A	350 A
MIG Duty Cycle, 40°C	350 A %40, 300 A %60, 250 A %100	350 A %40, 300 A %60, 250 A %100
TIG Duty Cycle, 40°C	350 A %40, 300 A %60, 250 A %100	350 A %40, 300 A %60, 250 A %100
MMA Duty Cycle, 40°C	350 A %40, 300 A %60, 250 A %100	350 A %40, 300 A %60, 250 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	Liquid Cooled 55 kg	Air Cooled 42 kg
Standard Accessories	5m Power Cable (4x 2.5mm²) 5m Earth Clamp (50mm²) Interconnection H.P (5m)	5m Power Cable (4x2.5mm²) 5m Earth Clamp (50mm²) Interconnection H.P (5m)
Dimensions (W, L, H)	532mm x 860mm x 974mm	532mm x 624mm x 974mm
Certification	CE	CE

It's Manual Or Robotic.
Experience 406* welding programs

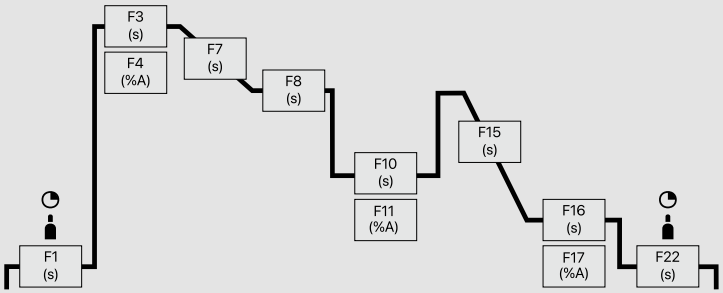


Pulse

Intuitive User Interface

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	318 / 19 12 3	$Ar+2.5\%CO_2$	38	40	42	46
	316 / 19 12 3		68	70	72	76
	310 / 25 20			520	522	
	309 / 23 12		538	540	542	546
	308 / 19 9		58	60	62	66
	307 / 18 8		48	50	52	56
	Duplex 22 9 3		78	80	82	86
		$Ar+20\%He+2\%CO_2$	88	90	92	96
CuSi		Ar100%	178	180	182	186
		$Ar+2.5\%CO_2$	558	560	562	566
CuAl		Ar100%	188	190	192	196
CuSi Brazing		Ar100%	198	200	202	206
		$Ar+2.5\%CO_2$	208	210	212	216
CuAl Brazing		Ar100%	218	220	222	226
		$Ar+2.5\%CO_2$	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		$Ar+18\%CO_2$	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	
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		$Ar+18\%CO_2$	298	300	302	306
		$Ar+10\%CO_2$	308	310	312	316
CrNi	318 / 19 12 3	$Ar+2.5\%CO_2$		620	622	626
	316 / 19 12 3			640	642	646
	310 / 25 20			660	662	
	309 / 23 12			670	672	676
	308 / 19 9			320	322	326
	307 / 18 8				632	636
	Duplex 22 9 3			650	652	656
AlMg4,5 Mn		Ar100%			332	336
AlSi		Ar100%			342	346
Al99		Ar100%			352	356
CrNi / FC Metal		$Ar+18\%CO_2$	608	610	612	616
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	318 / 19 12 3	$Ar+2.5\%CO_2$	678	680	682	
	316 / 19 12 3		698	700	702	
	308 / 19 9		398	400	402	
	307 / 18 8		688	690	692	
	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
		$Ar+20\%He+2\%CO_2$		110	112	116
NiCr-6617		Ar+30%He			552	556
Co - Based		Ar100%			532	536

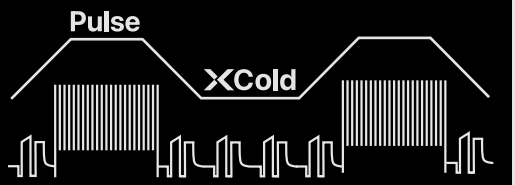


MIG/MAG	Function	Description	Min	Max
	F1	Gas pre-flow (s)	0	10
	F2	Start wire speed (m/min)	1.5	11
	F3	Start time (s)	0	10
	F4	Start current (%)	1	200
	F5	Start arc correction(V)	-9.9	+9.9
	F7	Start slope (s)	0	5
	F8	Duo peak time (s)	0.05	10
	F10	Duo base time (s)	0.05	10
	F11	Duo base amper (%)	1	100
	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

MMA	Function	Description	Min	Max
	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	Function	Description	Min	Max
	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

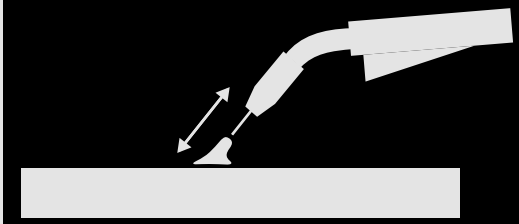
TIG	Function	Description	Min	Max
	F31	TIG V stop limit (V)	-	-
	F32	TIG comfort stop sensitivity (V)	-2	+2



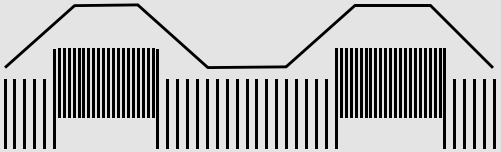
Position



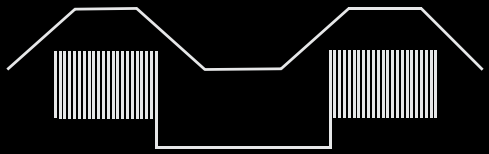
4x4 Rollers Wire Drive



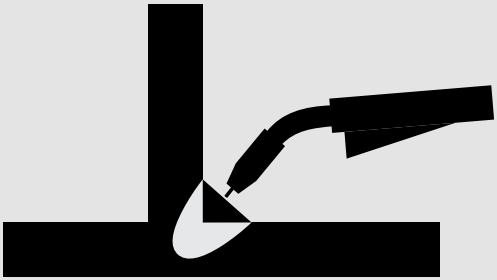
XStabil



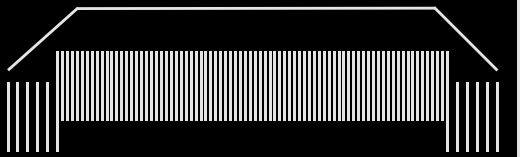
Duo Pulse



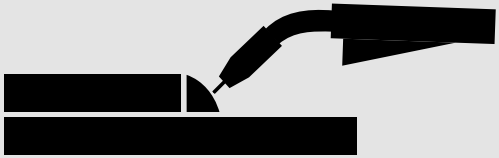
Twin



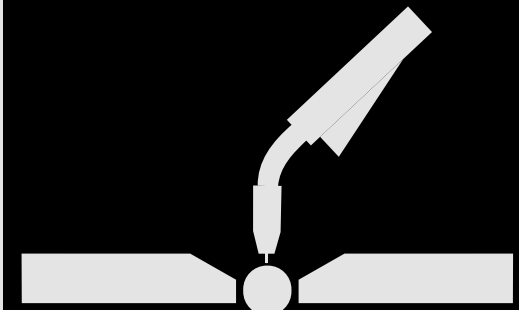
XDeep



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

2 Cost Optimization

3 Maintenance

4 Quality

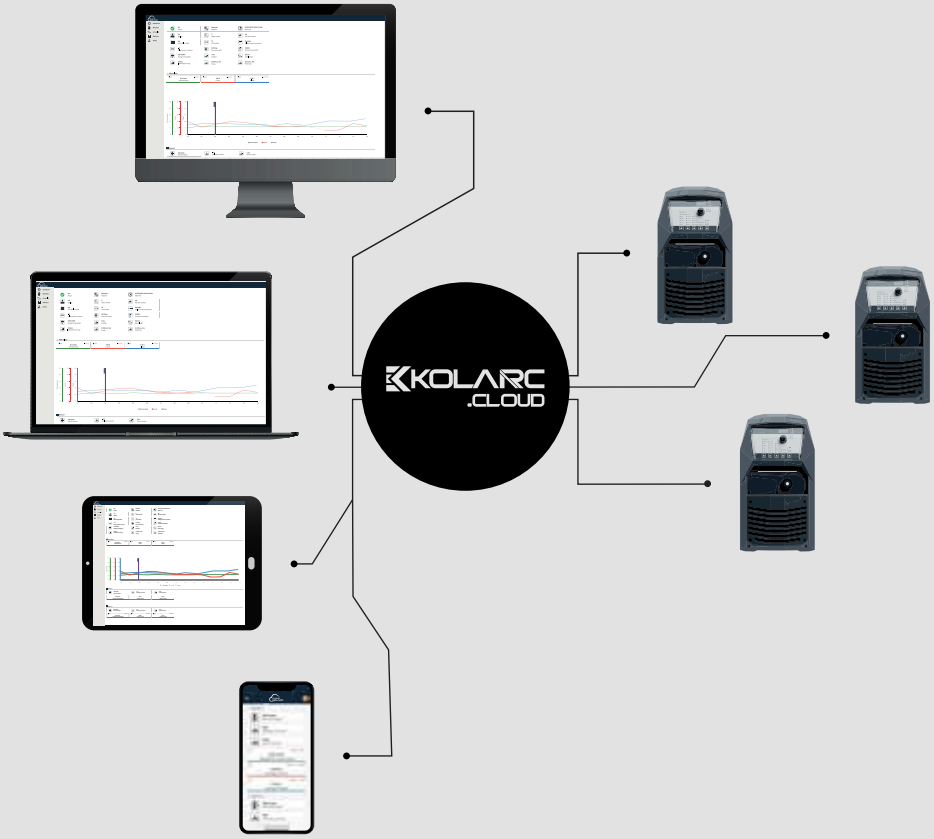
KOLARC .CLOUD

Wi Fi Bluetooth

LoRaWAN

Ethernet

USB Type-C



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