

MT-250i/300i



Quick Specs



Processes:
MIG,
Flux-Cored,
MMA(Stick),
TIG

Applications:
Metal Fabrication
Maintenance and Repair
Auto Body
Light Industrial

Input Power:

250i: 230V,1-Phase
300i: 400V,3-Phase

Amperage Range:

250i: 30-250A/300i: 30-300A

Rated Output at 40°C (104°F):

250i: 250A at 26.5V @60% Duty Cycle
300i: 300A at 29V @60% Duty Cycle

Weight : 32KG

For TIG,MIG and Stick Welding

Light in weight but heavy duty in welding powers, and excellent welding performance

MT-250i/300i is more than 50% lighter in weight than traditional step regulated machines. Electronic control of voltage and wire speed allows arc tuning during the weld process, so you can quickly establish the desired weld settings. Includes gun trigger latching and wire inch function. Available with 10 pins multipurpose connectors, used for Push-pull torch or spool guns, basically suitable for Fe, FeMc, FeFc, St/St, Alu, CuSi3, CuAl8 filler wires.

Specialist Features

Precision Arc Performance:

- **Multi-process includes MIG, Lift TIG and MMA**
- **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.
- **Spot/Stitch** mode is easy to operate and provides a quick and effective means for spot welding mild, galvanized or stainless materials.
- **Lift TIG** Mode uses contact ignition and has a good result in tig welding.
- **4T Trigger Hold** allows to hold the present current by user until press the trigger again.
- **Professional 4-rolls wire-feeder** provides a stable wire speed.
- **10 Pins multipurpose AMP connectors** extend the usage range and it's easy to work with a push-pull torch or spool gun.
- **Fast, precise, clean arc ignition and arc ending.**

Outstanding Quality:

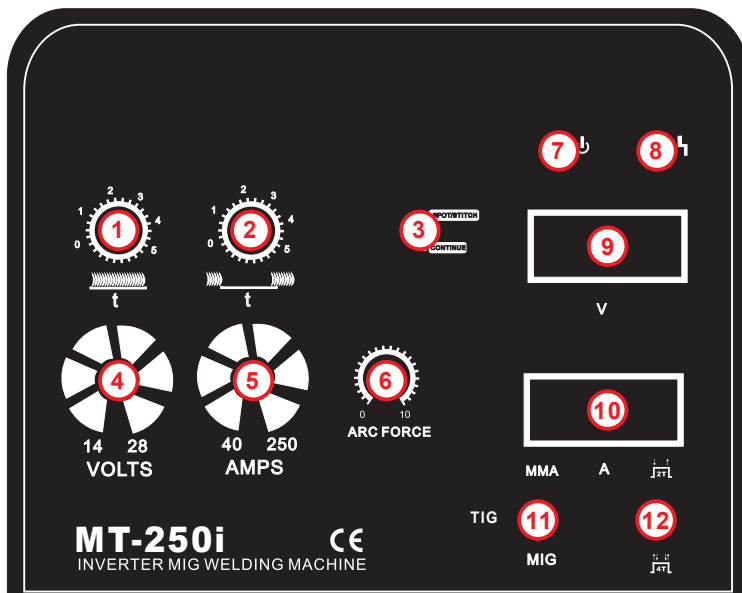
- Newly designed using the latest power electronic technology for improved reliability.
- CE Certified.
- One-Year Warranty on parts.



Technical specifications

Item No	MT-250i	MT-300i
Rated Input Voltage	1PH ~ 230V ±15%	3PH ~ 400V ±15%
Max. Load Power Capacity	10.35KVA	12.04KVA
Rated Duty Cycle(40oC) 60%	TIG: 250A/20V MIG: 250A/26.5V	TIG: 300A/22V MIG: Separated Wire-feeder: 300A/29V Internal Wire-feeder: 250A/26.5V
100%	MMA: 250A/28V TIG:200A/18V MIG: 200A/24V MMA: 200A/28V	MMA: 250A/28V TIG:250A/20V MIG: 200A/24V MMA:200A/28V
Welding Current/Voltage Range	TIG:30A/11.2V~250A/20V MIG: 30A/15.5V~250A/26.5V MMA:30A/21.2V~250A/28V	TIG:30A/11.2V~300A/22V MIG: 30A/15.5V~300A/29V MMA:30A/21.2V~250A/28V
Open Circuit Voltage	55V	55V
Power Factor	0.8	0.85
Efficiency	80%	85%
Pre-Gas Time	Preset	Preset
Flow-Gas Time	Preset	Preset
Wire-feed Mechanism	4 Rollers	4 Rollers
Wire-feed Speed Range	0~25m/ min	0~25m/ min
Wire Spool Capacity	300mm (15kg)	300mm (15kg)
Filler Wires Ø (mm) Fe, Ss:	0.6~1.2 mm	0.6~1.2 mm
Dimension (LxWxH)	770x250x650mm	770x250x650mm
Weight (KG)	32KG	32KG

General View of Control Panel

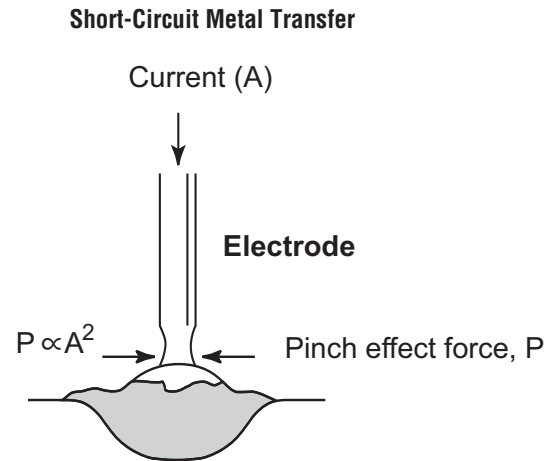


Control Panel Parameter Values

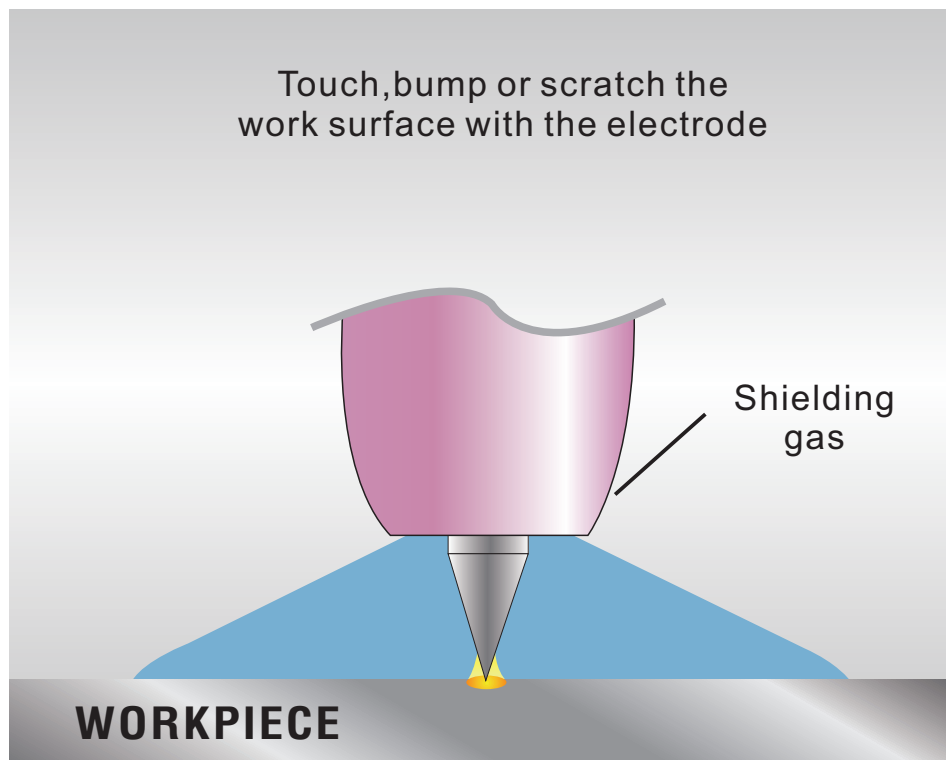
1. Spot/Stick welding TIME 1: on welding time adjustment knob.
2. Spot/Stick welding TIME 2: off welding time adjustment knob.
3. Spot/stick welding mode selection knob.
4. Welding Voltage regulator.
5. Welding Current regulator.
6. Arc Force regulator.
7. Power/working pilot lamp.
8. Arc Force regulator.
9. Over-load/Over-heat Protection or Damage pilot lamp.
10. Voltmeter.
11. MMA/MIG/TIG welding mode selection.
12. 2T/4T 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.



Lift TIG Mode



Lift TIG Mode provides TIG arc initiation without the use of high frequency. Touch, bump or scratch the work surface with the electrode to start the arc. It also has a good result in tig welding.

ADVANCED MIG/MAG:



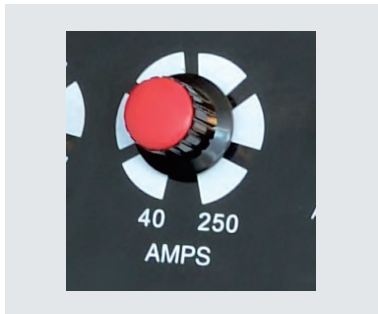
In the advanced MIG mode, MIG/MAG welding is carried out in inert gas with automatic wire feed. With this mode, a high welding speed and excellent quality are offered without any extra costs in the processing of ferrous metals, as well as various steels(see Advanced MIG/MAG. pdf).

Spot/Stitch mode



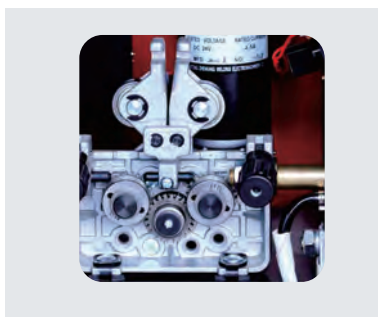
Use the spot and cycle arc timer you can easily control the welding time and the stitch length during the continue spot welding jobs. Spot/Stitch mode provides a quick and effective means for spot welding mild, galvanized or stainless materials. Very useful for the car body repairs.

Multipurpose AMP connectors



The 10 Pins multipurpose AMP connectors extend the usage range and it's easy to work with a push-pull torch or spool gun and suitable a variety of filler wires.

Four-Roll Drive System



4-Rolls wire-feeder with strong feeding motor.

Four-roll drive systems deliver the electrode to the welding torch. It provides a stable wire speed and is popular for industrial applications.



Accessories

For Standard accessories



MIG torch: MIG 24KD
Euro Connector
Cable length 3M



TIG torch: WP-26
Gas connector: M16
Cable length 4M
5-pin control coupler



Electrode holder with cable 2M
Earth clamp with cable 2M

For Optional accessories



CO₂ gas regular with heater



Spool gun: QLBF-200/8M



Argon gas regular

Consumables

For MIG torch: MIG 24KD



Nozzles

- ICS0800 Gas nozzle Φ 17mm
- ICS0806 Gas nozzle Φ 12.5mm
- ICS0807 Gas nozzle Φ 10mm
- ICS0808 Spot welding gas nozzle



Contact Tips

- ICU0003-06 Contact tip Φ 0.6mm M6x25 Ecu
- ICU0003-08 Contact tip Φ 0.8mm M6x25 Ecu
- ICU0003-09 Contact tip Φ 0.9mm M6x25 Ecu
- ICU0003-10 Contact tip Φ 1.0mm M6x25 Ecu

- ICU0003-58 Contact tip Φ 0.8mm M6x25 CuAl
- ICU0003-59 Contact tip Φ 0.9mm M6x25 CuAl
- ICU0003-60 Contact tip Φ 1.0mm M6x25 CuAl
- ICU0003-62 Contact tip Φ 1.2mm M6x25 CuAl
- ICU0003-76 Contact tip Φ 0.6mm M6x25 CuCrZr
- ICU0003-78 Contact tip Φ 0.8mm M6x25 CuCrZr
- ICU0003-80 Contact tip Φ 1.0mm M6x25 CuCrZr
- ICU0003-82 Contact tip Φ 1.2mm M6x25 CuCrZr

Replacement Lines

- IIC0220 Brass terminal Φ 2.0X4.0mm 0.35m
- IIC0160 Teflon liner Φ 2.0X3.0mm 3m Red
- IIC0560 Red liner Φ 1.0-1.2mm 3m

Others



5-pin connector



Drive Roll

- Fe 0.8/0.9 mm
- Fe 0.8/1.0 mm
- Fe 1.0/1.2 mm
- Al 0.8/0.9 mm
- Al 0.8/1.0 mm
- Al 1.0/1.2 mm