

ALUMIG-250P/300P



**Quick
Specs**



Processes:

MIG,
Flux-Cored,
Pulse MIG,
Double Pulse MIG,
MMA(Stick)

Applications:

Metal Fabrication
Maintenance and Repair
Auto Body
Light Industrial

Input Power:

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

Amperage Range:

250P: 10-250A/300P: 10-300A

Rated Output at 40°C (104°F):

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

Weight: 32KG

For MIG and Stick Welding

Strong power, Multi-functions, Superb performance and Economical choice

ALUMIG-250P/300P is a synergic, pulsed and double-pulsed MIG /MAG welding machine, suitable for a variety of materials including Fe, FeMc, FeFc, St/St, Al, CuSi3, CuAl8 fillers wires.

ALUMIG-250P/300P is specially designed for aluminum welding jobs with thickness from 1.5mm to 5mm.

Simply select the filler wire type and size, then go welding. For those regular welding jobs there's even a 10-channel memory function.

Specialist Features

Precision Arc Performance:

- **Multi-Process capable** - Welds MIG, flux-cored, stick, pulsed MIG, and advanced process of Pulse-On-Pulse.
- **Synergic control** – Set weld procedures with one control, simple and easy to operate.
- **Synergic MIG** provides communication between power source, feeder and gun.
As wire speed increases or decreases, the arc voltage also increases or decreases to maintain a constant welding arc.
- **Special Trigger Hold (S4T)** allows to hold the pre-set Initial Current by user until get a successful Arc Start on Aluminum plate.
- **Aluminum Pulse Process** – Welds 4XXX (AlSi wires) and 5XXX (AlMg wires) series aluminum for superior quality welding.
- **Pulse-on-Pulse** - Delivers a stacked dime appearance when welding aluminum.
- **Featured Wave-form control system:** Maintains a stable, smooth arc for short arc welding on steel. Improved penetration on thicker aluminum sections.
- **Fast, precise, clean arc ignition and arc ending.**
- **10 channels memory capacity.**



Outstanding Quality:

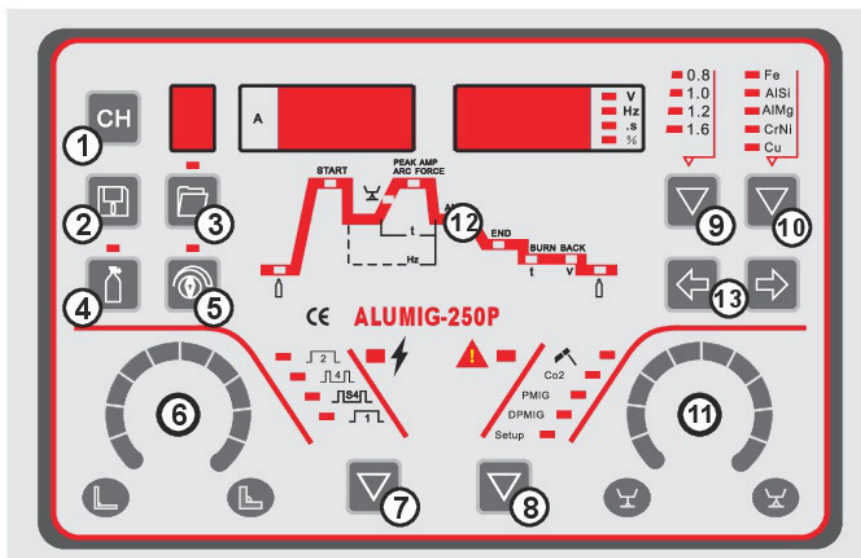
- Newly designed using the latest power electronic technology for improved reliability.
- CE Certified.
- One-Year Warranty on parts.



Technical specifications

Item No	ALUMIG-250P	ALUMIG-300P
Rated Input Voltage	1PH ~ 230V ±15%	3PH ~ 400V ±15%
Max. Load Power Capacity	10.35KVA	12.04KVA
Rated Duty Cycle(40°C) 60%	MIG: 250A/26.5V	MIG: Separated Wire-feeder: 300A/29V Internal Wire-feeder: 250A/26.5V
	MMA: 250A/28V	MMA: 250A/28V
100%	MIG: 200A/24V	MIG: 200A/24V
	MMA: 200A/28V	MMA: 200A/28V
Welding Current/Voltage Range	MIG: 10A/14.5V ~250A/26.5V MMA:10A/20.4V ~250A/28V	MIG: 10A/14.5V ~300A/29V MMA:10A/20.4V ~250A/28V
Open Circuit Voltage	55V	55V
Power Factor	0.8	0.85
Efficiency	80%	85%
Pre-Gas Time	0.1-15S	0.1-15S
Flow-Gas Time	0.1-15S	0.1-15S
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	0.6~1.2mm
FLUX CORED:	0.9~1.2 mm	0.9~1.2 mm
Al:	0.8~1.2 mm	1.0~1.2 mm
Dimension	770X250X650mm	770X250X650mm
Weight	32KG	32KG

General View of Control Panel



Control Panel Parameter Values

1.SELECT the Memory channel

2.OPEN the parameter of selected memory channel

3.STORE the setting to Memory channel

4.Push to Check Gas

5.Push to use Synergic Setting

6.Welding parameter setting,rotary dial

Adjustment of the welding current or feeding speed.

7.Torch Holding Mode

Push to select the torch handing type:

1)2T

2)4T

3)S4:for aluminium welding form cold to hot situation.

8.Welding Process

Push to select:

Welding prcess: MMA,MIG/MAG/CO2,Pulse MIG,
Double Pulse MIG.

9.Dia. of Welding Wire

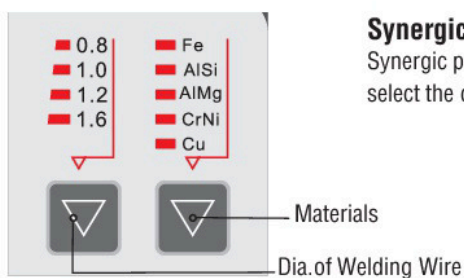
10.Wire Type

11.button,throttling effect(arc dynamics)

12.Function Sequence

13.Welding Settings

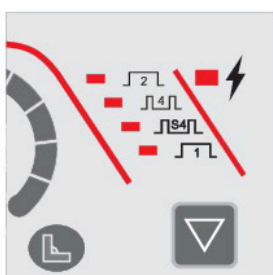
Synergic control



Synergic MIG

Synergic pulsed welding mode offers the simplicity of single-knob control. The machine will select the correct pulse power based on the wire feed speed (WFS) set by the operator.

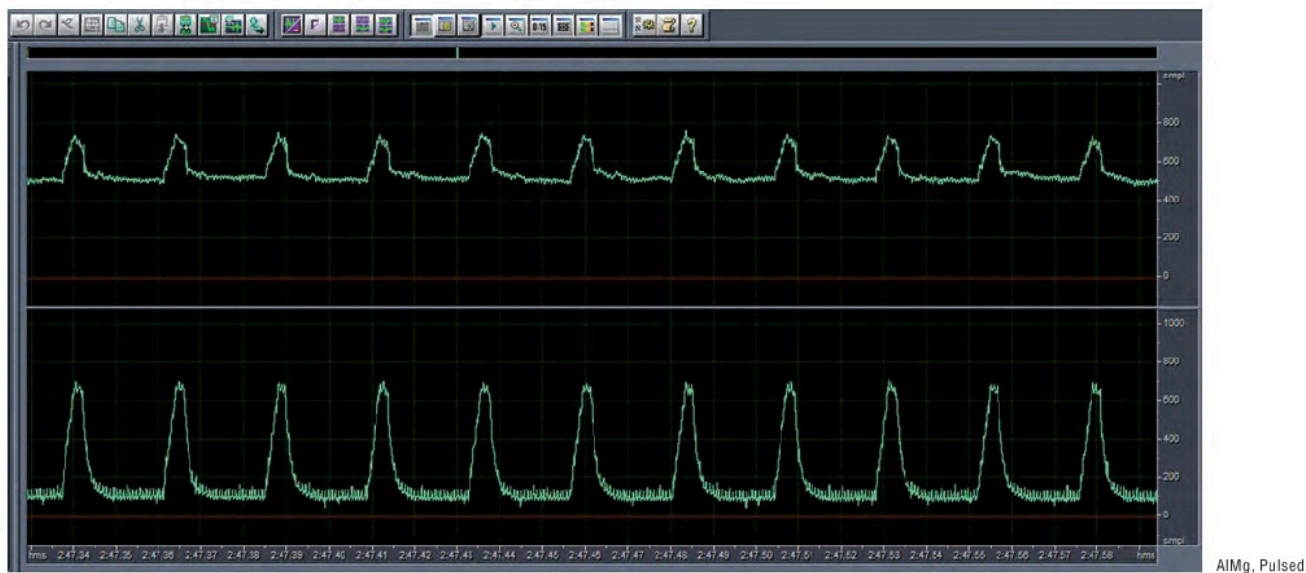
S4T Mode



S4T Mode.

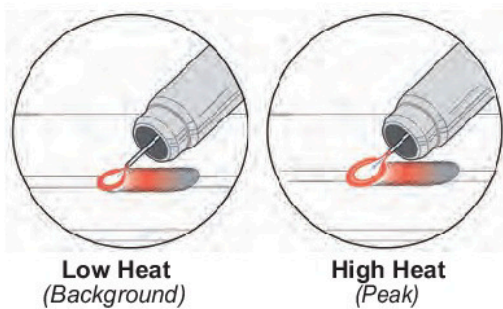
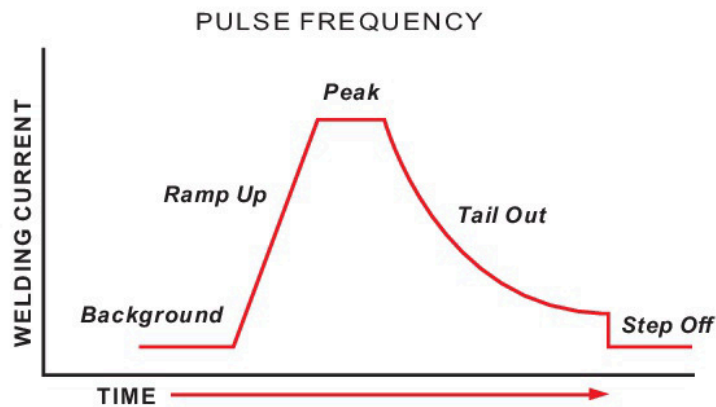
Begin and end welds with ease and confidence. Hot start eliminates incomplete fusion at the beginning of a weld, a common issue with aluminum welding. Crater gradually decreases weld current at the end of a weld to eliminate crater defects. Adjustable pre- and post-flow rates ensure that the puddle always has adequate gas coverage.

The advantage of Wave-form Control System



The latest technology of Waveform Control System with pulsed MIG control mode, can perfectly control the output of welding power and get the precision Arc performance. The wire melting droplet transfer cycle is very clear, the welding beam is very clean and very few spatters during welding.

Pulse MIG



Pulsed MIG varies weld current between peak (high heat) and background (low heat) current to provide better control of heat input, which minimizes warping and burnthrough on thin materials. Pulsed MIG also enables flat, horizontal, vertical up, or overhead welding without a slag system. Optimized GMAW-P waveforms are readily available to use on aluminum, carbon steel, high strength low alloy steel, stainless steel, and nickel alloys. See NX-2.70

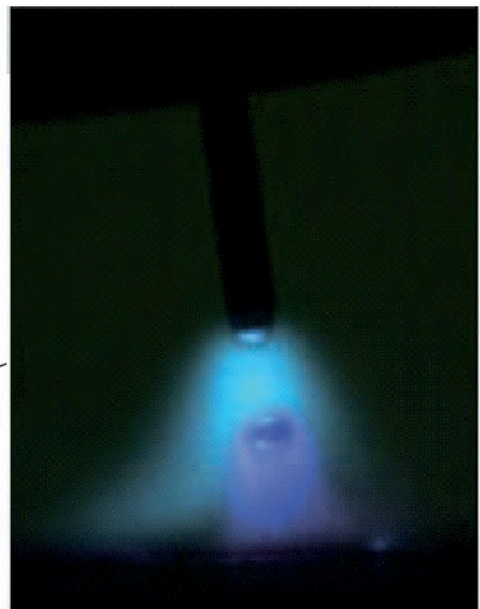
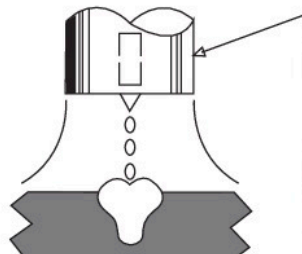
PULSED MIG

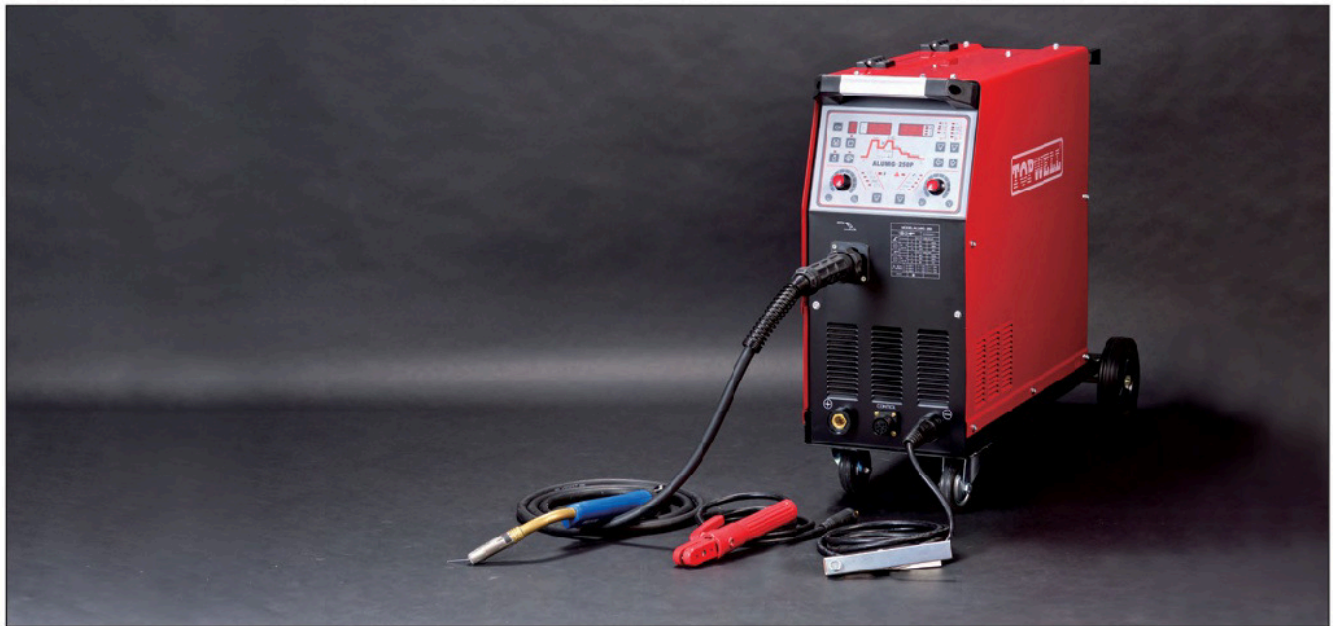
Pulse MIG precisely controls heat input through the 1-drop-per-pulse-transfer and offers a stable arc in the wide transfer area between short and spray arc.

Spray arc transfer “sprays” a stream of tiny molten droplets across the arc, from the electrode wire to the base metal. It produces a characteristic humming or buzzing sound.

Advantages of pulse mig:

- High deposition
- Good fusion and penetration
- Good bead appearance
- Capability of using larger diameter wires
- Presence of very little spatter





Accessories

For Standard accessories



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



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

For Optional accessories



Co₂ gas regular with heater



Push-pull Troch:
QTLB-24KD/36KD



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