



PROFESSIONAL IN WELDING

ProMIG-250SYN DPulse

Synergy, Pulse and Double Pulse MIG



Pulse Process For M.S/AL | Double Pulse Process For M.S/AL | Multi-processes | Full IGBT Modules | Synergy With JOBS-LIST

Advanced Features

Multi-Process Capable - Welds flux-cored, stick, TIG, pulsed MIG, and advanced processes like Double Pulse MIG*.

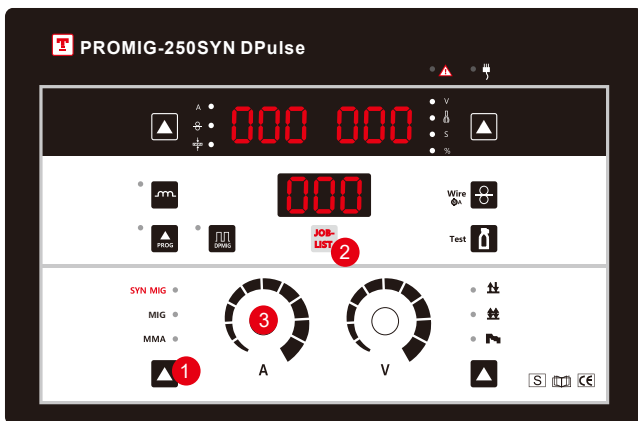
Pulse MIG Process - Welds Mild steel, 4XXX and 5XXX series aluminum for superior quality welding.

Double Pulse MIG Process - Delivers a staked dime appearance when welding mild steel and aluminum.

Synergic Control - Set weld procedures with one control.

Professional 4-Rollers Drive System - Allows for constant wire feed speed and consistent welds.

Simple Operation



3 Steps to achieve weld perfection

1. Select operation mode
2. Select Job-list No.
3. Adjust welding current
(always the perfect setting by the synergic function using the material thickness)

JOBS-list					
	Material	Gas	Wire		
			0.8	1.0	1.2
			JOBS No.		
No Pulse	M.S.	100%CO ₂	101	102	/
		82%Ar 18%CO ₂	201	202	/
	Flux Cored	Self-shielded	101	102	/
Pulse	M.S.	82%Ar 18%CO ₂	/	402	/
	S.S.	98%Ar 2%CO ₂	308	/	/
			316	/	/
	AL	100%Ar	4043	702	703
			5356	802	803

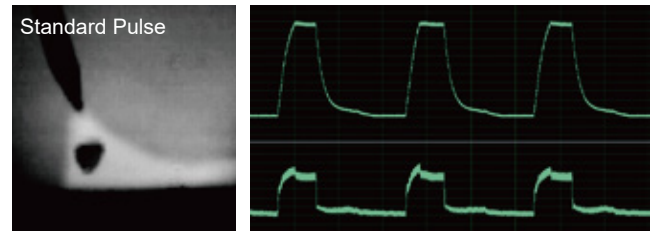
Synergy control with job-list

The Job-lists display is easily and intuitively controlled through its graphical user interface. We assembled the perfect welding curve in every Job-No. for highly efficient multi-process welding of carbon steels and aluminum alloys. Operation is easier than ever before.

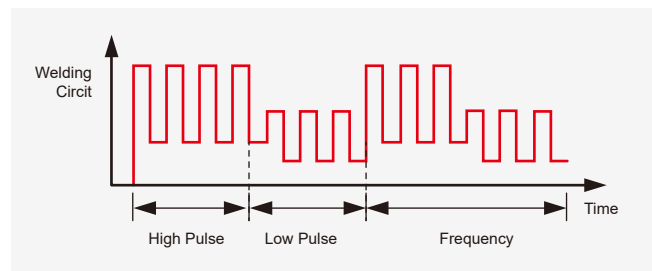
Pulse MIG

The Pulse MIG process works by forming one droplet of molten metal at the end of the electrode per pulse. Then, just the right amount of current is added to push that one droplet across the arc and into the puddle. The transfer of these droplets occurs through the arc, one droplet per pulse.

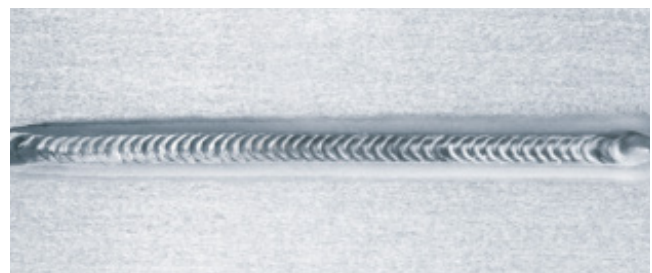
It minimizes warping and burnthrough on thin materials, not only for Aluminum, but also for Mild Steel. Moreover, it delivers ultra low spatters which is outstanding for Mild Steel welding.



Double Pulse



No need to swing, You can easily get a cosmetically pleasing weld seam, with significantly lower and more controller heat input into the workpiece. It results in much lower distortion and less rework for Mild steel and Aluminum sheets.

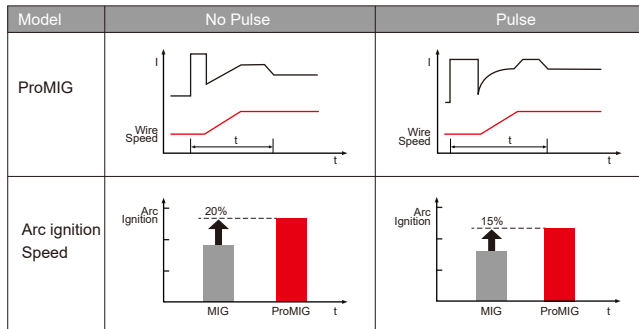


By Double Pulse process, the heat input of arc is alternating, effectively reducing the heat input of base metal. It reduces the occurrence of welding defects such as crack. Welding quality is comparable to TIG process.

Improved Operation Process & Controls

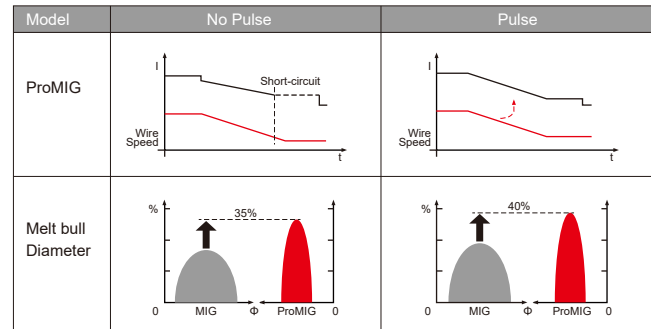
Initial Arc control

We control the arc energy by welding waveform, so the success rate of arc ignition can be improved and quickly establish a molten pool.



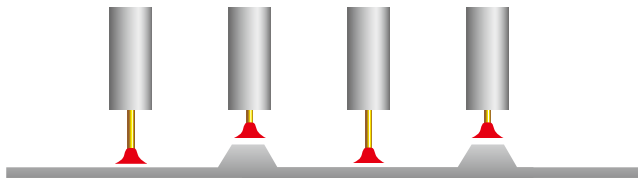
Burn Back control

Adjustable time delay between turning off the arc and the wire feed to prevent wire sticking to the puddle.



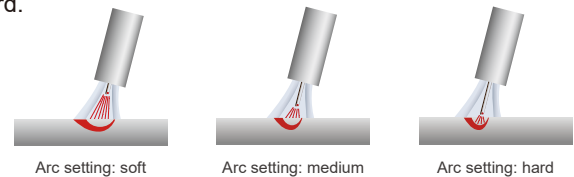
Arc Length control

By changing the distance between torch and workpiece. You can now react much more easily to control the arc, such as changing gap dimensions or arc blow, more intuitively and with greater efficiency !



Dynamic control

Dynamic control allows the welder, for the first time, to variably adjust a pulse welding machine to a wide range of jobs and welding positions as well as to his personal preferences. The welder can use a controller to directly access the arc characteristic and change it from soft to hard.



Specifications

Item No	PROMIG-250SYN DPulse
Rated Input Voltage	1PH ~ 230V ±15%/3PH ~ 400V ±15%
Max. Load Power Capacity	11.72KVA
Rated Duty Cycle(40 °C) 60%	MIG: 250A/26.5V
	MMA: 250A/30V
	TIG: 250A/20V
100%	MIG: 200A/24V
	MMA: 200A/28V
	TIG: 200A/18V
Welding Current/Voltage Range	MIG: 10A/14.5V ~250A/26.5V
	MMA: 20A/20.8V~250A/30V
	TIG: 5A/10.2V~250A/20V
Open Circuit Voltage	70V~80V
Power Factor	0.8
Efficiency	80%
Pre-Gas Time	0.1-10s
Flow-Gas Time	0.1-10s
Wire-feed Mechanism	4 Rollers
Wire-feed Speed Range	0-25m/min
Wire Spool Capacity	300mm (15kg)
Filler Wires (mm) for Fe :	0.8~1.2mm
For Stainless steel:	0.8~1.2mm
For Aluminum:	0.8~1.2mm
Dimension	790x250x650mm
Weight	32KG



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