

# MIG / MAG PULSE WELDING MACHINES



Power  
Factor  
Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Generator  
Friendly

- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers



Multivoltage  
Einsatz  
weltweit

- ▶ Regulates the voltage from 110 V - 230 V



AC/DC  
Technology

- ▶ Welding with direct current or alternating current



DC  
PULSE

- ▶ TIG DC function = enables simple TIG welding

# MIG/MAG gas-shielded welding systems

## **craftmig**® 201P Pulse /253 Pulse

Impulse gas-shielded welding machines. Modern MIG welding machines for professional use

- ▶ Pulse function: Significantly less rework thanks to low-spatter welding
- ▶ Best welding results thanks to reliable ignition and stable arc
- ▶ Synergy function: Automatic calculation of the tension and wire feed by preselecting the wire Ø, material and gas
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ The quiet-running fans dissipate the heat well from the appliances and ensure a long switch-on time
- ▶ Arc force control: The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrodes can be processed without any problems
- ▶ Cored wires can be easily welded by simply reversing the polarity
- ▶ Suitable for operation on a power generator
- ▶ Wide range of functions: MIG/MAG (Pulse, Dual Pulse, Synergic, manual), TIG Lift Arc, E-Hand

### **CRAFT-MIG 201P Pulse**

- ▶ Device with PFC (power factor correction) equipped enables the best use even on cable reels

### **CRAFT-MIG 253 Pulse:**

- ▶ Optionally with water cooling



Generator Friendly



DC PULSE



Power Factor Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



MIG/MAG



ELECTRODES



TIG Lift - Arc



CRAFT-MIG 201P Pulse

CRAFT-MIG 253 Pulse



Including SMB torch and pressure reducer

## OPERATION

1 Digital display for welding voltage

2 Digital display for welding amperage

3 LED for mains connection and overload indicator

4 Selector buttons for gas, wire loading, job and store/load

5 Welding process selection

6 Torch assignment (2-stroke/4-stroke)

7 Special parameters

8 Rotary knob for voltage

9 Rotary knob for arc length correction, among other things



## TECHNICAL DATA:

Model		CRAFT-MIG 201P Pulse	CRAFT-MIG 253 Pulse
Art. no.		1072201	1072253
<b>Technical data</b>			
Setting range MIG/MAG	A	20 – 200	20 – 250
Setting range TIG DC	A	10 – 200	10 – 250
Setting range Electrode	A	10 – 200	10 – 250
Duty cycle at max. current 40°C	%	40	60
Current at duty cycle 100% 40°C	A	130	195
Wire feed speed	m/min	1.5 – 24	1.5 – 24
Wire feed unit	Roll	4	4
No-load voltage	V	Electrode: 94.4 TIG: 92.2 MIG/MAG: 84.5	Electrode: 79 TIG: 75 MIG/MAG: 71
Idling voltage explanation		Specifications for electrical connection 230 V	
Power factor	cos phi	0.99	Electrode: 0.68 TIG: 0.66 MIG/MAG: 0.67
Efficiency	%	82.22	Electrode: 89.02 TIG: 84.71 MIG/MAG: 87.71
Electrical connection ~50 Hz	V	110/230	400
Dimensions (L x W x H) approx.	mm	580 x 230 x 400	750 x 240 x 450
Weight approx.	kg	25	28.5
Standards <sup>1)</sup> :		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

<sup>1)</sup> EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

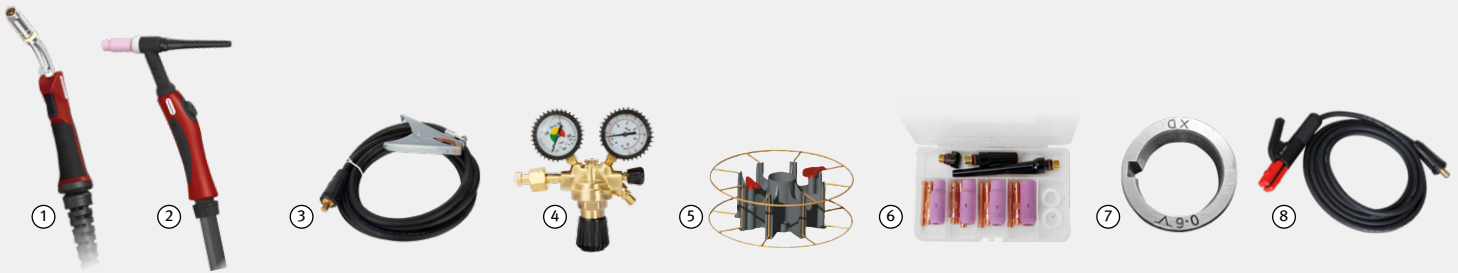
### CRAFT-MIG 201P PULSE SCOPE OF DELIVERY:

- Welding torch SMB 25/ 3 m
- Ground cable 25mm<sup>2</sup> / 3m
- Gas hose 12 x 6 mm, 4 m
- Argon/CO<sub>2</sub> pressure reducer
- Feed rollers Ø0.8 - 1.0 mm steel

### CRAFT-MIG 253 PULSE SCOPE OF DELIVERY:

- Welding torch SMB 25/ 4 m
- Ground cable 35mm<sup>2</sup> / 4m
- Gas hose 12 x 6 mm, 4 m
- Argon/CO<sub>2</sub> pressure reducer
- Feed rollers Ø0.8 - 1.0 mm steel

## ACCESSORIES



### ACCESSORIES

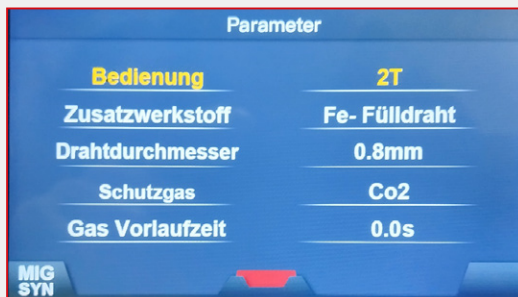
	Art. no.
① MIG/MAG welding torch, gas-cooled SMB25 4m	1090254
② SR26 TIG torch, 4 m ED, gas-cooled	1105004
③ Ground cable 4m 25mm <sup>2</sup> , KS50/13mm, clamp 200A	1250225
③ Ground cable 4m 35mm <sup>2</sup> , KS50/13mm, clamp 400A	1250235
④ Pressure reducer Argon/CO <sub>2</sub>	1700050
⑤ Basket coil adapter KA 2, with quick-release fastener	1110005
⑥ Wear parts kit VTS SR 17/18/26	1100152
⑦ ACCESSORIES for CRAFT-MIG 201P Pulse	
Sorting box, 3x torch cap, 5x gas nozzle, 4x adapter sleeve, 4x adapter sleeve housing, 1x Teflon seal	
Wire feed roller 0.6/0.8 mm V-groove	1171005
Wire feed roller 0.8/1.0 mm V-groove	1171006
Wire feed roller 0.8/1.0 mm K-groove	1171007
Wire feed roller 0.8/1.0 mm U-groove	1171008
⑧ SK4/25 KS13 EH260	1250361
ACCESSORIES for CRAFT-MIG 253 Pulse	
Wire feed roller 0.6/0.8 mm V-groove	1171030
Wire feed roller 0.8/1.0 mm V-groove	1171031
Wire feed roller 1.0/1.2 mm V-groove	1171032
Wire feed roller 0.8 / 1.0 mm for filler wire	1171033
Wire feed roller 1.0 / 1.2 mm for filler wire	1171034
Wire feed roller 0.8 / 1.0 mm for aluminium	1171035
Wire feed roller 1.0 / 1.2 mm for aluminium	1171036

# MIG/MAG gas-shielded welding systems

## Syn-Mig 353-4 W Pulse - Universally applicable MIG/MAG inverter welding machine with synergy characteristics and double pulse function

- ▶ Innovative impulse technology enables low-spatter weld seams - up to 80% less rework with a higher deposition rate at the same time
- ▶ Double-pulse function enables TIG-like weld seams at MAG speed
- ▶ High duty cycle of 60% at maximum power ensures longer welding times without overheating, ideal for large projects
- ▶ Synergy characteristics for steel, stainless steel and aluminium - 3 steps to the perfect result
- ▶ State-of-the-art inverter technology in modular design ensures maximum reliability combined with maximum efficiency
- ▶ Adjustable choke enables precise adjustment of the arc characteristics
- ▶ Suitable for use on the generator
- ▶ Integrated water cooling for optimum temperature control
- ▶ Sophisticated cooling system with encapsulated air duct for efficient heat dissipation ensures stable welding performance even in the toughest applications
- ▶ Can hold both 10 litre cylinders and up to 50 litre gas cylinders

## OPERATION



- User-friendly LCD display enables precise setting of welding parameters
- Simple setting with plain text display



- All welding parameters and settings at a glance

### TECHNICAL DATA:

Technical data		SYN-MIG 353-4 W Pulse
Article no.		1072353
Setting range for MIG/MAG	A	10 – 350
Setting range for TIG DC	A	10 – 350
Setting range for electrode	A	20 – 350
MIG soldering setting range	A	10 – 350
Duty cycle at max. current 40°C	%	60
Current at duty cycle 60% 40°C	A	350
Current at duty cycle 100% 40°C	A	270
MIG/MAG power consumption	kVA	12.4
Electrode power consumption	kVA	13.4
Power consumption TIG DC	kVA	9.8
Power factor	cos phi	0.726
Efficiency	%	89.02
Wire feeder, weldable wires, CuSi	mm	1.0
Wire feeder, weldable wires, filler wire	mm	0.9 – 1.6
Wire feeder, weldable wires, steel	mm	0.8 – 1.6
Wire feeder, weldable wires, stainless steel	mm	0.8 – 1.6
Wire feeder, weldable wires, aluminium	mm	1.0 – 1.6
Wire feed unit	Rollers	4
Wire feed speed	m/min	1.5 – 24
Required generator output	kVA	13
No-load voltage	V	MMA: 73 TIG: 73 MIG: 76
Power consumption	A	26.5
Connection voltage ~ 50 Hz	V	400
Dimensions (L x W x H) approx.	mm	1100 x 530 x 850
Weight approx.	kg	66.5

### SCOPE OF DELIVERY:

- MIG torch MB 401- 4 m
- 3 m ground cable 35 mm<sup>2</sup> with earth clamp 300 A
- Pressure reducer
- 4 m gas hose

### MACHINE IS DELIVERED WITHOUT COOLING WATER!

Equipment	
MIG/MAG process	Yes
MMA process	Yes
Operating display	LCD
Spot welding	Spot
Adjustable throttle	0 – 10 for syn, -10 – +10 for pulse
2-stroke/4-stroke change-over	2T/4T/4T+
Overload indicator	Yes

**MIG MAG**



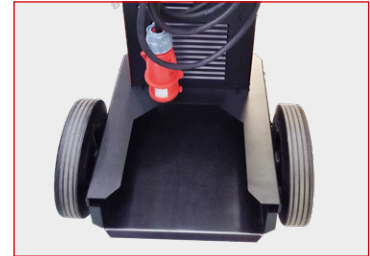
**HANDLE**

- Robust handle design for easy manoeuvring and for winding up the hose package



**COLOUR DISPLAY**

- Simple operation with large colour display.
- 3 steps to the result.
- The display is optimally protected by the cover.



**BOTTLE TROLLEY**

- low-lying



**FLAP**

- Large, wide-opening flap makes it easy to set up the machine
- The lighting also makes it easier to work in dark surroundings

**VIEWING WINDOW**

- in the cover of the wire feeder



Syn-Mig 353-4 W Pulse

