MIG-400DUAL

Quick Specs

Heavy Industrial Application:
- Metal fabrication workshops
- Shipyards and offshore industry
- Chemical and process industry
- Steel structure workshops

Process:
- MAG(GMAW)
- MIG (GMAW)
- Stick (SMAW)

Input Power:220~380V, 3-Phase
Amperage Range: 30-400A
Rated Output at 40°C (104°F): 400A at 34V @60% Duty Cycle
Weight: 50KG

For MIG and Stick Welding

Heavy duty powers at any volts from 220-440V.

MIG-400DUAL is built with a double control circuits in order to confirm the full welding powers at any voltage with rated duty cycle. Designed based on the universal stability power source, built with a soft-switching system, the machine can be fit with variable line-in volts automatically and reliably. It's the new idea and new technology to built a welding power source.

Specialist Features

Precision Arc Performance:

- **Built with a Double-controlled circuits** make the machine fit with variable line-in volts automatically and confirm the full output at any voltage with rated duty cycle.
- **The short-circuiting metal transfer mode** is the low heat input mode of metal transfer for GMAW so that it reduces weldment distortion.
- **Superior MAG Process** – Welds with mixed or CO2 shielding gas for superior quality welding.
- **Arc Force** makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.
- **Professional 4-rolls wire-feeder** provides a stable wire speed.
- Root pass welding process provides a good root formation and reduces the time for cleaning the weld spatter.
- **Intermediate cables up to 100M(75mm2) from the wire feeder unit.**
- **Fast, precise, clean arc ignition and arc ending.**

Outstanding Quality:

- Newly designed using the latest power electronic technology for improved reliability.
- CE Certified.

Technical specifications

Item No		MIG-400DUAL
Rated Input Voltage		3PH ~ 220~380V +15%
Max. Load Power Capacity		380V: 15.5KVA 220V:13.3KVA
Rated Duty Cycle(40oC)	60%	MIG: 380V:400A/30V
		220V:350A/28V
		MMA: 380V:350A/34V
		220V:300A/32V
	100%	MIG: 380V:350A/28V
		220V:300A/26V
		MMA:380V:300A/32V
		220V:250A/30V
Welding Current/Voltage Range		MIG: 380V: 30A/15.2V~400A/30V
		220V:30A/15.2V~350A/28V
		MMA:380V: 30A/21.2V~350A/34V
		220V:30A/21.2V~300A/32V
Open Circuit Voltage		70V
Power Factor		380V:0.92 220V:0.73
Efficiency		380V:88% 220V:80%
Pre-Gas Time		0-15S
Flow-Gas Time		0-15S
Wire-feed Mechanism		4 Rollers
Wire-feed Speed Range		1.5-15 m/ min
Wire Spool Capacity		300mm (15kg)
Filler Wires Ø (mm) Fe, Ss:		0.6~1.6 mm
	Flux Cored:	0.8~1.6 mm
	Al:	1.0~1.6 mm
Dimension		800x440X600mm
Weight		50KG

Panel

Panel Parameter Values

1.wire-feeder

Current/Wire Speed regulator for MIG welding.
Voltage regulator for MIG welding.

2.Control Panel

3.MIG torch connector (euro type).

4.Positive "+" output connector.

5.7-pin multi-purpose control plug.

6.Negative "-" output connector.

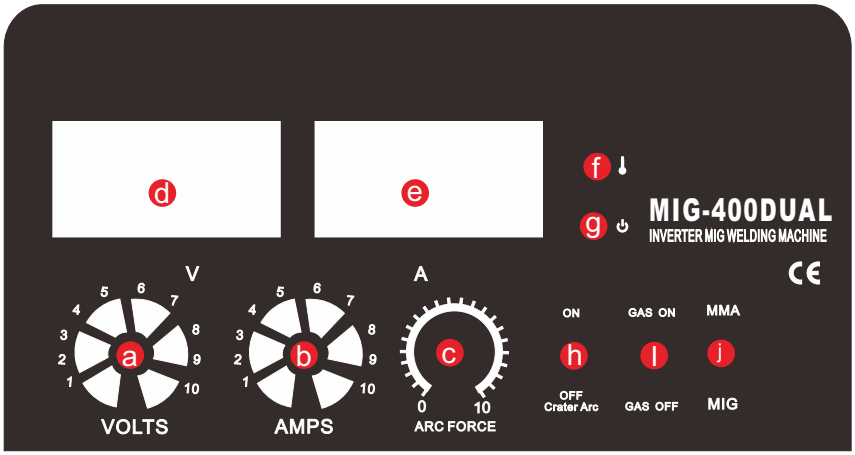
7.Fan.

8.Inlet power cable.

9.36V CO^2 heating power output socket

10.3 phase power cable Socket

General View of Control Panel



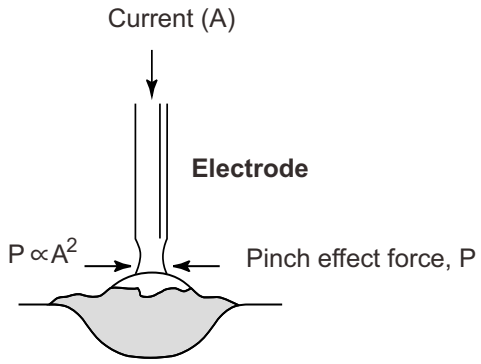
Control Panel Parameter Values

(a) Welding Voltage regulator.
(b) Welding Current regulator.
(c) Arc Force regulator.
(d) Power/working pilot lamp.
(e) Over-load/Over-heat Protection or Damage pilot lamp.
(f) Volmeter
(g) Ampmeter.
(h) Crater ON/OFF mode selection (2T/4T).
(I) Gas-test ON/OFF selection.
(j) MMA/MIG welding mode selection.

The short-circuiting metal transfer mode

The short-circuiting metal transfer mode is the low heat input mode of metal transfer for GMAW and has higher electrode efficiencies, 93% or more. The low heat input reduces weldment distortion and makes it ideal for sheet metal thickness materials.

Short-Circuit Metal Transfer



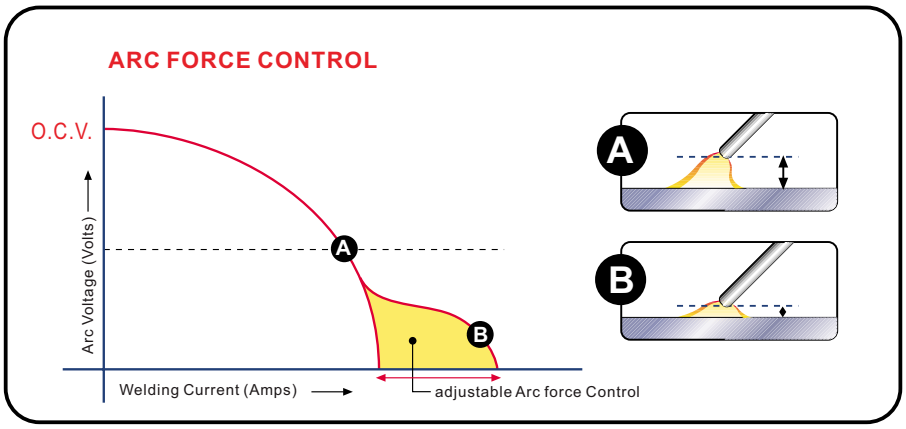
Four-Roll Drive System

4-Rolls wire-feeder with strong feeding motor.

The MIG-400DUAL gives precise, clean welding performance, and also support optional root pass welding process.Our new control technology ensures excellent arc ignition and welding performance, obviously reduce the time for cleaning the weld spatter.

Arcforce correction (welding characteristics)

During the welding process, arcforce prevents the electrode sticking in the weld pool with increases in current. This makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.



Root pass welding process

The **MIG-400DUAL** gives precise, clean welding performance, and also support optional root pass welding process. Our new control technology ensures excellent arc ignition and welding performance, obviously reduce the time for cleaning the weld spatter.

Accessories

For Standard accessories

MIG torch: MIG-501D
PTEE liner

Earth clamp with cable 3M

For Optional accessories

Argon/CO2 gas regular with heater
Output meter :1-30LPM
Inlet pressure gauge:280kg/4000psi
Out thread :M12-1.ORH(M)

Professional torch:
Tbi 9W/ALU water cooled

Trolley:WT-150

Consumables

For MIG torch: MIG-501D

Nozzles

ICS0713 Gas nozzle Φ16mm
ICS0740 Gas nozzle Φ14mm
ICS0746 Gas nozzle Φ19mm
ICS0747 Adjusted tapered nozzle Φ15mm
ICS0748 Spot welding gas nozzle Φ20mm

Contact Tips

ICU0005-08 Contact tip Φ0.8mm M8x30 Ecu
ICU0005-10 Contact tip Φ1.0mm M8x30 Ecu
ICU0005-12 Contact tip Φ1.2mm M8x30 Ecu
ICU0005-16 Contact tip Φ1. 6mm M8x30 Ecu
ICU0005-20 Contact tip Φ2.0mm M8x30 Ecu
ICU0005-24 Contact tip Φ2.4mm M8x30 Ecu
ICU0005-58 Contact tip Φ0.8mm M8x30 CuAl
ICU0005-59 Contact tip Φ0.9mm M8x30 CuAl
ICU0005-60 Contact tip Φ1.0mm M8x30 CuAl
ICU0005-62 Contact tip Φ1.2mm M8x30 CuAl
ICU0005-66 Contact tip Φ1. 6mm M8x30 CuAl
ICU0005-70 Contact tip Φ2.0mm M8x30 CuAl
ICU0005-74 Contact tip Φ2.4mm M8x30 CuAl
ICU0005-78 Contact tip Φ0.8mm M8x30 CuCrZr
ICU0005-80 Contact tip Φ1. 0mm M8x30 CuCrZr
ICU0005-82 Contact tip Φ1. 2mm M8x30 CuCrZr

Replacement Lines

IIC0226 Brass terminal Φ3.0X4.5mm 0.35m
IIC0210 Teflon liner Φ3.0X4.5mm 3m Yellow
IIC0580 Steel liner Φ1.2-1.6mm 3m

Others

10-pin connector

Drive Roll
Fe 0.6/0.8 mm
Fe 0.8/0.9 mm
Fe 0.8/1.0 mm
Fe 1.0/1.2 mm
Fe 1.2/1.6 mm
Al 0.6/0.8 mm
Al 0.8/0.9 mm
Al 0.8/1.0 mm
Al 1.0/1.2 mm
Al 1.2/1.6 mm