MERKLE

GENERAL CATALOGUE

WELDING EQUIPMENT | WELDING TORCHES | ACCESSORIES

05/2020

www.merkle.de

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1. General information

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

M E R K L E
Schweissanlagen-Technik GmbH
Industriestraße 3
D-89359 Koetz, GERMANY
www.merkle.de

1.1. Contacts

Switch board:	Tel.: +49 / 08221 915-0 Fax: +49 / 08221 915-40 Fax: +49 / 08221 915-50 sales e-mail: info@merkle.de		
Secretary:		-12	info@merkle.de Fax: +49 / 8221 915-40
Management:	Mr. Wilhelm Merkle Dr.-Ing. Ulrich Prank Mr. Thomas Merkle	-12 -12 -12	wilhelm.merkle@merkle.de ulrich.prank@merkle.de thomas.merkle@merkle.de
Domestic sales / export:	Mr. Helmut Beyer Mr. Justin Nehrwein Mr. Nikolai Kern	-35 -14 -13	helmut.beyer@merkle.de justin.nehrwein@merkle.de export@merkle.de Fax: +49 / 8221 915-50
Service:	Mr. David Kindermann Mr. Bernhard Klotz	-32 -58	service@merkle.de Fax: +49 / 8221 915-62
Accounting:			fibu@merkle.de Fax: +49 / 8221 32596

1.2. Price list

MIG/MAG WELDING UNITS

Model	without accessories	with accessories	with torch 3 m	with torch 4 m	torch model
RedMIG Series - step controlled					
RedMIG 1600 K*	1,320.00	1,360.00	1,420.00	1,427.00	SB 157 G
RedMIG 2000 K*	1,320.00	1,360.00	1,420.00	1,427.00	SB 157 G
RedMIG 2800 K (DV-26)*	1,720.00	1,770.00	1,860.00	1,890.00	SB 307 G
RedMIG 3000 K (DV-26)*	1,920.00	1,970.00	2,060.00	2,090.00	SB 307 G
RedMIG 3000 D (DV-26)*	2,610.00	2,660.00	2,750.00	2,780.00	SB 307 G
CompactMIG Series - synergic wire feed, step controlled, 4-roller wire feeder					
CompactMIG 280 K*	2,090.00	2,140.00	2,230.00	2,260.00	SBT 307 G
CompactMIG 400 K*	3,175.00	3,255.00	3,345.00	3,375.00	SBT 307 G
CompactMIG 400 DW*	4,420.00	4,500.00	4,640.00	4,650.00	SBT 504 W
OptiMIG Series - synergic step control, TEDAC system, 4-roller wire feeder					
OptiMIG 351 KW*	4,150.00	4,230.00	4,370.00	4,380.00	SBT 504 W
OptiMIG 451 KW*	4,290.00	4,370.00	4,510.00	4,520.00	SBT 504 W
OptiMIG 351 DW*	5,180.00	5,260.00	5,400.00	5,410.00	SBT 504 W
OptiMIG 451 DW*	5,320.00	5,400.00	5,540.00	5,550.00	SBT 504 W
OptiMIG 551 DW*	6,150.00	6,250.00	6,390.00	6,400.00	SBT 504 W
MobiMIG Series - synergic continuous control, TEDAC system, electrode, TIG (DC)					
MobiMIG 180 K	1,848.00	1,888.00	1,968.00	1,975.00	SBT 157 G
MobiMIG 280 K	3,250.00	3,300.00	3,410.00	3,440.00	SBT 307 G
MobiMIG 321 K	3,500.00	3,550.00	3,660.00	3,690.00	SBT 307 G
MobiMIG 321 K – with WK 300, TW 112	4,890.00	4,940.00	5,080.00	5,090.00	SBT 504 W
SpeedMIG touch Series - continuously controlled, TEDAC-System, DeepARC as a standard:					
SpeedMIG touch 450 KW	6,045.00	6,145.00	6,285.00	6,295.00	SBT 504 W
SpeedMIG touch 450 DW	6,970.00	7,070.00	7,210.00	7,220.00	SBT 504 W

SYNERGIC MIG PULSE-ARC WELDING MACHINES – Series HighPULSE touch

Model	without accessories	with accessories	with torch 3 m	with torch 4 m	torch model
HighPULSE touch 280 K	5,380.00	5,450.00	5,560.00	5,590.00	SBT 307 G
HighPULSE touch 350 K	5,840.00	5,910.00	6,020.00	6,050.00	SBT 307 G
HighPULSE touch 350 K – with WK 301, TW 112	7,080.00	7,150.00	7,290.00	7,300.00	SBT 504 W
HighPULSE touch 400 KW	6,960.00	7,040.00	7,180.00	7,190.00	SBT 504 W
HighPULSE touch 450 KW	7,530.00	7,630.00	7,770.00	7,780.00	SBT 504 W
HighPULSE touch 400 DW	7,910.00	7,990.00	8,130.00	8,140.00	SBT 504 W
HighPULSE touch 450 DW	8,480.00	8,580.00	8,720.00	8,730.00	SBT 504 W

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

* : Prices do not include material surcharge.

SYNERGIC MIG PULSE-ARC WELDING MACHINES – Series HighPULSE

Model	without accessories	with accessories	with torch 3 m	with torch 4 m	torch model
HighPULSE 284 K	5,680.00	5,750.00	5,860.00	5,890.00	SBT 307 G
HighPULSE 354 K	6,140.00	6,210.00	6,320.00	6,350.00	SBT 307 G
HighPULSE 354 K – with WK 300, TW 112	7,460.00	7,530.00	7,670.00	7,680.00	SBT 504 W
HighPULSE 353 K	6,330.00				
HighPULSE 454 KW	8,710.00	8,810.00	8,950.00	8,960.00	SBT 504 W
HighPULSE 554 KW	8,980.00	9,080.00	9,220.00	9,230.00	SBT 504 W
HighPULSE 354 DW	8,650.00	8,730.00	8,870.00	8,880.00	SBT 504 W
HighPULSE 454 DW-26	9,740.00	9,840.00	9,980.00	9,990.00	SBT 504 W
HighPULSE 454 DW-31	10,220.00	10,320.00	10,460.00	10,470.00	SBT 504 W
HighPULSE 554 DW-26	10,000.00	10,100.00	10,240.00	10,250.00	SBT 504 W
HighPULSE 554 DW-31	10,480.00	10,580.00	10,720.00	10,730.00	SBT 504 W
HighPULSE 354 DW TWIN	12,440.00	with optional wire straightening unit			
HighPULSE 454 DW TWIN	13,350.00	with optional wire straightening unit			
HighPULSE 554 DW TWIN	13,890.00	with optional wire straightening unit			
HighPULSE 352/452/552 RS	Robot- and Automation power source, see data sheet/catalogue				

TIG WELDING UNITS

Model	without accessories	with accessories	with torch 4 m	with torch 8 m	torch model
TIG DC-series - portable DC TIG welding units					
LiteTIG 190 DC	1,415.00	1,465.00	1,715.00	1,795.00	TH 202 G
LiteTIG 210 DC	1,970.00	2,020.00	2,270.00	2,350.00	TH 202 G
MobiTIG 194 DC mobil	1,680.00	1,730.00	1,980.00	2,060.00	TH 202 G
MobiTIG 304 DC	3,130.00	3,210.00	3,460.00	3,540.00	TH 202 G
MobiTIG 304 DC with WK 210, TW 112	4,480.00	4,560.00	4,810.00	4,890.00	TH 452 W
HighTIG series (DC)					
HighTIG W 350 DC	6,610.00	6,730.00	7,110.00	7,150.00	TH 452 W
HighTIG 452 DC with WK 350, TW 114	9,095.00			9,635.00	TH 452 W
HighTIG 552 DC with WK 350, TW 114	9,485.00			10,210.00	TH 600 W
HighTIG 452 DC RS	6,290.00	plus combination			
HighTIG 552 DC RS	6,450.00	plus combination			
TIG AC/DC-series - portable AC/DC TIG welding units					
LiteTIG 190 AC/DC	2,415.00	2,465.00	2,715.00	2,795.00	TH 202 G
LiteTIG 210 AC/DC	2,785.00	2,835.00	3,085.00	3,165.00	TH 202 G
LogiTIG 221 AC/DC	4,570.00	4,650.00	4,900.00	4,980.00	TH 202 G
LogiTIG 221 AC/DC with WK 210, TW 112	5,830.00	5,910.00	6,290.00	6,330.00	TH 452 W
LogiTIG 240 AC/DC	4,990.00	5,070.00	5,320.00	5,400.00	TH 202 G
LogiTIG 240 AC/DC with WK 230, TW 112	6,280.00	6,360.00	6,740.00	6,780.00	TH 452 W
LogiTIG 300 AC/DC	6,950.00	7,070.00	7,320.00	7,400.00	TH 202 G
LogiTIG 300 AC/DC with WK 300, TW 112	8,080.00	8,200.00	8,580.00	8,620.00	TH 452 W
INSQUARE series (AC/DC) - TIG welding units with integrated water cooler					
Insquare W 321 AC/DC	9,995.00	10,115.00	10,495.00	10,535.00	TH 452 W
Insquare W 421 AC/DC	10,650.00	10,780.00	11,160.00	11,200.00	TH 452 W
Insquare W 600 AC/DC	20,035.00	20,295.00		20,870.00	TH 600 W

PLASMA WELDING UNITS

HighPLAS 352/452 DC RS	see data sheet/catalogue

MMA/STICK ELECTRODE WELDING UNITS

Model	without accessories	with accessories	
LiteARC 160	585.00	655.00	(with LiftTIG)
LiteARC 180	685.00	755.00	(with LiftTIG)
MobiARC 164 mobil	900.00	970.00	(with LiftTIG)
MobiARC 284 cel	2,510.00	2,610.00	(with LiftTIG)
MobiARC 284 cel ±	3,590.00	3,690.00	(with LiftTIG)

PLASMA CUTTING UNITS

Model	without accessories	with accessories	with torch, 8 m	torch model
C 82	4,270.00	4,305.00	4,690.00	PR 81
AirCUT 120 W*	7,120.00	7,200.00	8,150.00	PR 122 W

MIG/MAG WELDING TORCHES*

	Standard			TEDAC			
	SB	SB	SB	SBT	SBT	SBT	
Model	3 m	4 m	5 m	3 m	4 m	5 m	
157 G	112.00	119.00		197.00	204.00		gas cooled
307 G	158.00	188.00	218.00	243.00	273.00	303.00	gas cooled
351 G	168.00	198.00	228.00	253.00	283.00	313.00	gas cooled
352 W	365.00	375.00		440.00	450.00		water cooled
504 W short version	350.00	360.00	370.00	425.00	435.00	445.00	water cooled
504 W long version	380.00	390.00	400.00	455.00	465.00	475.00	water cooled
603 W	450.00	465.00		555.00	570.00		water cooled
H 600 W high performance	520.00	535.00		625.00	640.00		high performance gas nozzle
R 351 G fume extraction	425.00	460.00		520.00	555.00		gas cooled
R 503 W fume extraction	578.00	608.00		673.00	703.00		water cooled
MSB 400 W machine welding torch			see data sheet/catalogue				water cooled
ROB W HW robot and machine welding torch			see data sheet/catalogue				water cooled
ROB 505 W robot and machine welding torch			see data sheet/catalogue				water cooled
MSB 603 W machine welding torch			see data sheet/catalogue				water cooled

PUSH PULL TORCHES*

Model	Standard PP, 8 m		TEDAC PPT, 8 m		
	fixed	rotatable	fixed	rotatable	
307 G		1,790.00		1,990.00	gas cooled
502 W	1,890.00	2,090.00	2,090.00	2,290.00	water cooled

TIG WELDING TORCHES*

	Standard		Potentiometer		
Model	4 m	8 m	4 m	8 m	torch connector
TH 202 G gas cooled	280.00	370.00		425.00	Merkle TCG-Connector
	290.00	*380.00*		*435.00*	*Euro-Connector*
TH 452 W water cooled	405.00	445.00	460.00	500.00	Merkle TCG-Connector
	415.00	*455.00*	*470.00*	*510.00*	*Euro-Connector*
TH 600 W water cooled		575.00		615.00	Euro-Connector
TM 450 W water cooled		see data sheet/catalogue			machine torch, Euro-Connector

PLASMA CUTTING TORCHES*

Model	8 m	
PR 81	518.00	gas cooled
PR 81-M	560.00	gas cooled
PR 122 W	950.00	water cooled
PR 121 W-M	1,070.00	water cooled

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

* : Prices do not include material surcharge.

2. MIG/MAG welding units

2.1 Welding units step controlled
RedMIG series

2.2 Welding units step controlled with synergic wire feed
CompactMIG series
OptiMIG series

2.3 Welding units continuously controlled
MobiMIG series
SpeedMIG touch series

2.1. MIG/MAG welding units step controlled

2.1.1. RedMIG 1600 K

Primary:	
Voltage:	1 x 230 V
Frequency:	50 / 60 Hz
Continuous power:	3 kVA
Continuous current:	13 A
Max. current:	22 A
cos phi:	0.85
Secondary:	
Open circuit voltage:	19 - 35 V
Welding voltage:	15 - 22 V
Welding current:	25 - 160 A
Duty cycle 30 % (10 min.):	160 A (40 °C)
Duty cycle 35 % (10 min.):	160 A (20 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)

Protection class:	IP 21
Insulation:	H
Cooling:	AF
Voltage control:	7 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time	potentiometer
Intermission time:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas
Gas bottle holder:	10 - 20 l cylinders
Mains supply cable:	3 x 1.5 mm², 5 m long with plug
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Weight:	65 kg
Dimensions l x w x h:	800 x 460 x 655 mm

Wire feeder compact mounted: model DV-21

Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7 - 20 m/min
Wire feed:	2-roller-drive
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit RedMIG 1600 K**					
	A	**MIG/MAG welding unit model RedMIG 1600 K**		**19**	**SET113974**	**1.320,00**
	AB	**MIG/MAG welding unit odel RedMIG 1600 K with accessories**		**19**	**SET113976**	**1.360,00**
	ABC1	**MIG/MAG welding unit model RedMIG 1600 K with accessories and hand welding torch SB 157 G, 3 m**		**19**	**SET113978**	**1.420,00**
	ABC2	**MIG/MAG welding unit model RedMIG 1600 K with accessories and hand welding torch SB 157 G, 4 m**		**19**	**SET113979**	**1.427,00**
B	**Standard accessories:**					
	B1	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	40,50
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch model SB 157 G, 3 m**		**06**	**118700**	**112,00**
	C2	**MIG/MAG hand welding torch model SB 157 G, 4 m**		**06**	**118702**	**119,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Front carriage extension for RedMIG and CompactMIG 280 K for using 50 l gas cylinders		46	157750	82,00
	D3	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
E	**Additional wire equipment for DV-21:**					
	E1	Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)		46	01200387	41,00
	E2	Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200388	43,00
	E3	Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200390	58,00
	E4	Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)		46	01200392	58,00

2.1.2. RedMIG 2000 K

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	4.2 kVA
Continuous current:	6.0 A
Max. current:	12 A
cos phi (200 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	17 - 39 V
Welding voltage:	15 - 24 V
Welding current:	25 - 200 A
Duty cycle 30 % (10 min.):	200 A (40 °C)
Duty cycle 35 % (10 min.):	200 A (20 °C)
Duty cycle 60 % (10 min.):	160 A (40 °C)

Protection class:	IP 21
Insulation:	H
Cooling:	AF
Voltage control:	7 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time:	potentiometer
Intermissiontime:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas
Gas bottle holder:	10 - 20 l cylinders
Mains supply cable:	4 x 1.5 mm², 5 m long
	with plug 3 x 400 V / 16 A
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Weight:	70 kg
Dimensions l x w x h:	800 x 460 x 655 mm

Wire feeder compact mounted: model DV-21

Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7-20 m/min.
Gear:	2-roller-drive
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit RedMIG 2000 K**					
	A	**MIG/MAG welding unit RedMIG 2000 K**		**39**	**SET113990**	**1.320,00**
	AB	**MIG/MAG welding unit RedMIG 2000 K with accessories**		**39**	**SET113992**	**1.360,00**
	ABC1	**MIG/MAG welding unit RedMIG 2000 K with accessories and hand welding torch SB 157 G, 3 m**		**39**	**SET113994**	**1.420,00**
	ABC2	**MIG/MAG welding unit RedMIG 2000 K with accessories and hand welding torch SB 157 G, 4 m**		**39**	**SET113996**	**1.427,00**
B	**Standard accessories:**					
	B1	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	40,50
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch model SB 157 G, 3 m**		**06**	**118700**	**112,00**
	C2	**MIG/MAG hand welding torch model SB 157 G, 4 m**		**06**	**118702**	**119,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Front carriage extension for RedMIG and CompactMIG 280 K for using 50 l gas cylinders		46	157750	82,00
	D3	MIG/MAG hand welding torch model SB 307 G, 3 m		06	02210758	158,00
	D4	MIG/MAG hand welding torch model SB 307 G, 4 m		06	02210759	188,00
E	**Additional wire equipment for DV-21:**					
	E1	Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)		46	01200387	41,00
	E2	Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200388	43,00
	E3	Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200390	58,00
	E4	Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)		46	01200392	58,00

2.1.3. RedMIG 2800 K

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	6.2 kVA
Continuous current:	9.0 A
Max. current:	19 A
cos phi (280 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	16 - 42 V
Welding voltage:	15 - 28 V
Welding current:	25 - 280 A
Duty cycle 30 %(10 min.):	280 A (40 °C)
Duty cycle 35% (10 min.):	280 A (20 °C)
Duty cycle 60% (10 min.):	210 A (40 °C)

Protection class:	IP 21
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time:	potentiometer
Intermissiontime:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas
Gas bottle holder:	10 - 20 l cylinders
Mains supply cable:	4 x 1.5 mm², 5 m long
	with plug 3 x 400 V / 16 A
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Weight:	80 kg
Dimensions l x w x h:	800 x 460 x 655 mm

Wire feeder: compact mounted, model DV-26	
Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive
	0.7-25 m/min
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit RedMIG 2800 K**					
	A	**MIG/MAG welding unit RedMIG 2800 K with 4-roller-drive DV-26**		**69**	**SET116056**	**1.720,00**
	AB	**MIG/MAG welding unit RedMIG 2800 K ith 4-roller-drive DV-26 and accessories**		**69**	**SET116058**	**1.770,00**
	ABC1	**MIG/MAG welding unit RedMIG 2800 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 3 m**		**69**	**SET116060**	**1.860,00**
	ABC2	**MIG/MAG welding unit RedMIG 2800 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 4 m**		**69**	**SET116062**	**1.890,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch model SB 307 G, 3 m**		**06**	**02210758**	**158,00**
	C2	**MIG/MAG hand welding torch model SB 307 G, 4 m**		**06**	**02210759**	**188,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Front carriage extension for RedMIG and CompactMIG 280 K for using 50 l gas cylinders		46	157750	82,00
E	**Additional wire equipment for DV-26:**					
	E1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	E2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	E3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	E4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	E5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	E6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.1.4. RedMIG 3000 K

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	8.3 kVA
Continuous current:	12 A
Max. current:	19 A
cos phi (280 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	16 - 42 V
Welding voltage:	15 - 28 V
Welding current:	25 - 280 A
Duty cycle 35 % (10 min.):	280 A (40 °C)
Duty cycle 60 % (10 min.):	240 A (40 °C)
Duty cycle 100 %:	200 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time:	potentiometer
Intermission time:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas
Mains supply cable:	4 x 1.5 mm², 5 m long
	with plug 3 x 400 V / 16 A
Gas bottle holder:	10, 20, 50 l cylinders
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces as option
Weight:	120 kg
Dimensions l x w x h:	940 x 445 x 760 mm

Wire feeder: compact mounted, model DV-26

Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive
	0.7-25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit RedMIG 3000 K**					
	A	**MIG/MAG welding unit RedMIG 3000 K with 4-roller-drive DV-26**		**69**	**SET116064**	**1.920,00**
	AB	**MIG/MAG welding unit RedMIG 3000 K ith 4-roller-drive DV-26 and accessories**		**69**	**SET116066**	**1.970,00**
	ABC1	**MIG/MAG welding unit RedMIG 3000 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 3 m**		**69**	**SET116068**	**2.060,00**
	ABC2	**MIG/MAG welding unit RedMIG 3000 K with 4-roller-drive DV-26 and accessories and hand welding torch SB 307 G, 4 m**		**69**	**SET116070**	**2.090,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch model SB 307 G, 3 m**		**06**	**02210758**	**158,00**
	C2	**MIG/MAG hand welding torch model SB 307 G, 4 m**		**06**	**02210759**	**188,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Lifting eye screw, galvanized		46	09002001	3,60
E	**Additional wire equipment for DV-26:**					
	E1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	E2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	E3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	E4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	E5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	E6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

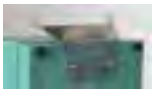
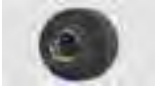
2.1.5. RedMIG 3000 D

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	8.3 kVA
Continuous current:	12 A
Max. current:	19 A
cos phi (280 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	16 - 42 V
Welding voltage:	15 - 28 V
Welding current:	25 - 280 A
Duty cycle 35 % (10 min.):	280 A (40 °C)
Duty cycle 60 % (10 min.):	240 A (40 °C)
Duty cycle 100 %:	200 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	potentiometer
Wire burn back:	preset
Spot welding time:	potentiometer
Intermission time:	potentiometer
Control lamp:	mains on
Rectifier:	silicon press-in diodes
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 1.5 mm², 5 m long with plug 3 x 400 V / 16 A
Gas bottle holder:	10, 20, 50 l cylinders
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces as option
Weight:	140 kg
Dimensions l x w x h:	940 x 445 x 1040 mm

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7-25 m/min.
Gear:	4-roller-drive DV-26
Wire feed speed:	potentiometer
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Weight:	18 kg
Dimensions:	610 x 400 x 180 mm
Connection cable:	1.6 m, 50 mm², water cooled
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit RedMIG 3000 D**					
	A	**MIG/MAG welding unit RedMIG 3000 D**		**69**	**SET138186**	**2.610,00**
	AB	**MIG/MAG welding unit RedMIG 3000 D with accessories**		**69**	**SET138188**	**2.660,00**
	ABC1	**MIG/MAG welding unit RedMIG 3000 D with access. and torch SB 307 G, 3 m**		**69**	**SET138190**	**2.750,00**
	ABC2	**MIG/MAG welding unit RedMIG 3000 D with access. and torch SB 307 G, 4 m**		**69**	**SET138192**	**2.780,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch model SB 307 G, 3 m**		**06**	**02210758**	**158,00**
	C2	**MIG/MAG hand welding torch model SB 307 G, 4 m**		**06**	**02210759**	**188,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Lifting eye screw, galvanized		46	09002001	3,60
	D3	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
E	**Accessories for wire feeder:**					
	E1	Rotatable device for wire feeder including screw set		46	137436	155,00
	E2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	E3	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	E4	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	E5	Wire feeder DV-26 for RedMIG 3000 D		38	138192	1.175,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Pos.	Description	Pu	PrGrp	Part No.	Price/€
F	**Connection cable to wire feeder:**				
F1	Connection cable, 5 m, 50 mm² g RedMIG 3000 D		38	138186	295,00
F2	Connection cable 10 m, 50 mm² g RedMIG 3000 D		38	138188	400,00
F3	Connection cable 20 m, 50 mm² g RedMIG 3000 D		38	138190	630,00
	Price reduction, when not taken:				
F4	Connection cable, 1.6 m, 50 mm² g RedMIG 3000 D		38	138185	220,00
G	**Additional wire equipment for DV-26:**				
G1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
G2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
G3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
G4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
G5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
G6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.2. MIG/MAG welding units step controlled with synergic wire feed

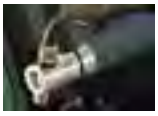
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

2.2.1. CompactMIG 280 K

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	6.2 kVA
Continuous current:	9.0 A
Max. current:	19 A
cos phi (280 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	16 - 42 V
Welding voltage:	15 - 28 V
Welding current:	25 - 280 A
Duty cycle 35 % (10 min.):	280 A (40 °C)
Duty cycle 40 % (10 min.):	280 A (20 °C)
Duty cycle 60 % (10 min.):	230 A (40 °C)
Duty cycle 100 %:	180 A (40 °C)

Protection class:	IP 21
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Choke:	1-step
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas cooled
Gas bottle holder:	10 - 20 l gas cylinders
Mains supply cable:	4 x 1.5 mm², 5 m long with plug 3 x 400 V/16 A
Gas supply cable:	2 m long
Earth cable:	socket 50 mm²
Weight:	105 kg
Dimensions l x w x h:	870 x 480 x 740 mm

Wire feeder: compact mounted, model DV-26	
Voltage:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7 - 25 m/min.
Wire feed:	4-roller-system
Reel hub assembly:	D 300/15 DIN 8559
Torch connector:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit CompactMIG 280 K**					
	A	**MIG/MAG welding unit CompactMIG 280 K**		**44**	**SET113376**	**2.090,00**
	AB	**MIG/MAG welding unit CompactMIG 280 K with accessories**		**44**	**SET113378**	**2.140,00**
	ABC1	**MIG/MAG welding unit CompactMIG 280 K with accessories and TEDAC torch SBT 307 G, 3 m**		**44**	**SET113380**	**2.230,00**
	ABC2	**MIG/MAG welding unit CompactMIG 280 K with accessories and TEDAC torch SBT 307 G, 4 m**		**44**	**SET113382**	**2.260,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Front carriage extension for RedMIG and CompactMIG 280 K for using 50 l gas cylinders		46	157750	82,00
	D3	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D4	Mains supply 3 x 230/400 V for MIG 280 - 300 A		46	01903054	70,00
E	**Additional wire equipment for DV-26:**					
	E1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	E2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	E3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	E4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	E5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	E6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

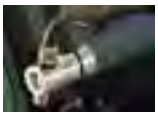
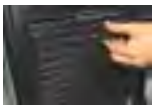
2.2.2. CompactMIG 400 K

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	10.4 kVA
Continuous current:	14 A
Max. current:	28 A
cos phi (350 A):	0.8
cos phi (200 A):	0.85
Secondary:	
Open circuit voltage:	17 - 48 V
Welding voltage:	15 - 34 V
Welding current:	25 - 400 A
Duty cycle 30 % (10 min.):	400 A (40 °C)
Duty cycle 60 % (10 min.):	300 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Choke:	100 %, option: 60 %
Norm:	EN 60974-1 "S" / CE
Torch cooling:	gas cooled
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4 mm² 5 m long with plug 3 x 400 V / 32 A
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces as option
Weight:	140 kg
Dimensions l x w x h:	940 x 480 x 760 mm

Wire feeder: compact mounted, model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.7 - 25 m/min.
Gear:	4-roller-drive DV-26
Wire feeder support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit CompactMIG 400 K**					
	A	**MIG/MAG welding unit CompactMIG 400 K**		**40**	**SET123810**	**3.175,00**
	AB	**MIG/MAG welding unit CompactMIG 400 K with accessories**		**40**	**SET123812**	**3.255,00**
	ABC1	**MIG/MAG welding unit CompactMIG 400 K with accessories and hand welding torch SBT 307 G, 3 m**		**40**	**SET123814**	**3.345,00**
	ABC2	**MIG/MAG welding unit CompactMIG 400 K with accessories and hand welding torch SBT 307 G, 4 m**		**40**	**SET123816**	**3.375,00**
B	**Standard accessories:**					
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D3	Filter frame incl. filter for IQ 300/420/600, CM 350/400, RM 3000/4000, reduced duty cycle		46	00501047	105,00
	D4	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)		46	00501048	3,50
	D5	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	D6	Lifting eye screw, galvanized		46	09002001	3,60

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Optional choke socket 60 % for series OptiMIG and CompactMIG		46	144610	83,50
	D8	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Additional wire equipment for DV-26:

	E1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	E2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	E3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	E4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	E5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	E6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

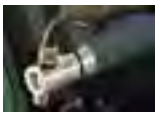
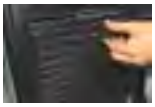
2.2.3. CompactMIG 400 DW

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	10.4 kVA
Continuous current:	14 A
Max. current:	28 A
cos phi (350 A):	0.8
cos phi (200 A):	0.85
Secondary:	
Open circuit voltage:	17 - 48 V
Welding voltage:	15 - 34 V
Welding current:	25 - 400 A
Duty cycle 30 % (10 min.):	400 A (40 °C)
Duty cycle 60 % (10 min.):	300 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)

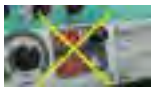
Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	range 0-1-2
Voltage control:	14 steps
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Push pull torch:	connector (option)
Remote control:	wire feed speed (option)
Choke:	100 %, option: 60 %
Norm:	EN 60974-1 "S" / CE
Torch cooling:	water cooled
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4 mm², 5 m long with plug 3 x 400 V / 32 A
Gas hose:	2 m long
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces as option
Weight:	170 kg
Dimensions l x w x h:	940 x 480 x 1040 mm

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive
	0.7 - 25 m/min.
Gear:	4-roller-drive DV-26
Wire feed speed:	potentiometer
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Weight:	18 kg
Dimensions:	610 x 400 180 mm
Connection cable:	1.6 m, 50 mm², water cooled
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MIG/MAG welding unit CompactMIG 400 DW**				
	A	**MIG/MAG welding unit CompactMIG 400 DW**		**40**	**SET123830**	**4.420,00**
	AB	**MIG/MAG welding unit CompactMIG 400 DW with accessories**		**40**	**SET123832**	**4.500,00**
	ABC1	**MIG/MAG welding unit CompactMIG 400 DW with accessories and hand welding torch SBT 504 W, 3 m**		**40**	**SET123834**	**4.640,00**
	ABC2	**MIG/MAG welding unit CompactMIG 400 DW with accessories and hand welding torch SBT 504 W, 4 m**		**40**	**SET123836**	**4.650,00**
B		**Standard accessories:**				
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C		**Welding torches:**				
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**
D		**Accessories:**				
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	D4	Filter frame incl. filter for IQ 300/420/600, CM 350/400, RM 3000/4000, reduced duty cycle		46	00501047	105,00
	D5	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)		46	00501048	3,50
	D6	Lifting eye screw, galvanized		46	09002001	3,60

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Price reduction no digital display for CompactMIG 400 D/DW		46	134506	-150,00
	D8	Optional choke socket 60 % for series OptiMIG and CompactMIG		46	144610	83,50
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for wire feeder:

	E1	Rotatable device for wire feeder including screw set		46	137436	155,00
	E2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	E3	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	E4	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00

F Connection cable to wire feeder:

	F1	Connection cable, 5 m, 50 mm² water CompactMIG 400 DW, RedMIG 4000 DW		38	115256	320,00
	F2	Connection cable, 10 m, 70 mm² water CompactMIG 400 DW, RedMIG 4000 DW		38	115260	490,00
	F3	Connection cable, 15 m, 70 mm² water CompactMIG 400 DW, RedMIG 4000 DW		38	115262	670,00
	F4	Connection cable, 20 m, 70 mm² water CompactMIG 400 DW, RedMIG 4000 DW		38	115264	855,00

Price reduction, when not taken:

	F5	Connection cable, 1.6 m, 50 mm² water CompactMIG 400 DW, RedMIG 4000 DW		38	115266	162,00

G Additional wire equipment for DV-26:

	G1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	G2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	G3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	G4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	G6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.2.4. OptiMIG 351 KW

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	13.1 kVA
Continuous current:	19 A
Max. current:	22 A
cos phi (350 A):	0.8
cos phi (150 A):	0.82
Secondary:	
Open circuit voltage:	16 - 40 V
Welding voltage:	15 - 32 V
Welding current:	25 - 350 A
Duty cycle 60 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	300 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3 phase
Voltage control:	28 steps 4-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Rectifier:	silicon press-in diodes
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m long
Choke:	100%, option: 60%
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces as an option
Weight:	190 kg
Dimensions l x w x h:	990 x 510 x 845 mm incl. gas bottle holder

Wire feeder: compact mounted, model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MIG/MAG welding unit OptiMIG 351 KW**				
	A	**MIG/MAG welding unit OptiMIG 351 KW**		**01**	**SET149938**	**4.150,00**
	AB	**MIG/MAG welding unit OptiMIG 351 KW with accessories**		**01**	**SET149940**	**4.230,00**
	ABC1	**MIG/MAG welding unit OptiMIG 351 KW with accessories and hand welding torch SBT 504 W, 3 m**		**01**	**SET149942**	**4.370,00**
	ABC2	**MIG/MAG welding unit OptiMIG 351 KW with accessories and hand welding torch SBT 504 W, 4 m**		**01**	**SET149944**	**4.380,00**
B		**Standard accessories:**				
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C		**Welding torches:**				
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.2.5. OptiMIG 451 KW

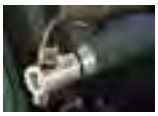
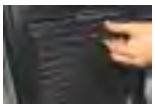
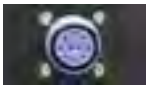
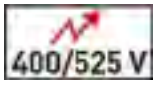
Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	14.5 kVA
Continuous current:	21 A
Max. current:	36 A
cos phi (450 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	17 - 52 V
Welding voltage:	15 - 36.5 V
Welding current:	25 - 450 A
Duty cycle 40 % (10 min.):	450 A (40 °C)
Duty cycle 60 % (10 min.):	420 A (40 °C)
Duty cycle 100 %:	340 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3 phase
Voltage control:	42 steps 6-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Rectifier:	silicon press-in diodes
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces (option)
Weight:	200 kg
Dimensions l x w x h:	990 x 510 x 845 mm incl. gas bottle holder

Wire feeder: compact mounted, model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	Wire feed speed
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MIG/MAG welding unit OptiMIG 451 KW**				
	A	**MIG/MAG welding unit OptiMIG 451 KW**		**01**	**SET149946**	**4.290,00**
	AB	**MIG/MAG welding unit OptiMIG 451 KW with accessories**		**01**	**SET149948**	**4.370,00**
	ABC1	**MIG/MAG welding unit OptiMIG 451 KW with accessories and hand welding torch SBT 504 W, 3 m**		**01**	**SET149950**	**4.510,00**
	ABC2	**MIG/MAG welding unit OptiMIG 451 KW with accessories and hand welding torch SBT 504 W, 4 m**		**01**	**SET149952**	**4.520,00**
B		**Standard accessories:**				
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C		**Welding torches:**				
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.2.6. Accessories for OptiMIG 351/451 KW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	**Accessories:**					
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.4	Filter frame incl. filter for OptiMIG reduced duty cycle		46	109524	104,00
	1.5	Filter for OptiMIG	10 pcs	46	109528	3,50
	1.6	Metal filter insert for OptiMIG		46	156682	115,00
	1.7	Push-Pull kit incl. sockets and switches		46	02110403	630,00
	1.8	Connection for automated welding welding ON, arc OK, emergency STOP for MAG 30 controller		46	114668	240,00
	1.9	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	1.10	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	1.11	Mains supply 3 x 230/400V, for OptiMIG series		46	114670	230,00
	1.12	Supply voltage 3 x 400/525 V for OptiMIG series		46	111416	440,00
	1.13	Price reduction: no integrated water cooling unit (K version)		46	111832	-250,00
	1.14	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.15	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	251,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.16	EN 1090 WPS/WPQR package for series OptiMIG		17	138672	149,00
	1.17	Optional choke socket 60 % for series OptiMIG and CompactMIG		46	144610	83,50

2 Additional wire equipment for DV-26:

	2.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	2.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	2.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	2.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	2.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	2.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.2.7. OptiMIG 351 DW

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	13.1 kVA
Continuous current:	19 A
Max. current:	22 A
cos phi (350 A):	0.8
cos phi (150 A):	0.82
Secondary:	
Open circuit voltage:	16 - 40 V
Welding voltage:	15 - 32 V
Welding current:	25 - 350 A
Duty cycle 60 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	300 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3 phase
Voltage control:	28 steps 4-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m long
Choke:	100%, option: 60%
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces (option)
Push pull torch:	connector (option)
Weight:	210 kg
Dimensions l x w x h:	990 x 510 x 1135 mm incl. gas bottle holder

Wire feeder: separately mounted, model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	Wire feed speed
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 50 mm² water
Standard wire equipment:	mild steel 1.0 mm
Weight:	18 kg
Dimensions:	610 x 400 x 180 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit OptiMIG 351 DW**					
	A	**MIG/MAG welding unit OptiMIG 351 DW**		**01**	**SET149914**	**5.180,00**
	AB	**MIG/MAG welding unit OptiMIG 351 DW with accessories**		**01**	**SET149916**	**5.260,00**
	ABC1	**MIG/MAG welding unit OptiMIG 351 DW with accessories and hand welding torch SBT 504 W, 3 m**		**01**	**SET149918**	**5.400,00**
	ABC2	**MIG/MAG welding unit OptiMIG 351 DW with accessories and hand welding torch SBT 504 W, 4 m**		**01**	**SET149920**	**5.410,00**
!	**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**					
		Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26		**46**	**01910011**	**480,00**
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.2.8. OptiMIG 451 DW

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	14.5 kVA
Continuous current:	21 A
Max. current:	36 A
cos phi (450 A):	0.8
cos phi (150 A):	0.85
Secondary:	
Open circuit voltage:	17 - 52 V
Welding voltage:	15 - 36.5 V
Welding current:	25 - 450 A
Duty cycle 40 % (10 min.):	450 A (40 °C)
Duty cycle 60 % (10 min.):	420 A (40 °C)
Duty cycle 100 %:	340 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3 phase
Voltage control:	42 steps 6-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Rectifier:	silicon press-in diodes
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m long
Choke:	100%, option: 60%
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces (option)
Push pull torch:	connector (option)
Weight:	220 kg
Dimensions l x w x h:	990 x 510 x 1135 mm incl. gas bottle holder

Wire feeder: separately mounted, model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	Wire feed speed
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions:	610 x 400 x 180 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MIG/MAG welding unit OptiMIG 451 DW**				
	A	**MIG/MAG welding unit OptiMIG 451 DW**		**01**	**SET149922**	**5.320,00**
	AB	**MIG/MAG welding unit OptiMIG 451 DW with accessories**		**01**	**SET149924**	**5.400,00**
	ABC1	**MIG/MAG welding unit OptiMIG 451 DW with accessories and hand welding torch SBT 504 W, 3 m**		**01**	**SET149926**	**5.540,00**
	ABC2	**MIG/MAG welding unit OptiMIG 451 DW with accessories and hand welding torch SBT 504 W, 4 m**		**01**	**SET149928**	**5.550,00**
!		**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**				
		Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26		**46**	**01910011**	**480,00**
B		**Standard accessories:**				
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C		**Welding torches:**				
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

2.2.9. OptiMIG 551 DW

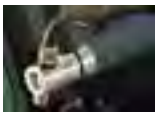
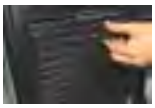
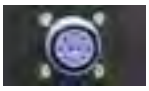
Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Continuous power:	22.8 kVA
Continuous current:	33 A
Max. current:	52 A
cos phi (500 A):	0.8
cos phi (150 A):	0.82
Secondary:	
Open circuit voltage:	18 - 62 V
Welding voltage:	15 - 42 V
Welding current:	25 - 560 A
Duty cycle 40 % (10 min.):	560 A (40 °C)
Duty cycle 60 % (10 min.):	500 A (40 °C)
Duty cycle 100 %:	450 A (40 °C)

Protection class:	IP 23
Insulation:	H
Cooling:	AF
Mains switch:	3-phasig
Voltage control:	42 steps 6-step coarse selector 7-step fine selector
Operation modes:	2-/4-stroke/stitch/spot welding
Wire feed speed:	automatic setting through synergic controller (can be switched off)
Arc trim:	adjustable +/- 30 % at potentiometer or TEDAC torch
Wire selection:	selector switch
Wire burn back:	adjustable
Spot welding/interm. time:	adjustable
Creep start:	adjustable
Safety cut-off:	in 4-stroke operation
Wire insertion auto:	in 2-stroke operation
Functions:	gas test, wire inching
Digital display:	2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function
Control lamp:	mains on, temp. protection, failure
Controller:	MAG 30 plug-in controller at the front panel
Rectifier:	silicon press-in diodes
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Gas bottle holder:	10, 20, 50 l cylinders
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m long
Choke:	100%, option: 60%
Socket 50 mm²:	for earth lead
Lifting eyes:	4 pieces (option
Push pull torch:	connector (option)
Weight:	250 kg
Dimensions l x w x h:	990 x 510 x 1135 mm incl. gas bottle holder

Wire feeder: separately mounted, model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	Wire feed speed
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions:	610 x 400 x 180 mm

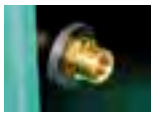
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit OptiMIG 551 DW**					
	A	**MIG/MAG welding unit OptiMIG 551 DW (DV-26)**		**01**	**SET149930**	**6.150,00**
	AB	**MIG/MAG welding unit OptiMIG 551 DW (DV-26) with accessories**		**01**	**SET149932**	**6.250,00**
	ABC1	**MIG/MAG welding unit OptiMIG 551 DW (DV-26) with accessories and hand welding torch SBT 504 W, 3 m**		**01**	**SET149934**	**6.390,00**
	ABC2	**MIG/MAG welding unit OptiMIG 551 DW (DV-26) with accessories and hand welding torch SBT 504 W, 4 m**		**01**	**SET149936**	**6.400,00**
!	**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**					
		Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26		**46**	**01910011**	**480,00**
B	**Standard accessories:**					
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.2.10. Accessories for OptiMIG 351/451/551 DW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.4	Filter frame incl. filter for OptiMIG reduced duty cycle		46	109524	104,00
	1.5	Filter for OptiMIG	10 pcs	46	109528	3,50
	1.6	Metal filter insert for OptiMIG		46	156682	115,00
	1.7	Push-Pull kit incl. sockets and switches		46	02110403	630,00
	1.8	Connection for automated welding welding ON, arc OK, emergency STOP for MAG 30 controller		46	114668	240,00
	1.9	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	1.10	Arc air gouging for OptiMIG 551		46	141538	310,00
	1.11	Price reduction: no integrated water cooling unit (D version)		46	01903611	-485,00
	1.12	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.13	Mains supply 3 x 230/400V, for OptiMIG series		46	114670	230,00
	1.14	Supply voltage 3 x 400/525 V for OptiMIG series		46	111416	440,00
	1.15	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	251,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.16	EN 1090 WPS/WPQR package for series OptiMIG		17	138672	149,00
	1.17	Optional choke socket 60 % for series OptiMIG and CompactMIG		46	144610	83,50
	1.18	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

2 Accessories for wire feeder:

	2.1	Rotatable device for wire feeder including screw set		46	137436	155,00
	2.2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	2.3	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	2.4	Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26		46	01910011	480,00
	2.5	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	2.6	Balancer G3		05	147244	980,00
	2.7	Wheelbase widening set for OptiMIG DW		05	117548	82,00
	2.8	Connection for wire feed liner inside the wire feeder box		38	110454	62,00
	2.9	Wire feeder DV-26 for OptiMIG 351/451/551 DW		38	149922	1.225,00
	2.10	Wire feeder DV-31 für OptiMIG 351/451/551 DW		38	149924	1.600,00

3 Connection cable to wire feeder for OptiMIG 351 and 451 DW:

	3.1	Connection cable 5 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138844	400,00
	3.2	Connection cable 10 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138846	560,00
	3.3	Connection cable 15 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153218	750,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	3.4	Connection cable 20 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153220	940,00
	3.5	Connection cable 30 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	154388	1.320,00
		Price reduction, when not taken:				
	3.6	Connection cable 1.6m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138842	280,00
4		**Connection cable to wire feeder for OptiMIG 551 DW:**				
	4.1	Connection cable 5 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137638	420,00
	4.2	Connection cable 10 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137642	610,00
	4.3	Connection cable 15 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137644	820,00
	4.4	Connection cable 20 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137646	975,00
	4.5	Connection cable 30 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	154386	1.410,00
		Price reduction, when not taken:				
	4.6	Connection cable 1.6m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137634	290,00
5		**Additional wire equipment for DV-26 and DV-31:**				
	5.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	5.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	5.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	63,00
	5.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	5.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	5.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	79,00
	5.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	5.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00
	5.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	83,00
	5.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	78,00
	5.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	78,00

2.3. MIG/MAG welding units continuously controlled

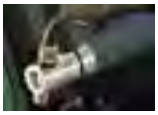
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

2.3.1. MobiMIG 180 K

Primary:	
Power supply:	1 x 230 V
Frequency:	50 / 60 Hz
cos phi:	0.98
MIG/MAG operation:	
Open circuit voltage:	64 V
Welding voltage:	15 - 23 V
Welding current:	25 - 180 A
Duty cycle 20 % (10 min.):	180 A (40 °C)
Duty cycle 60 % (10 min.):	110 A (40 °C)
Duty cycle 100 %:	90 A (40 °C)
Prim. contin. power:	3.7 kVA
Prim. contin. current:	16 A
Prim. max. current:	26 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	synergic operation, automatic energy control
Programs:	MIG/MAG, MMA/stick electrode, TIG DC (LiftTIG), ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, stitch. spot welding
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas
Mains supply cable:	3 x 2.5 mm², 2.5 m long with plug
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	17 kg
Dimensions l x w x h:	450 x 210 x 480 mm

TIG operation:	
Open circuit voltage:	64 V
Welding voltage:	10 - 17.2 V
Welding current:	10 - 180 A
Duty cycle 20 % (10 min.):	180 A (40 °C)
Duty cycle 60 % (10 min.):	110 A (40 °C)
Duty cycle 100 %:	90 A (40 °C)
Prim. contin. power:	2.8 kVA
Prim. contin. current:	12 A
Prim. max. current:	23 A
MMA/stick electrode operation:	
Open circuit voltage:	64 V
Welding voltage:	20.6 - 26.4 V
Welding current:	25 - 160 A
Duty cycle 30 % (10 min.):	150 A (40 °C)
Duty cycle 60 % (10 min.):	90 A (40 °C)
Duty cycle 100 %:	80 A (40 °C)
Prim. contin. power:	3.7 kVA
Prim. contin. current:	16 A
Prim. max. current:	26 A
Wire feeder: compact mounted, Model DV-21	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 20 m/min.
Wire feed system:	2-roller-drive DV-21
Reel hub assembly:	D 200/5
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit MobiMIG 180 K**					
	A	**MIG/MAG welding unit MobiMIG 180 K**		**20**	**SET122354**	**1.848,00**
	AB	**MIG/MAG welding unit MobiMIG 180 K ith accessories**		**20**	**SET122356**	**1.888,00**
	ABC1	**MIG/MAG welding unit MobiMIG 180 K with accessories and TEDAC hand welding torch SBT 157 G, 3 m**		**20**	**SET122358**	**1.968,00**
	ABC2	**MIG/MAG welding unit MobiMIG 180 K with accessories and TEDAC hand welding torch SBT 157 G, 4 m**		**20**	**SET122360**	**1.975,00**
!	**Software ColdMIG included for free (Worth: 630,00 €).**					
B	**Standard accessories:**					
	B1	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	40,50
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 157 G, 3 m**		**06**	**118704**	**197,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 157 G, 4 m**		**06**	**118706**	**204,00**
D	**Accessories:**					
	D1	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/fabric hose assembly		10	133632	270,00
	D2	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/fabric hose assembly		10	129532	350,00
	D3	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D4	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D5	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D6	Adapter for centering of small wire spool		46	133070	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	D8	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Software (for free):

	E1	Software for ColdMIG process for MobiMIG 180 K		17	122352	630,00

F Additional wire equipment for DV-21:

	F1	Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)		46	01200387	41,00
	F2	Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200388	43,00
	F3	Kit for mild steel 1.0 mm (DV-21,20/2) (without contact tips)		46	01200389	43,00
	F4	Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)		46	01200390	58,00
	F5	Kit for stainless steel 1.0 mm (DV-21,20/2) (without contact tips)		46	01200391	58,00
	F6	Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)		46	01200392	58,00

2.3.2. MobiMIG 280 K

Primary:		
Power supply:	3 x 400 V 3 x 220 - 440 V* 1 x 220 - 440 V*	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Data at supply voltage:	**3 x 400 V**	**1 x 230 V***
MIG/MAG operation:		
Open circuit voltage:	90 V	103 V*
Welding voltage:	15 - 28 V	15 - 23 V*
Welding current:	25 - 280 A	25 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 50 % (10 min.):	280 A (20 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	9 kVA	3.7 kVA*
Prim. contin. current:	13 A	16 A*
Prim. max. current:	20 A	26 A*

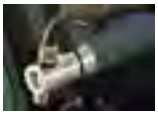
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	synergic operation, automatic energy control
Programs:	MIG/MAG, MMA/stick electrode, TIG DC (LiftTIG), ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, stitch, spot welding
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 400 V / 16 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	27 kg
Dimensions l x w x h:	470 x 255 x 545 mm

*: BiPowerPLUS: Multi voltage supply system:
automatic switching between 1 and 3 phase
in the range 220 – 440 V (option)

Data at supply voltage:	**3 x 400 V**	**1 x 230 V***
TIG operation:		
Open circuit voltage:	90 V	103 V*
Welding voltage:	10 - 21.2 V	10 - 17.2 V*
Welding current:	10 - 280 A	10 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 50 % (10 min.):	280 A (20 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	8.3 kVA	2.8 kVA*
Prim. contin. current:	12 A	12 A*
Prim. max. current:	16 A	23 A*
MMA/stick electrode operation:		
Open circuit voltage:	90 V	103 V*
Welding voltage:	20.6 - 31.2 V	20.6 - 31.2 V
Welding current:	20 - 280 A	25 -160 A*
Duty cycle 35 % (10 min.):	280 A (40 °C)	150 A (20 °C)*
Duty cycle 50 % (10 min.):	250 A (40 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	90 A (40 °C)*
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)*
Prim. contin. power:	8.3 kVA	3.7 kVA*
Prim. contin. current:	14 A	16 A*
Prim. max. current:	21 A	26 A*

Wire feeder: compact mounted, Model DV-26

Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 200/5
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit MobiMIG 280 K**					
	A	**MIG/MAG welding unit MobiMIG 280 K**		**20**	**SET128432**	**3.250,00**
	AB	**MIG/MAG welding unit MobiMIG 280 K with accessories**		**20**	**SET128434**	**3.300,00**
	ABC1	**MIG/MAG welding unit MobiMIG 280 K with accessories and TEDAC hand welding torch SBT 307 G, 3 m**		**20**	**SET128436**	**3.410,00**
	ABC2	**MIG/MAG welding unit MobiMIG 280 K with accessories and TEDAC hand welding torch SBT 307 G, 4 m**		**20**	**SET128438**	**3.440,00**
!	**Software ColdMIG included for free (Worth: 630,00 €).**					
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**
D	**Accessories:**					
	D1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	160,00
	D2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	39,00
	D3a	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/fabric hose assembly		10	133632	270,00
	D3b	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/fabric hose assembly		10	129532	350,00
	D4	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D5a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D5b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D6	Adapter for centering of small wire spool		46	133070	29,00
	D7	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Software (for free):

	E1	Software for ColdMIG process for MobiMIG 280/320/321 K		17	128430	630,00

F Additional wire equipment for DV-26:

	F1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	F2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	F3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	F4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	F5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	F6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.3.3. MobiMIG 321 K

Primary:		
Power supply:	3 x 400 V 3 x 220 - 440 V* 1 x 220 - 440 V*	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Data at supply voltage:	**3 x 400 V**	**1 x 230 V***
MIG/MAG operation:		
Open circuit voltage:	90 V	103 V*
Welding voltage:	15 - 30 V	15 - 23 V*
Welding current:	25 - 320 A	25 - 180 A*
Duty cycle 20 % (10 min.):		180 A (40 °C)*
Duty cycle 30 % (10 min.):	320 A (40 °C)	
Duty cycle 35 % (10 min.):	300 A (40 °C)	
Duty cycle 60 % (10 min.):	260 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	240 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	11.1 kVA	3.7 kVA*
Prim. contin. current:	16 A	16 A*
Prim. max. current:	23 A	26 A*

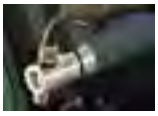
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	synergic operation, automatic energy control
Programs:	MIG/MAG, MMA/stick electrode, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, stitch, spot welding
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, soft start
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas, option: water
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 400 V / 32 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	32 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Data at supply voltage:	**3 x 400 V**	**1 x 230 V***
Option MMA/stick electrode operation:		
Open circuit voltage:	90 V	103 V*
Welding voltage:	20.8 - 32 V	20.8 - 26.4 V*
Welding current:	20 - 300 A	20 -160 A*
Duty cycle 20 % (10 min.):		160 A (40 °C)*
Duty cycle 30 % (10 min.):	300 A (40 °C)	
Duty cycle 60 % (10 min.):	250 A (40 °C)	110 A (40 °C)*
Duty cycle 100 %:	230 A (40 °C)	90 A (40 °C)*
Prim. contin. power:	12.5 kVA	3.7 kVA*
Prim. contin. current:	18 A	16 A*
Prim. max. current:	24 A	26 A*

Wire feeder: compact mounted, Model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 0.8 mm

*: BiPowerPLUS: Multi voltage supply system:
automatic switching between 1 and 3 phase in the range 220 – 440 V
(option, not in combination with socket for water cooler)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit MobiMIG 321 K**					
	A	**MIG/MAG welding unit MobiMIG 321 K**		**01**	**SET156556**	**3.500,00**
	AB	**MIG/MAG welding unit MobiMIG 321 K with accessories**		**01**	**SET156558**	**3.550,00**
	ABC1	**MIG/MAG welding unit MobiMIG 321 K with accessories and TEDAC hand welding torch SBT 307 G, 3 m**		**01**	**SET156560**	**3.660,00**
	ABC2	**MIG/MAG welding unit MobiMIG 321 K with accessories and TEDAC hand welding torch SBT 307 G, 4 m**		**01**	**SET156562**	**3.690,00**
!	**Software ColdMIG included for free (Worth: 630,00 €).**					
	With water cooler and trolley TW 112:					
		MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112		**01**	**SET156564**	**4.890,00**
		MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112 incl. accessories		**01**	**SET156566**	**4.940,00**
		MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112, incl. accessories and TEDAC torch SBT 504 W, 3 m		**01**	**SET156568**	**5.080,00**
		MIG/MAG welding unit MobiMIG 321 K with water cooler WK 300, trolley TW 112, incl. accessories and TEDAC torch SBT 504 W, 4 m		**01**	**SET156570**	**5.090,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**
D	**Accessories:**					
	D1	BiPowerPLUS for MobiMIG 320/321 K not in combination with socket for water cooling unit		46	131446	175,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D2	Adapter: Schuko plug 230 V to CEE connector 32 A/400 V for MobiMIG 320/321 K		46	143244	42,00
	D3	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D4a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D4b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D5	Cover for operation panel for MobiMIG 320/321 K		46	155918	148,00
	D6	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	134,00
	D7	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for water cooler:

	E1	Water cooling unit model WK 300		46	02610143	990,00
	E2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321 K		46	124858	169,00
	E3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	E4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	440,00
	E5	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	450,00
	E6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	425,00
	E7	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	435,00

F Software (for free):

ColdMIG	F1	Software for ColdMIG process for MobiMIG 280/320/321 K		17	128430	630,00

G Additional wire equipment for DV-26:

Pos.	Description	Pu	PrGrp	Part No.	Price/€
G1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
G2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
G3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
G4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
G5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
G6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

2.3.4. SpeedMIG touch 450 KW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, MIG brazing, MMA/stick electrode, DeepARC, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, (stitch, spot welding)
Gas check:	button with hold function and automatic switch off
Button:	Wire inching
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	90 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MIG/MAG welding unit SpeedMIG touch 450 KW**				
	A	**Synergic MIG welding unit SpeedMIG touch 450 KW**		**01**	**SET155612**	**6.045,00**
	AB	**Synergic MIG welding unit SpeedMIG touch 450 KW with accessories**		**01**	**SET155614**	**6.145,00**
	ABC1	**Synergic MIG welding unit SpeedMIG touch 450 KW with accessories and TEDAC torch SBT 504 W, 3 m**		**01**	**SET155616**	**6.285,00**
	ABC2	**Synergic MIG welding unit SpeedMIG touch 450 KW with accessories and TEDAC torch SBT 504 W, 4 m**		**01**	**SET155618**	**6.295,00**
!		**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**				
B		**Standard accessories:**				
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C		**Welding torches:**				
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.3.5. SpeedMIG touch 450 DW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, MIG brazing, MMA/stick electrode, DeepARC, ColdMIG
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, (stitch, spot welding)
Gas check:	button with hold function and automatic switch off
Button:	Wire inching
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	120 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

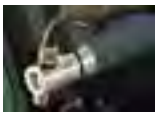
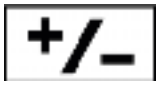
Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

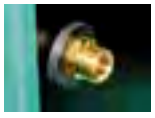
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MIG/MAG welding unit SpeedMIG touch 450 DW**					
	AB	**Synergic MIG welding unit peedMIG touch 450 DW (DV-26)**		**01**	**SET155542**	**6.970,00**
	ABC	Synergic MIG welding unit SpeedMIG touch 450 DW (DV-26) with accessories		01	SET155544	7.070,00
	ABCD1	**Synergic MIG welding unit SpeedMIG touch 450 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m**		**01**	**SET155546**	**7.210,00**
	ABCD2	Synergic MIG welding unit SpeedMIG touch 450 DW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m		01	SET155548	7.220,00
!	**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**					
B	**Wire feeder DV-26:**					
	Wire feeder DV-26 for SpeedMIG touch, incl. control panel			**38**	**155550**	**1.450,00**
!	**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**					
	Option	**Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26**		**46**	**01910011**	**480,00**
C	**Standard accessories:**					
	C1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

2.3.6. Accessories for SpeedMIG touch 450 KW/DW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Connection for remote control incl. socket 10-pol for SpeedMIG touch KW		46	155850	110,00
	1.4	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.5	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	1.6	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.7	Filter 340 x 190 mm for SpeedMIG and HighPULSE touch 400/450 (minimum 10 pieces)	10 pcs	46	155848	3,50
	1.8a	Price reduction: no integrated water cooling unit (K version)		46	111832	-250,00
	1.8b	Price reduction: no integrated water cooling unit (D version)		46	01903611	-485,00
	1.9	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.10	Polarity change for series SpeedMIG touch		46	155880	305,00
	1.11	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	251,00
	1.12a	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	440,00
	1.12b	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	450,00
	1.13a	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		25	154244	525,00
	1.13b	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		25	154248	535,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.14	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

2 Accessories for wire feeder:

	2.1	Rotatable device for wire feeder including screw set		46	137436	155,00
	2.2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	2.3a	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137546	152,00
	2.3b	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137547	132,00
	2.4	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	2.5	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	2.6	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	2.7	Connection for wire feed liner inside the wire feeder box		38	110454	62,00
	2.8	Wire feeder DV-26 for SpeedMIG touch, incl. control panel		38	155550	1.450,00

3 Connection cable for controller in wire feeder:

	3.1	Connection cable 5 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138518	510,00
	3.2	Connection cable 10 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138520	750,00
	3.3	Connection cable 15 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138522	970,00
	3.4	Connection cable 20 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138524	1.200,00
	3.5	Connection cable 30 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 incl. control cable for controller in wire feeder		38	145740	1.700,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Price reduction, when not taken:						
	3.6	Connection cable 1.6 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138516	360,00
4 Software (for free):						
DeepARC	4.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	4.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
5 Software:						
	5.1	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
6 Automation accessories:						
	6.1	Connection automated welding SpeedMIG touch emerg. STOP, welding ON, arc OK - socket 6 pol.		46	155852	285,00
	6.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
7 Additional wire equipment for DV-26 and DV-31:						
	7.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	7.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	7.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	63,00
	7.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	7.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	7.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	79,00
	7.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	7.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00
	7.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	83,00
	7.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	78,00
	7.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	78,00
	7.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	219,00
	7.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	219,00
	7.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	219,00

3. Synergic Pulse welding units

3.1 Synergic Pulse welding units with touch control
HighPULSE touch 280/350 K
HighPULSE touch 400/450 KW
HighPULSE touch 400/450 DW

3.2 Synergic Pulse welding units
HighPULSE 284/354/353 K
HighPULSE 454/554 KW
HighPULSE 354/454/554 DW

3.3 Synergic Pulse welding units for automation and robotics
HighPULSE 352/452/552 RS

3.1. Synergic Pulse welding units - Series HighPULSE touch

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.1. HighPULSE touch 280 K

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Synergic pulse / MIG operation:		
Open circuit voltage:	57 V	
Welding voltage:	15 - 28 V	
Welding current:	25 - 280 A	
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	280 A (20 °C)
Duty cycle 100 %:	200 A (40 °C)	230 A (20 °C)
Prim. contin. power:	11.1 kVA	
Prim. contin. current:	16 A	
Prim. max. current:	19 A	

Optional: with water cooling unit WK 301 and trolley TW 112, with drawer as an option.

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch,
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Control:	via touch display and/or rotary encorder with push button
Rotary encorder:	energy, arc length
Job mode:	2000 jobs programmable
Cover:	transparent, to protect the control panel
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas (option: water)
Socket water cooling unit:	6 pol.
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 3 x 400 V / 16 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	33 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Option MMA/stick electrode operation:	
Open circuit voltage:	57 V
Welding voltage:	20 - 31.2 V
Welding current:	20 - 280 A
Duty cycle 35 % (10 min.):	280 A (40 °C)
Duty cycle 100 %:	200 A (40 °C)
Prim. contin. power:	11.7 kVA
Prim. contin. current:	17 A
Prim. max. current:	21 A

Wire feeder: compact mounted, Model DV-26	
Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Portable Synergic Pulse welding unit HighPULSE touch 280 K**					
	A	**Synergic Pulse welding unit HighPULSE touch 280 K**		**30**	**SET158500**	**5.380,00**
	AB	**Synergic Pulse welding unit HighPULSE touch 280 K with accessories**		**30**	**SET158502**	**5.450,00**
	ABC1	**Synergic Pulse welding unit HighPULSE touch 280 K with accessories and TEDAC torch SBT 307 G, 3 m**		**30**	**SET158504**	**5.560,00**
	ABC2	**Synergic Pulse welding unit HighPULSE touch 280 K with accessories and TEDAC torch SBT 307 G, 4 m**		**30**	**SET158506**	**5.590,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.2. HighPULSE touch 350 K

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Synergic pulse / MIG operation:		
Open circuit voltage:	57 V	
Welding voltage:	15 - 31.5 V	
Welding current:	25 - 350 A	
Duty cycle 40 % (10 min.):	350 A (40 °C)	
Duty cycle 60 % (10 min.):	280 A (40 °C)	330 A (20 °C)
Duty cycle 100 %:	250 A (40 °C)	280 A (20 °C)
Prim. contin. power:	12.5 kVA	
Prim. contin. current:	18 A	
Prim. max. current:	25 A	

Optional: with water cooling unit WK 301 and trolley TW 112, with drawer as an option.

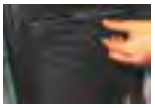
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch,
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Control:	via touch display and/or rotary encorder with push button
Rotary encorder:	energy, arc length
Job mode:	2000 Jobs programmable
Cover:	transparent, to protect the control panel
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas (option: water)
Socket water cooling unit:	6 pol.
Mains supply cable:	4 x 2,5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	36.5 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Option MMA/stick electrode operation:	
Open circuit voltage:	57 V
Welding voltage:	20 - 34 V
Welding current:	20 - 350 A
Duty cycle 40 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)
Prim. contin. power:	13.1 kVA
Prim. contin. current:	19 A
Prim. max. current:	27 A

Wire feeder: compact mounted, Model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Portable Synergic Pulse welding unit HighPULSE touch 350 K**					
	A	**Synergic Pulse welding unit HighPULSE touch 350 K**		**30**	**SET158520**	**5.840,00**
	AB	**Synergic Pulse welding unit HighPULSE touch 350 K with accessories**		**30**	**SET158522**	**5.910,00**
	ABC1	**Synergic Pulse welding unit HighPULSE touch 350 K with accessories and TEDAC torch SBT 307 G, 3 m**		**30**	**SET158524**	**6.020,00**
	ABC2	**Synergic Pulse welding unit HighPULSE touch 350 K with accessories and TEDAC torch SBT 307 G, 4 m**		**30**	**SET158526**	**6.050,00**
	With water cooler and trolley TW 112:					
		Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 301, trolley TW 112		**30**	**SET158620**	**7.080,00**
		Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 301, trolley TW 112, accessories		**30**	**SET158622**	**7.150,00**
		Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 301, trolley TW 112, accessories and TEDAC torch SBT 504 W, 3 m		**30**	**SET158624**	**7.290,00**
		Synergic Pulse welding unit HighPULSE touch 350 K incl. water cooler WK 301, trolley TW 112, accessories and TEDAC torch SBT 504 W, 4 m		**30**	**SET158626**	**7.300,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**

3.1.3. Accessories for HighPULSE 284/354 K

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	1.3b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	1.4	Push-Pull kit incl. socket 10-pol and switches for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107706	640,00
	1.5	Connection for remote control incl. socket for HighPULSE, SpeedMIG, OptiMIG in K version		46	155486	54,00
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.7	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	1.8	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	1.9	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	134,00
	1.10	Filter frame incl. filter for HighPULSE 282, 284, 352, 354 K and HighPULSE touch 280/350 K reduced duty cycle		46	108424	99,00
	1.11	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	3,50
	1.12	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	110,00
	1.13	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
2	**Accessories for water cooler:**					
	3.1	Water cooling unit model WK 301		46	158990	990,00
	3.2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	3.3	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	440,00
	3.4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	450,00
	3.5	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	425,00
	3.6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	435,00
3	**Software (for free):**					
DeepARC	5.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	5.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	5.3	Software for HighUP process for series HighPULSE		17	134392	880,00
4	**Software:**					
	6.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00
	6.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	6.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
5	**Automation accessories:**					
	7.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	7.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

6 Additional wire equipment for DV-26:

Pos.	Description	Pu	PrGrp	Part No.	Price/€
8.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
8.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
8.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
8.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
8.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
8.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

3.1.4. Water cooling unit WK 301

Power supply:	230 V
Frequency:	50 / 60 Hz
Mains current:	1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
Electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Water cooling unit:**					
	A	Water cooling unit model WK 301		46	158990	990,00
B	**Accessories:**					
	B1	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	57,00
	B2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.5. HighPULSE touch 400 KW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	25 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 34 V
Welding current:	20 - 400 A
Duty cycle 80 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	90 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE touch 400 KW**					
	A	**Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26)**		**30**	**SET158720**	**6.960,00**
	AB	**Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories**		**30**	**SET158722**	**7.040,00**
	ABC1	**Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m**		**30**	**SET158724**	**7.180,00**
	ABC2	**Synergic MIG Pulse welding unit HighPULSE touch 400 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m**		**30**	**SET158726**	**7.190,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**					
B	**Standard accessories:**					
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

3.1.6. HighPULSE touch 450 KW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG blazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	90 kg
Dimensions l x w x h:	1210 x 430 x 880 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE touch 450 KW**					
	A	**Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26)**		**30**	**SET158994**	**7.530,00**
	AB	**Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access.**		**30**	**SET158996**	**7.630,00**
	ABC1	**Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET158998**	**7.770,00**
	ABC2	**Synergic MIG Pulse welding unit HighPULSE touch 450 KW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET159000**	**7.780,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**					
B	**Standard accessories:**					
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.7. Accessories for HighPULSE touch 400/450 KW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG KW		46	138290	625,00
	1.4	Connection for remote control incl. socket for HP, SM in KW version		46	155484	54,00
	1.5	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.6	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	1.7	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.8	Filter 340 x 190 mm for SpeedMIG and HighPULSE touch 400/450 (minimum 10 pieces)	10 pcs	46	155848	3,50
	1.9	Price reduction: no integrated water cooling unit (K version)		46	111832	-250,00
	1.10	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.11a	Cover WITH lock, transparent, for power source HighPULSE touch, SpeedMIG touch Version KW und DW		46	158746	130,00
	1.11b	Cover WITHOUT lock, transparent, for power source HighPULSE touch, SpeedMIG touch Version KW und DW		46	159398	120,00
	1.12	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
2 Software (for free):						
DeepARC	3.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	3.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	3.3	Software for HighUP process for series HighPULSE		17	134392	880,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
3 Software:						
	4.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00
	4.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	4.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
	4.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
4 Automation accessories:						
	6.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	6.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
		Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
		Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00
5 Additional wire equipment for DV-26:						
		Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
		Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
		Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
		Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
		Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
		Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.8. HighPULSE touch 400 DW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	25 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 34 V
Welding current:	20 - 400 A
Duty cycle 80 % (10 min.):	400 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	120 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE touch 400 DW**					
	AB	**Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26)**		**30**	**SET158986**	**7.910,00**
	ABC	**Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access.**		**30**	**SET158988**	**7.990,00**
	ABCD1	**Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET158990**	**8.130,00**
	ABCD2	**Synergic MIG Pulse welding unit HighPULSE touch 400 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET158992**	**8.140,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**					
B	**Wire feeder DV-26:**					
		Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG		**38**	**137652**	**1.225,00**
!	**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**					
	Option	**Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26**		**46**	**01910011**	**480,00**
C	**Standard accessories:**					
	C1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.1.9. HighPULSE touch 450 DW

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	13.8 kVA
Contin. current:	20 A
Max. current:	28 A
cos phi:	0.96
Secondary:	
Open circuit voltage:	67 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 60 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	360 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Arc length:	automatic energy control
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Wire inching:	button and wire inching automatic
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the wire feeder, at the TEDAC torch
Adjustable parameters:	choke inductance, wire burn back, pulse shape
Job-mode:	2000 jobs programmable
Control:	via touch display and/or rotary encoder with push button
Rotary encoder:	energy, arc length
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	120 kg (incl. wire feeder)
Dimensions l x w x h:	1210 x 430 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

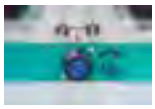
Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE touch 450 DW**					
	AB	**Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26)**		**30**	**SET158710**	**8.480,00**
	ABC	**Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access.**		**30**	**SET158712**	**8.580,00**
	ABCD1	**Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET158714**	**8.720,00**
	ABCD2	**Synergic MIG Pulse welding unit HighPULSE touch 450 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET158716**	**8.730,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (Worth: 2.640,00 €).**					
B	**Wire feeder DV-26:**					
		Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG		**38**	**137652**	**1.225,00**
!	**Max. 1.2 mm wire with wire feeder DV-26. Use option DV-31 for wire > 1.2 mm:**					
	Option	**Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26**		**46**	**01910011**	**480,00**
C	**Standard accessories:**					
	C1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

3.1.10. Accessories for HighPULSE touch 400/450 DW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG DW		46	138286	645,00
	1.4	Connection for remote control incl. switch and socket for HighPULSE, SpeedMIG, OptiMIG in DW version		46	02110427	60,00
	1.5	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.6	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	1.7	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.8	Filter 340 x 190 mm for SpeedMIG and HighPULSE touch 400/450 (minimum 10 pieces)	10 pcs	46	155848	3,50
	1.9	Price reduction: no integrated water cooling unit (D version)		46	01903611	-485,00
	1.10	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.11a	Cover WITH lock, transparent, for power source HighPULSE touch, SpeedMIG touch Version KW und DW		46	158746	130,00
	1.11b	Cover WITHOUT lock, transparent, for power source HighPULSE touch, SpeedMIG touch Version KW und DW		46	159398	120,00
	1.12	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
2 Accessories for wire feeder:						
	2.1	Rotatable device for wire feeder including screw set		46	137436	155,00

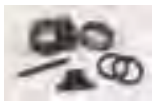
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	2.2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	2.3	Standard operation panel inside wire feeder for series HighPULSE, HighPULSE touch and SpeedMIG (only with special interconnection cable)		46	138526	140,00
	2.4	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137547	132,00
	2.5	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137546	152,00
	2.6	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	2.7	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	2.8	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	2.9	Balancer G3		05	147244	980,00
	2.10	Wider trolly for mounting for HighPULSE touch, SpeedMIG touch DW		05	160188	73,00
	2.11	Connection for wire feed liner inside the wire feeder box		38	110454	62,00
	2.12	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG		38	137652	1.225,00
	2.13	Wire feeder DV-31 for HighPULSE, HighPULSE touch, SpeedMIG		38	137650	1.600,00

3 Connection cable to wire feeder for controller in machine:

	3.1	Connection cable 5 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138844	400,00
	3.2	Connection cable 10 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138846	560,00
	3.3	Connection cable 15 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153218	750,00
	3.4	Connection cable 20 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153220	940,00
	3.5	Connection cable 30 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	154388	1.320,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
4	**Price reduction, when not taken:**					
	3.6	Connection cable 1.6m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138842	280,00
5	**Connection cable for controller in wire feeder:**					
	5.1	Connection cable 1.6 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138516	360,00
	5.2	Connection cable 5 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138518	510,00
	5.3	Connection cable 10 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138520	750,00
	5.4	Connection cable 15 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138522	970,00
	5.5	Connection cable 20 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138524	1.200,00
	5.6	Connection cable 30 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 incl. control cable for controller in wire feeder		38	145740	1.700,00
6	**Software (for free):**					
DeepARC	7.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	7.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	7.3	Software for HighUP process for series HighPULSE		17	134392	880,00
7	**Software:**					
	8.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00
	8.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	8.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
	8.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
8	**Automation accessories:**					
	10.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	10.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	10.3	Bus connection (Profibus, DeviceNet, CANopen, interbus, etc.) for HighPULSE, SpeedMIG		17	113834	1.635,00
	10.4	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	10.5	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
	10.6	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
9	**Additional wire equipment for DV-26 and DV-31:**					
	11.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	11.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	11.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	63,00
	11.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	11.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	11.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	79,00
	11.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	11.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00
	11.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	83,00
	11.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	78,00
	11.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	78,00
	11.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	219,00
	11.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	219,00
	11.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	219,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2. Synergic Pulse welding units for hand welding

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.1. HighPULSE 284 K

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98

Synergic pulse / MIG operation:

Open circuit voltage:	57 V	
Welding voltage:	15 - 28 V	
Welding current:	25 - 280 A	
Duty cycle 35 % (10 min.):	280 A (40 °C)	
Duty cycle 60 % (10 min.):	240 A (40 °C)	280 A (20 °C)
Duty cycle 100 %:	200 A (40 °C)	230 A (20 °C)
Prim. contin. power:	11.1 kVA	
Prim. contin. current:	16 A	
Prim. max. current:	19 A	

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	256 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, TIG DC, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, stitch, spot welding
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	Mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape
Automated functions:	wire burn back, soft start (programmable)
Job mode:	2000 jobs programmable
Cover:	transparent, to protect the control panel
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas (option: water)
Socket water cooling unit:	6 pol.
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 3 x 400 V / 16 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	33 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Option TIG operation:

Open circuit voltage:	57 V
Welding voltage:	10 - 21.2 V
Welding current:	10 - 280 A
Duty cycle 35 (10 min.):	280 A (40 °C)
Duty cycle 60 (10 min.):	240 A (40 °C)
Duty cycle 100 %:	200 A (40 °C)
Prim. contin. power:	9.7 kVA
Prim. contin. current:	14 A
Prim. max. current:	18 A

Option MMA/stick electrode operation:

Open circuit voltage:	57 V
Welding voltage:	20 - 31.2 V
Welding current:	20 - 280 A
Duty cycle 35 % (10 min.):	280 A (40 °C)
Duty cycle 100 %:	200 A (40 °C)
Prim. contin. power:	11.7 kVA
Prim. contin. current:	17 A
Prim. max. current:	21 A

Wire feeder: compact mounted, Model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 1.0 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Portable Synergic Pulse welding unit HighPULSE 284 K**					
	A	**Synergic Pulse welding unit HighPULSE 284 K**		**30**	**SET154134**	**5.680,00**
	AB	**Synergic Pulse welding unit HighPULSE 284 K with accessories**		**30**	**SET154136**	**5.750,00**
	ABC1	**Synergic Pulse welding unit HighPULSE 284 K with accessories and TEDAC torch SBT 307 G, 3 m**		**30**	**SET154138**	**5.860,00**
	ABC2	**Synergic Pulse welding unit HighPULSE 284 K with accessories and TEDAC torch SBT 307 G, 4 m**		**30**	**SET154140**	**5.890,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.2. HighPULSE 354 K

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Synergic pulse / MIG operation:		
Open circuit voltage:	57 V	
Welding voltage:	15 - 31.5 V	
Welding current:	25 - 350 A	
Duty cycle 40 % (10 min.):	350 A (40 °C)	
Duty cycle 60 % (10 min.):	280 A (40 °C)	330 A (20 °C)
Duty cycle 100 %:	250 A (40 °C)	280 A (20 °C)
Prim. contin. power:	12.5 kVA	
Prim. contin. current:	18 A	
Prim. max. current:	25 A	

Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.

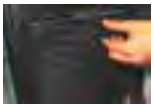
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	256 programs
Schweißverfahren:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, TIG DC, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, stitch, spot welding
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	Mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape
Automated functions:	wire burn back, soft start (programmable)
Job mode:	2000 Jobs programmable
Cover:	transparent, to protect the control panel
Power source:	inverter
Sockets 50 mm²:	earth lead and electrode cable
Torch cooling:	gas (option: water)
Socket water cooling unit:	6 pol.
Mains supply cable:	4 x 2,5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Handle:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	36.5 kg
Dimensions l x w x h:	600 x 300 x 565 mm

Option TIG operation:	
Open circuit voltage:	57 V
Welding voltage:	10 - 24 V
Welding current:	10 - 350 A
Duty cycle 40 % (10 min.):	350 A (40 °C)
Duty cycle 60 % (10 min.):	280 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)
Prim. contin. power:	11.1 kVA
Prim. contin. current:	16 A
Prim. max. current:	23 A
Option MMA/stick electrode operation:	
Open circuit voltage:	57 V
Welding voltage:	20 - 34 V
Welding current:	20 - 350 A
Duty cycle 40 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)
Prim. contin. power:	13.1 kVA
Prim. contin. current:	19 A
Prim. max. current:	27 A
Wire feeder: compact mounted, Model DV-26	
Supply:	26 V-DC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Portable Synergic Pulse welding unit HighPULSE 354 K**					
	A	**Synergic Pulse welding unit HighPULSE 354 K**		**30**	**SET154142**	**6.140,00**
	AB	**Synergic Pulse welding unit HighPULSE 354 K with accessories**		**30**	**SET154144**	**6.210,00**
	ABC1	**Synergic Pulse welding unit HighPULSE 354 K with accessories and TEDAC torch SBT 307 G, 3 m**		**30**	**SET154146**	**6.320,00**
	ABC2	**Synergic Pulse welding unit HighPULSE 354 K with accessories and TEDAC torch SBT 307 G, 4 m**		**30**	**SET154148**	**6.350,00**
	With water cooler and trolley TW 112:					
		Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112		**30**	**SET154150**	**7.460,00**
		Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories		**30**	**SET154152**	**7.530,00**
		Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 3 m		**30**	**SET154154**	**7.670,00**
		Synergic Pulse welding unit HighPULSE 354 K incl. water cooler WK 300, trolley TW 112, accessories and TEDAC torch SBT 504 W, 4 m		**30**	**SET154156**	**7.680,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	C2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.3. Accessories for HighPULSE 284 and 354 K

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	1.3b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	1.4	Push-Pull kit incl. socket 10-pol and switches for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107706	640,00
	1.5	Connection for remote control incl. socket for HighPULSE, SpeedMIG, OptiMIG in K version		46	155486	54,00
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.7	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	1.8	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	1.9	Suspension device, electrically isolated for HighPULSE 28x/35x K and HighPULSE touch 280/350 K		46	107540	134,00
	1.10	Filter frame incl. filter for HighPULSE 282, 284, 352, 354 K and HighPULSE touch 280/350 K reduced duty cycle		46	108424	99,00
	1.11	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	3,50
	1.12	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	110,00
	1.13	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
2	**Accessories for TIG operation:**					
	2.1a	TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/fabric hose assembly		10	133632	270,00
	2.1b	TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/fabric hose assembly		10	129532	350,00
	2.2	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/fabric hose assembly		10	145092	440,00
3	**Accessories for water cooler:**					
	3.1	Water cooling unit model WK 300		46	02610143	990,00
	3.2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	3.3	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	440,00
	3.4	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	450,00
	3.5	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	425,00
	3.6	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	435,00
4	**Interface power source <-> computer:**					
	4.1	Ethernet interface for HighPULSE		17	126506	1.245,00
	4.2	Option Wifi equipment		17	144106	145,00
5	**Software (for free):**					
DeepARC	5.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	5.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	5.3	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	5.4	Software for Interpulse process for series HighPULSE		17	120490	280,00
6	**Software:**					
	6.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	6.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	6.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
7	**Robot and automation accessories:**					
	7.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	7.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	7.3	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
	7.4	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
8	**Additional wire equipment for DV-26:**					
	8.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	8.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	8.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	8.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	8.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	8.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

3.2.4. Water cooling unit WK 300

Power supply:	1 x 400 V / 230 V
Frequency:	50 / 60 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Water cooling unit:**					
	A	**Water cooling unit model WK 300**		**46**	**02610143**	**990,00**
B	**Accessories:**					
	B1	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	57,00
	B2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.5. HighPULSE 353 K

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
Synergic pulse/MIG operation:		
Open circuit voltage:	57 V	
Welding voltage:	15 - 31.5 V	
Welding current:	25 - 350 A	
Duty cycle 40 % (10 min.):	350 A (40 °C)	
Duty cycle 60 % (10 min.):	280 A (40 °C)	330 A (20 °C)
Duty cycle 100 %:	250 A (40 °C)	280 A (20 °C)
Prim. contin. power:	12.5 kVA	
Prim. contin. current:	18 A	
Prim. max. current:	25 A	

Protection class:	IP 20
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, InterPULSE, DeepARC, ColdMIG, HighUP
Adjustable parameters:	choke inductance, pulse shape wire burn back
Automated functions:	soft start (programmable)
Power source:	inverter
Socket 50 mm²:	earth lead
Torch cooling:	gas
Mains supply cable:	4 x 4 mm², 5 m long with plug 3 x 400 V / 32 A
Gas hose:	2 m
Suspension device:	on top of the machine
Norm:	EN 60974-1 "S" / CE
Weight:	49.6 kg
Dimensions l x w x h:	720 x 170 x 630 mm

With JOB operation panel:

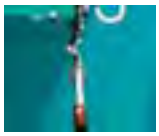
Job mode:	4 Jobs, selectable at the TEDAC torch
Potentiometer:	trim (arc length or wire feed speed)
Job display:	4 big display modules
Buttons:	gas check and wire inching
Socket:	connection of external operation panel

With standard operation panel:

Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current, stitch, spot welding
LEDs:	Mains, failure, temp. protection, hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
Job mode:	999 jobs programmable
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Potentiometers:	energy and arc trim
Buttons:	gas check and wire inching

Wire feeder compact mounted: Model DV-26

Supply:	26 V-DC / 42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Wire feed system:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**With standard operation panel:**					
	A	**Synergic MIG Pulse welding unit HighPULSE 353 K, slim version incl. standard operation panel**		**30**	**SET131919**	**6.330,00**
B	**With JOB operation panel:**					
	B	**Synergic MIG Pulse welding unit HighPULSE 353 K, slim version incl. operation panel with 4 jobs**		**30**	**SET131918**	**6.330,00**
C	**Accessories:**					
	C1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
	C3	Adapter for wire spool		46	02900104	19,50
	C4	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	C5	Torch holder for HighPULSE 351/353 K bent, for SB/SBT torches		46	129972	68,00
	C6	Torch holder for HighPULSE 351/353 K bent, for RSB/T torches		46	129976	69,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m**		**06**	**02210858**	**243,00**
	D2	**MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m**		**06**	**02210859**	**273,00**
	D3	**MIG/MAG hand welding torch TEDAC, model SBT 351 G, 3 m**		**06**	**112938**	**253,00**
	D4	**MIG/MAG hand welding torch TEDAC, model SBT 351 G, 4 m**		**06**	**112940**	**283,00**
	D5	**Fume extraction torch TEDAC, model RSBT 351 G, 3 m**		**11**	**129276**	**520,00**
	D6	**Fume extraction torch TEDAC, model RSBT 351 G, 4 m**		**11**	**129278**	**555,00**

3.2.6. HighPULSE 454 KW

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	15.9 kVA	
Contin. current:	23 A	
Max. current:	34 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	72 V	
Welding voltage:	15 - 36.5 V	
Welding current:	20 - 450 A	
Duty cycle 50 % (10 min.):		450 A (40 °C)
Duty cycle 60 % (10 min.):	450 A (25 °C)	400 A (40 °C)
Duty cycle 100 %:	400 A (25 °C)	330 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Weight:	115 kg
Dimensions l x w x h:	1100 x 490 x 895 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive
	0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE 454 KW**					
	A	**Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26)**		**30**	**SET154198**	**8.710,00**
	AB	**Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories**		**30**	**SET154200**	**8.810,00**
	ABC1	**Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154202**	**8.950,00**
	ABC2	**Synergic MIG Pulse welding unit HighPULSE 454 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154204**	**8.960,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

3.2.7. HighPULSE 554 KW

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	19.4 kVA	
Contin. current:	28 A	
Max. current:	45 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	72 V	
Welding voltage:	15 - 41.5 V	
Welding current:	20 - 550 A	
Duty cycle 40 % (10 min.):		550 A (40 °C)
Duty cycle 50 % (10 min.):		500 A (40 °C)
Duty cycle 60 % (10 min.):	550 A (20 °C)	470 A (40 °C)
Duty cycle 100 %:	500 A (20 °C)	420 A (40 °C)

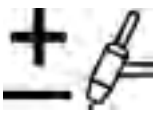
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, pulse shape, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Weight:	120 kg
Dimensions l x w x h:	1100 x 490 x 895 mm

Wire feeder: integrated, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Standard wire equipment:	mild steel 1.2 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE 554 KW**					
	A	**Synergic MIG Pulse welding unit HighPULSE 552 KW (DV-26)**		**30**	**SET135792**	**8.980,00**
	AB	**Synergic MIG Pulse welding unit HighPULSE 552 KW (DV-26) with accessories**		**30**	**SET135794**	**9.080,00**
	ABC1	**Synergic MIG Pulse welding unit HighPULSE 552 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 3 m**		**30**	**SET135796**	**9.220,00**
	ABC2	**Synergic MIG Pulse welding unit HighPULSE 552 KW (DV-26) with accessories and TEDAC torch SBT 504 W, 4 m**		**30**	**SET135798**	**9.230,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Standard accessories:**					
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

3.2.8. Accessories for HighPULSE 454/554 KW

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG KW		46	138290	625,00
	1.4	Connection for remote control incl. socket for HP, SM in KW version		46	155484	54,00
	1.5	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.6	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	1.7	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.8a	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	3,50
	1.8b	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	110,00
	1.9	Price reduction: no integrated water cooling unit (K version)		46	111832	-250,00
	1.10	Polarity change and TIG (DC) welding for series HighPULSE and SpeedMIG version DW (LiftTIG), MAG torch connector		46	138276	305,00
	1.11	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/fabric hose assembly		10	145092	440,00
	1.12	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	1.13a	MAG Remote Control MRC-50 for HighPULSE und SpeedMIG in steel casing with handgrip and magnet, incl. 5 m supply cable		46	154578	885,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.13b	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	1.13c	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	1.13d	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
	1.14	Cover with lock, transparent, for power source HighPULSE, SpeedMIG and HighTIG version KW and DW		46	138238	142,00
	1.15	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	251,00
	1.16	Front panel for 4 jobs incl. trim potentiometer and buttons for gas test and wire inching for series HighPULSE when not using standard operation panel		46	137158	1.480,00
	1.17	Front panel MC-40 for series HighPULSE 8 job version with digital displays and rotary switches incl. digital process controller ME-MTC32 when not using standard operation panel		46	145766	1.480,00
TEDAC® DIGITAL	1.18a	Option torch with TEDAC DIGITAL system when not using standard TEDAC torch for HighPULSE and SpeedMIG		25	155840	100,00
	1.18b	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		25	154244	525,00
	1.18c	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		25	154248	535,00
	1.19	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

2 Interface power source <-> computer:

	2.1	Ethernet interface for HighPULSE		17	126506	1.245,00
	2.2	Option Wifi equipment		17	144106	145,00

3 Software (for free):

DeepARC	3.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	3.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	3.3	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	3.4	Software for Interpulse process for series HighPULSE		17	120490	280,00

4 Software:

	4.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	4.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	4.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
	4.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00

5 WeldFACTORY:
control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)

6 Automation accessories:

	7.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	7.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	7.3	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
	7.4	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00

7 Additional wire equipment for DV-26:

	8.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
	8.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
	8.3	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
	8.4	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
	8.5	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
	8.6	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.9. HighPULSE 354 DW

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	14.5 kVA	
Contin. current:	21 A	
Max. current:	25 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	57 V	
Welding voltage:	15 - 31.5 V	
Welding current:	25 - 350 A	
Duty cycle 50 % (10 min.):		350 A (40 °C)
Duty cycle 60 % (10 min.):	350 A (20 °C)	330 A (40 °C)
Duty cycle 100 %:	300 A (20 °C)	280 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	256 programs
Programs:	MIG/MAG, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 4,0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	130 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE 354 DW**					
	A	Synergic MIG Pulse welding unit HighPULSE 354 DW (power source) without wire feeder		30	154138	7.390,00
	With DV-26 wire feeder:					
	AB	**Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26)**		**30**	**SET154158**	**8.650,00**
	ABC	**Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access.**		**30**	**SET154160**	**8.730,00**
	ABCD1	**Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154162**	**8.870,00**
	ABCD2	**Synergic MIG Pulse welding unit HighPULSE 354 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154164**	**8.880,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Wire feeder DV-26:**					
	B	**Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG**		**38**	**137652**	**1.225,00**
C	**Standard accessories:**					
	C1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**
!	**Option DV-31:**					
		Option for wire feeder DV-31 0.5 - 30 m/min. incl. wire straightener and tacho motor when not using DV-26		**46**	**01910011**	**480,00**

3.2.10. HighPULSE 454 DW

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	15.9 kVA	
Contin. current:	23 A	
Max. current:	34 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	72 V	
Welding voltage:	15 - 36.5 V	
Welding current:	20 - 450 A	
Duty cycle 50 % (10 min.):		450 A (40 °C)
Duty cycle 60 % (10 min.):	450 A (20 °C)	400 A (40 °C)
Duty cycle 100 %:	400 A (20 °C)	330 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA/stick electrode, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6,0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	140 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply:	42 V-DC/42 V-AC
Wire feed motor:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Wire feed support:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 70 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE 454 DW**					
	A	Synergic MIG Pulse welding unit HighPULSE 454 DW (power source) without wire feeder		30	154142	8.370,00
	With DV-26 wire feeder:					
	AB1	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26)**		**30**	**SET154166**	**9.740,00**
	AB1C	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access.**		**30**	**SET154168**	**9.840,00**
	AB1CD1	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154170**	**9.980,00**
	AB1CD2	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154172**	**9.990,00**
	With DV-31 wire feeder:					
	AB2	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31)**		**30**	**SET154174**	**10.220,00**
	AB2C	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access.**		**30**	**SET154176**	**10.320,00**
	AB2CD1	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154178**	**10.460,00**
	AB2CD2	**Synergic MIG Pulse welding unit HighPULSE 454 DW (DV-31) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154180**	**10.470,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Wire feeder:**					
	B1	**Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG**		**38**	**137652**	**1.225,00**
	B2	**Wire feeder DV-31 for HighPULSE, HighPULSE touch, SpeedMIG**		**38**	**137650**	**1.600,00**
C	**Standard accessories:**					
	C1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.11. HighPULSE 554 DW

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	19.4 kVA	
Contin. current:	28 A	
Max. current:	45 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	72 V	
Welding voltage:	15 - 41.5 V	
Welding current:	20 - 550 A	
Duty cycle 40 % (10 min.):		550 A (40 °C)
Duty cycle 50 % (10 min.):		500 A (40 °C)
Duty cycle 60 % (10 min.):	550 A (20 °C)	470 A (40 °C)
Duty cycle 100 %:	500 A (20 °C)	420 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974 -1 "S" / CE
Weight:	145 kg (incl. wire feeder)
Dimensions l x w x h:	1100 x 490 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-26

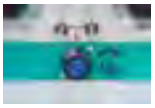
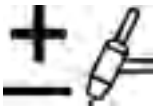
Supply:	26 V-DC/42 V-AC
Wire feed motor:	DC motor with worm gear drive 0.5 - 25 m/min.
Gear:	4-roller-drive DV-26
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	Euro connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	18 kg
Dimensions l x w x h:	610 x 410 x 195 mm

Wire feeder: separately mounted, model DV-31

Supply voltage:	42 V-DC/42 V-AC
Wire feed:	4-roller drive 0.5 - 30 m/min. with wire straightener and tacho motor
Potentiometer:	energy
Potentiometer:	arc length (voltage trim)
Button:	wire inching
Reel hub assembly:	D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Standard wire equipment:	mild steel 1.2 mm
Weight:	21 kg
Dimensions l x w x h:	610 x 410 x 195 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding unit HighPULSE 554 DW**					
	A	Synergic MIG Pulse welding unit HighPULSE 554 DW (power source) without wire feeder		30	154152	8.870,00
	With DV-26 wire feeder:					
	AB1	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26)**		**30**	**SET154182**	**10.000,00**
	AB1C	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26) with access.**		**30**	**SET154184**	**10.100,00**
	AB1CD1	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-26) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154186**	**10.240,00**
	AB1CD2	**Synergic MIG PULSE welding unit HighPULSE 554 DW (DV-26) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154188**	**10.250,00**
	With DV-31 wire feeder:					
	AB2	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31)**		**30**	**SET154190**	**10.480,00**
	AB2C	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31) with access.**		**30**	**SET154192**	**10.580,00**
	AB2CD1	**Synergic MIG Pulse welding unit HighPULSE 554 DW (DV-31) with access. and TEDAC torch SBT 504 W, 3 m**		**30**	**SET154194**	**10.720,00**
	AB2CD2	**Synergic MIG PULSE welding unit HighPULSE 554 DW (DV-31) with access. and TEDAC torch SBT 504 W, 4 m**		**30**	**SET154196**	**10.730,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Wire feeder:**					
	B1	**Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG**		**38**	**137652**	**1.225,00**
	B2	**Wire feeder DV-31 for HighPULSE, HighPULSE touch, SpeedMIG**		**38**	**137650**	**1.600,00**
C	**Standard accessories:**					
	C1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	C2	Regulator argon/CO2, single stage		46	01200300	68,00
D	**Welding torches:**					
	D1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	D2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**

3.2.12. Accessories for HighPULSE 354/454/554 DW

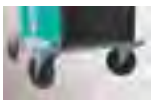
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Accessories:						
	1.1	Adapter for wire spool		46	02900104	19,50
	1.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	1.3	Push-Pull kit incl. sockets and switches for HighPULSE and SpeedMIG DW		46	138286	645,00
	1.4	Connection for remote control incl. switch and socket for HighPULSE, SpeedMIG, OptiMIG in DW version		46	02110427	60,00
	1.5	Connection for buttons inching and gas test for ROB torch, mounted in wire feeder with 10 pol. socket		46	158422	60,00
	1.6	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	1.7	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	1.8	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	1.9a	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	3,50
	1.9b	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	110,00
	1.10	Price reduction: no integrated water cooling unit (D version)		46	01903611	-485,00
	1.11	Mains supply 500 V for HP and SM DW, transformer installed at the welding unit		46	138282	1.020,00
	1.12	Polarity change and TIG (DC) welding for series HighPULSE and SpeedMIG version DW (LiftTIG), MAG torch connector		46	138276	305,00
	1.13	TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/fabric hose assembly		10	145092	440,00
	1.14	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.15a	MAG Remote Control MRC-50 for HighPULSE und SpeedMIG in steel casing with handgrip and magnet, incl. 5 m supply cable		46	154578	885,00
	1.15b	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	1.15c	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	1.15d	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
	1.16	Cover with lock, transparent, for power source HighPULSE, SpeedMIG and HighTIG version KW and DW		46	138238	142,00
	1.17	Power supply and automation connection or WCM, installed in the Merkle welding power source, 10 pin plug. : Welding ON, ARC OK, Emergency Stop and 42 V AC		31	132532	251,00
	1.18	Front panel for 4 jobs incl. trim potentiometer and buttons for gas test and wire inching for series HighPULSE when not using standard operation panel		46	137158	1.480,00
	1.19	Front panel MC-40 for series HighPULSE 8 job version with digital displays and rotary switches incl. digital process controller ME-MTC32 when not using standard operation panel		46	145766	1.480,00
	1.20a	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		06	142546	440,00
	1.20b	MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		06	142548	450,00
	1.21a	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		25	154244	525,00
	1.21b	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		25	154248	535,00
	1.22	Bus connection for operation of TEDAC Digital torches at standard wire feeder series HighPULSE, (only with special interconnection cable)		46	156414	150,00
	1.23	Option torch with TEDAC DIGITAL system when not using standard TEDAC torch for HighPULSE and SpeedMIG		25	155840	100,00
	1.24	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

2 Accessories for wire feeder:

	2.1	Rotatable device for wire feeder including screw set		46	137436	155,00
	2.2	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	2.3	Standard operation panel inside wire feeder for series HighPULSE, HighPULSE touch and SpeedMIG (only with special interconnection cable)		46	138526	140,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	2.4a	Cover with lock for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137546	152,00
	2.4b	Cover (standard) for operation panel at the wire feeder for HighPULSE, HighPULSE touch and SpeedMIG		46	137547	132,00
	2.5	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	2.6	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	2.7	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	2.8	Balancer G3		05	147244	980,00
	2.9	Wheelbase widening set for HighPULSE, SpeedMIG x52, x54 DW		05	138266	73,00
	2.10	Connection for wire feed liner inside the wire feeder box		38	110454	62,00
	2.11	Wire feeder DV-26 for HighPULSE, HighPULSE touch, SpeedMIG		38	137652	1.225,00
	2.12	Wire feeder DV-31 for HighPULSE, HighPULSE touch, SpeedMIG		38	137650	1.600,00

3 Connection cable to wire feeder for HighPULSE 354/454 DW:

	3.1	Connection cable 5 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138844	400,00
	3.2	Connection cable 10 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138846	560,00
	3.3	Connection cable 15 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153218	750,00
	3.4	Connection cable 20 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	153220	940,00
	3.5	Connection cable 30 m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	154388	1.320,00

Price reduction, when not taken:

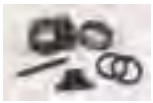
	3.6	Connection cable 1.6m 70 mm², HighPULSE, SpeedMIG 352, 452, 354, 454 OptiMIG 351, 451, HighPULSE touch 400/450 DW		38	138842	280,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
4	**Connection cable to wire feeder for HighPULSE 554 DW:**				
4.1	Connection cable 5 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137638	420,00
4.2	Connection cable 10 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137642	610,00
4.3	Connection cable 15 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137644	820,00
4.4	Connection cable 20 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137646	975,00
4.5	Connection cable 30 m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	154386	1.410,00
	Price reduction, when not taken:				
4.6	Connection cable 1.6m 95 mm², HighPULSE, SpeedMIG 552, OptiMIG 551		38	137634	290,00
5	**Connection cable for controller in wire feeder:**				
5.1	Connection cable 1.6 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138516	360,00
5.2	Connection cable 5 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138518	510,00
5.3	Connection cable 10 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138520	750,00
5.4	Connection cable 15 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138522	970,00
5.5	Connection cable 20 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 for operation panel inside wire feeder		38	138524	1.200,00
5.6	Connection cable 30 m 95 mm², HighPULSE, SpeedMIG 352, 452, 354, 454, 554, HighPULSE touch 400/450 incl. control cable for controller in wire feeder		38	145740	1.700,00
6	**Interface power source <-> computer:**				
6.1	Ethernet interface for HighPULSE		17	126506	1.245,00
6.2	Option Wifi equipment		17	144106	145,00
7	**Software (for free):**				
7.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
7.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
7.3	Software for HighUP process for series HighPULSE		17	134392	880,00
7.4	Software for Interpulse process for series HighPULSE		17	120490	280,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
8	**Software:**					
	8.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00
	8.2	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	8.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
	8.4	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
9	**WeldFACTORY:** **control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)**					
10	**Automation accessories:**					
	11.1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	11.2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	11.3	Bus connection (Profibus, DeviceNet, CANopen, interbus, etc.) for HighPULSE, SpeedMIG		17	113834	1.635,00
	11.4	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	11.5	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
	11.6	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00

11 Additional wire equipment for DV-26 and DV-31:



Pos.	Description	Pu	PrGrp	Part No.	Price/€
12.1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
12.2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
12.3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	63,00
12.4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
12.5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
12.6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	79,00
12.7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
12.8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00
12.9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	83,00
12.10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	78,00
12.11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	78,00
12.12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	219,00
12.13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	219,00
12.14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	219,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.2.13. HighPULSE 354/454/554 DW TWIN

Model HighPULSE	HP 354 DW	HP 454 DW	HP 554 DW
Primary:			
Power supply:	3 x 400 V	3 x 400 V	3 x 400 V
Frequency:	50 / 60 Hz	50 / 60 Hz	50 / 60 Hz
Contin. power:	14.5 kVA	15.9 kVA	19.4 kVA
Contin. current:	21 A	23 A	28 A
Max. current:	25 A	34 A	45 A
cos phi:	0.98	0.98	0.98
Secondary:			
Open circuit voltage:	57 V	72 V	72 V
Welding voltage:	15 - 31.5 V	15 - 36.5 V	15 - 41.5 V
Welding current:	20 - 350 A	20 - 450 A	20 - 550 A
Duty cycle 40 % (40°C):			550 A
Duty cycle 50 % (40°C):	350 A	450 A	500 A
Duty cycle 60 % (40°C):	330 A	400 A	470 A
Duty cycle 100 % (40°C):	280 A	330 A	420 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MMA, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE, option: TIG DC
Program selection:	material, wire diameter and gas at the display
Operation modes:	2-stroke, 4-stroke, 4-stroke with start current
Gas check:	button with hold function and automatic switch off
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	at the machine, at the wire feeder, at the TEDAC torch, job mode
LEDs:	mains, failure, temp. protection, hold function
Adjustable parameters:	choke inductance, wire burn back
Automated functions:	soft start (programmable)
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and electrode cable
Torch cooling:	integrated water cooler
Mains supply cable:	4 x 4.0 mm² 4 x 6.0 mm² 4 x 6.0 mm² with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	for 10, 20 and 50 l cylinders
Stabilization:	± 10 % power mains fluctuation
Air filter:	as a standard
Norm:	EN 60974-1 "S" / CE
Weight:	155 kg 165 kg 170 kg (incl. wire feeder and connection cable)
Dimensions l x w x h:	1100 x 700 x 1200 mm (incl. wire feeder and rotary device)

Wire feeder: separately mounted, model DV-32 TWIN

Supply voltage:	42 V-AC/42 V-DC
Wire feed:	2 units 4-roller drive 0.5 - 30 m/min. with tacho motor
Standard wire equipment:	mild steel 1.2 mm
LED:	2 x selection of wire feeder
Reel hub assembly:	2 x D 300/15 DIN 8559
Torch connection:	EURO connector
Connection cable:	1.6 m, 95 mm², water cooled
Weight:	42 kg
Dimensions l x w x h:	662 x 440 x 424 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Synergic Pulse welding units HighPULSE DW TWIN:**					
	A1	**Synergic MIG Pulse welding unit ighPULSE 354 DW TWIN with twin wire feeder DV-32 TWIN**		**30**	**SET132279**	**12.440,00**
	A2	**Synergic MIG Pulse welding unit ighPULSE 454 DW TWIN with twin wire feeder DV-32 TWIN**		**30**	**SET132280**	**13.350,00**
	A3	**Synergic MIG Pulse welding unit HighPULSE 554 DW TWIN with twin wire feeder DV-32 TWIN**		**30**	**SET132282**	**13.890,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
B	**Accessories:**					
	B1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.**		**06**	**142482**	**425,00**
	C2	**MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.**		**06**	**142484**	**435,00**
	C3	**MIG/MAG hand welding torch TEDAC, SBT 504 W-Alu, 3 m, long vers. special equipment for aluminium welding**		**06**	**142672**	**485,00**
	C4	**MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m**		**06**	**142546**	**440,00**
	C5	**MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m**		**06**	**142548**	**450,00**
D	**Accessories:**					
	D1	Adapter for wire spool		46	02900104	19,50
	D2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	D3	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	D4	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D5a	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	3,50
	D5b	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	110,00
	D6	Switch-off of the open circuit voltage of the non activated torch for TWIN wire feeder		46	156928	540,00
	D7	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for wire feeder:

	E1	Option: 4 wheels mounted on the wire feeder		38	00102109	55,00
	E2	Rotatable device for wire feeder including screw set		46	137436	155,00
	E3	Wire straightener - 360° without wire sensor 4-roller-drive DV-32		46	146452	295,00
	E4	Wire feeder DV-32 TWIN incl. suspension device		38	147922	4.850,00

F Connection cable to wire feeder:

	F1	Connection cable 5 m 95 mm² TWIN HighPULSE 352/452/552 DW		38	138256	840,00
	F2	Connection cable 10 m 95 mm² TWIN HighPULSE 352/452/552 DW		38	138258	1.130,00
	F3	Connection cable 15 m 95 mm² TWIN HighPULSE 352/452/552 DW		38	138260	1.480,00
	F4	Connection cable 20 m 95 mm² TWIN HighPULSE 352/452/552 DW		38	138262	1.770,00
	F5	Connection cable 1.6 m 95 mm² TWIN HighPULSE 352/452/552 DW		38	138254	680,00

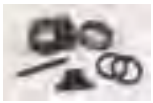
G Software (for free):

DeepARC	G1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	G2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	G4	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	G3	Software for Interpulse process for series HighPULSE		17	120490	280,00

H Software:

EN 1090 WPQR	H1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00

I Additional wire equipment for DV-32:



Pos.	Description	Pu	PrGrp	Part No.	Price/€
I1	Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113846	63,00
I2	Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113848	63,00
I3	Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113850	63,00
I4	Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113852	79,00
I5	Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113854	79,00
I6	Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113856	79,00
I7	Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)		46	113858	83,00
I8	Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113860	83,00
I9	Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)		46	113862	83,00
I10	Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)		46	113864	78,00
I11	Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)		46	113866	78,00
I12	Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)		46	113868	219,00
I13	Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)		46	113870	219,00
I14	Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)		46	113872	219,00

3.3. Synergic Pulse welding units for automation and robotics

3.3.1. HighPULSE 352 RS

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	12 kVA
Contin. current:	17 A
Max. current:	25 A
cos phi:	0.98
Secondary:	
Open circuit voltage:	57 V
Welding voltage:	15 - 31.5 V
Welding current:	20 - 350 A
Duty cycle 60% (10 min.):	350 A (40 °C)
Duty cycle 100%:	300 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 2.5 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	51 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.3.2. HighPULSE 452 RS

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
Contin. power:	14.4 kVA
Contin. current:	25 A
Max. current:	34 A
cos phi:	0.98
Secondary:	
Open circuit voltage:	72 V
Welding voltage:	15 - 36.5 V
Welding current:	20 - 450 A
Duty cycle 50% (10 min.):	450 A (40 °C)
Duty cycle 60% (10 min.):	400 A (40 °C)
Duty cycle 100%:	330 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	62 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

3.3.3. HighPULSE 552 RS

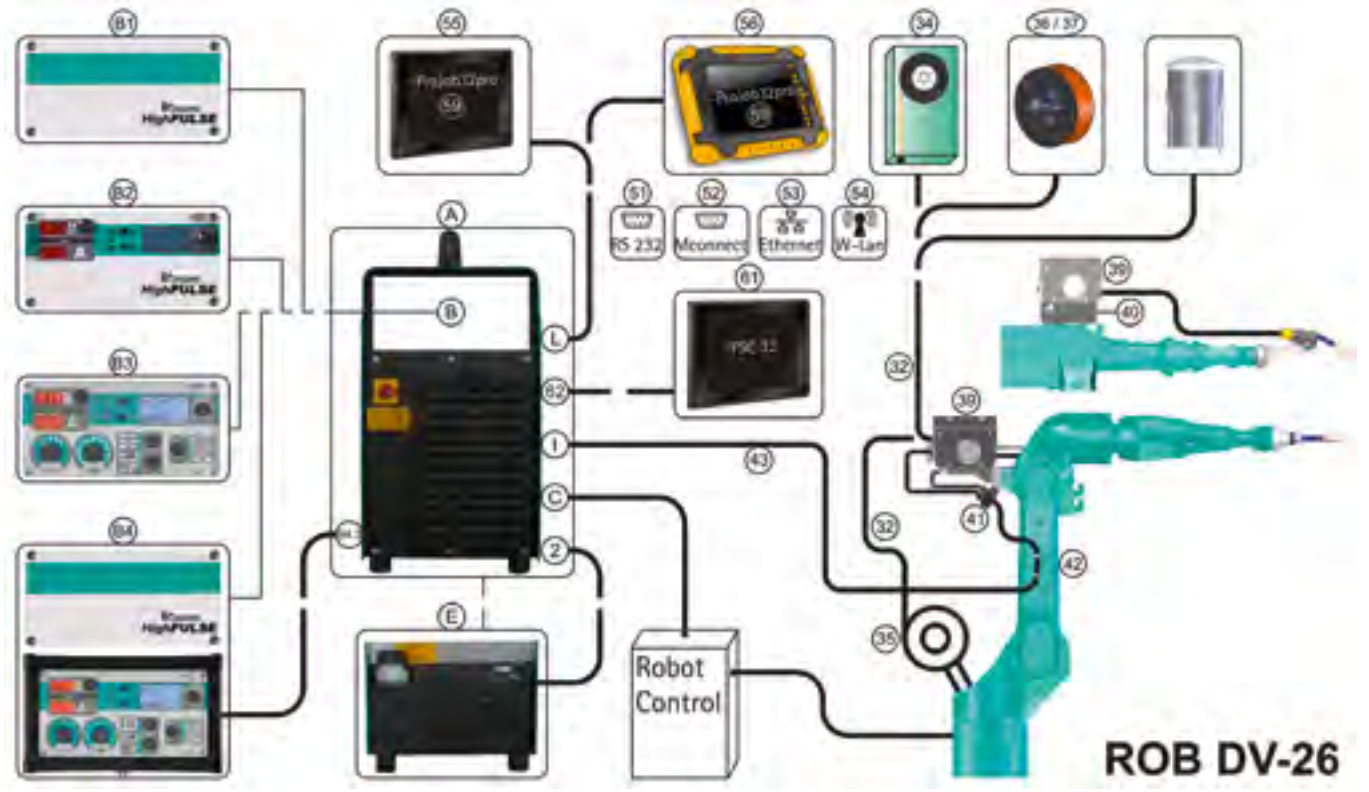
Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
Contin. power:	19.4 kVA	
Contin. current:	28 A	
Max. current:	45 A	
cos phi:	0.98	
Secondary:		
Open circuit voltage:	72 V	
Welding voltage:	15 - 41.5 V	
Welding current:	20 - 550 A	
Duty cycle 40% (10 min.):		550 A (40 °C)
Duty cycle 50% (10 min.):		500 A (40 °C)
Duty cycle 60% (10 min.):	550 A (20 °C)	470 A (40 °C)
Duty cycle 100%:	500 A (20 °C)	420 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Arc length:	Automatic energy control
Program capacity:	512 programs
Programs:	MIG/MAG, PulseARC, MIG brazing, DeepARC, ColdMIG, HighUP, ProSWITCH, InterPULSE
Program selection:	material, wire diameter and gas at the display (option)
Gas check:	button with hold function and automatic switch off
Wire inching:	button
Digital display:	current, voltage, wire feed speed and material thickness with pre-display and hold function
Energy adjustment:	control via the interface, job operation mode
LEDs:	mains, failure, temp. protection, hold function
Automated functions:	choke inductance, pulse shape, wire burn back adjustable at display, soft start programmable
Job mode:	2000 jobs programmable
Power source:	inverter
Sockets 95 mm²:	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	64 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.3.4. Wire feeder ROB DV-26



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Robot Synergic Pulse welding units:**				
A1	**Robot MIG Pulse Welding Unit Model HighPULSE 352 RS (without front, interface and motor controller)**		**30**	**SET144020**	**4.820,00**
A2	**Robot MIG Pulse Welding Unit Model HighPULSE 452 RS (without front, interface and motor controller)**		**30**	**SET144022**	**5.920,00**
A3	**Robot MIG Pulse Welding Unit Model HighPULSE 552 RS (without front, interface and motor controller)**		**30**	**SET144024**	**6.420,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**				
	Motor controller (please select):				
	Motor controller for ROB DV-26		46	118626	1.120,00
B	**Operation panel/front (please select one):**				
B1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
B2	Front panel MC-30 with MTC32 for series HighPULSE with digital display (V, m/min, mm, %) and multi-function display with process controller		46	154424	990,00
B3	Front panel MC-20 with MTC32 for series HighPULSE with digital display and display field incl. process controller		46	153838	1.480,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
External operation panel:						
	B4.1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
	B4.2	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	B4.3	MAG Remote Control MRC-21 mounted in ext. controller incl. displays for series HighPULSE with 5 m cable (only with 117.440)		46	113809	1.340,00
	B4.4	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	B4.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
C Interface connection (please select one):						
	C1	Interface CANopen for RS series		17	117428	1.980,00
	C2	Bus interface Profibus-DP for RS series		17	117430	1.980,00
	C3	Bus interface DeviceNet for RS series		17	117432	1.980,00
	C4	Bus interface Interbus for RS series		17	117436	1.980,00
	C5	Bus interface ProfiNET-IO for RS series		17	117438	1.980,00
	C6	Bus interface RS485 for RS series		17	139818	597,00
	C7	Interface Ethercat for RS series		17	141746	1.980,00
	C8	Bus interface EtherNet/IP for RS series		17	146338	1.980,00
	C9	Bus interface Modbus RTU RS485 for RS series		17	158834	1.850,00
	C10	Bus interface Modbus TCP for RS series		17	158836	1.850,00
	C11a	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	C11b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C12a	Analogue interface for RS series incl. socket 24 pol.		17	113788	1.300,00
	C12b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C13a	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	450,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C13b	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

E Water cooling:

	1	Water cooling unit model WK 350		46	144008	1.200,00
	2	Water flow control device mounted in the water cooler		46	02610156	265,00
	3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

F Wire feeder ROB DV-26:

	39	Robot wire feeder ROB DV-26 weight 7 kg		38	118458	1.800,00
	32	Wire feeding liner from unspool device to wire feeder, 4 m		38	02200340	95,00
	33	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	34	Box for wire spool incl. connection for wire feeding liner		38	101464	420,00
	34.1	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	35	Mounting device for wire spool (K300) incl. housing for KUKA robot		38	118474	178,00
	36	Reel-Off Device ASV 300 for non-returnable large spools 300 kg		05	02900100	5.020,00
	37	Reel-Off Device ASV 40 for aluminium wire spools, heated incl. wire end recognition		05	110130	8.500,00

G1 Roboter installation devices for standard robots:

40.1	Assembly device for ROB DV-26 for KUKA robot standard		09	118462	290,00
40.2	Assembly device for ROB DV-26 for Motoman robot standard		09	118464	290,00
40.3	Assembly device for ROB DV-26 for fanuc robot standard		09	118466	290,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	40.4	Assembly device for ROB DV-26 for ABB robot standard		09	119926	290,00
	40.5	Assembly device for ROB DV-26 for REIS robot standard		09	128720	290,00
G2	**Roboter installation devices for HW robots:**					
	41.1	Assembly device for ROB DV-26 for KUKA robot KR 5 HW		09	118463	300,00
	41.2	Assembly device for ROB DV-26 for KUKA robot KR 16 arc HW		09	125210	300,00
	41.3	Assembly device for ROB DV-26 for Motoman/Yaskawa robot HW		09	118465	300,00
	41.4	Assembly device for ROB DV-26 for fanuc robot HW		09	118467	300,00
	41.5	Assembly device for ROB DV-26 for ABB robot HW		09	119928	300,00
	41.6	Assembly device for ROB DV-26 for REIS robot HW		09	128722	300,00
	41.7	Assembly device for ROB DV-26 for Kawasaki robot HW		09	153040	300,00
H	**Fixtures and accessories:**					
	42.1	Fixtures for interconnection cable at the robot, system KUKA		09	118468	198,00
	42.2	Fixtures for interconnection cable at the robot, system Motoman/Yaskawa		09	118470	198,00
	42.3	Fixtures for interconnection cable at the robot, system Fanuc		09	118472	198,00
	42.4	Fixtures for interconnection cable at the robot, system ABB		09	119930	198,00
	42.5	Fixtures for interconnection cable at the robot, system REIS		09	128724	198,00
I	**Connection cables:**					
	43.1	Connection cable, 5 m, 95 mm², w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		38	118620	930,00
	43.2	Connection cable, 10 m, 95 mm², w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		38	118624	1.430,00
	43.3	Connection cable, 15 m, 95 mm², w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		38	143614	1.980,00
	43.4	Connection cable, 20 m, 95 mm², w. robot - ROB DV-26 wire feeder high flex., incl. water hoses		38	142432	2.480,00
J	**Options and accessories:**					
	13	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	14	Regulator argon/CO2, single stage		46	01200300	68,00
	15.1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	15.2	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	16	Protective gas control		46	01903578	111,00
	17	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
	18	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

K Welding software (free of charge):

DeepARC	50.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	50.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	50.3	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	50.4	Software for Interpulse process for series HighPULSE		17	120490	280,00

L Interface power source <-> computer:

	53	Ethernet interface for HighPULSE		17	126506	1.245,00
	54	Option Wifi equipment		17	144106	145,00

M Software:

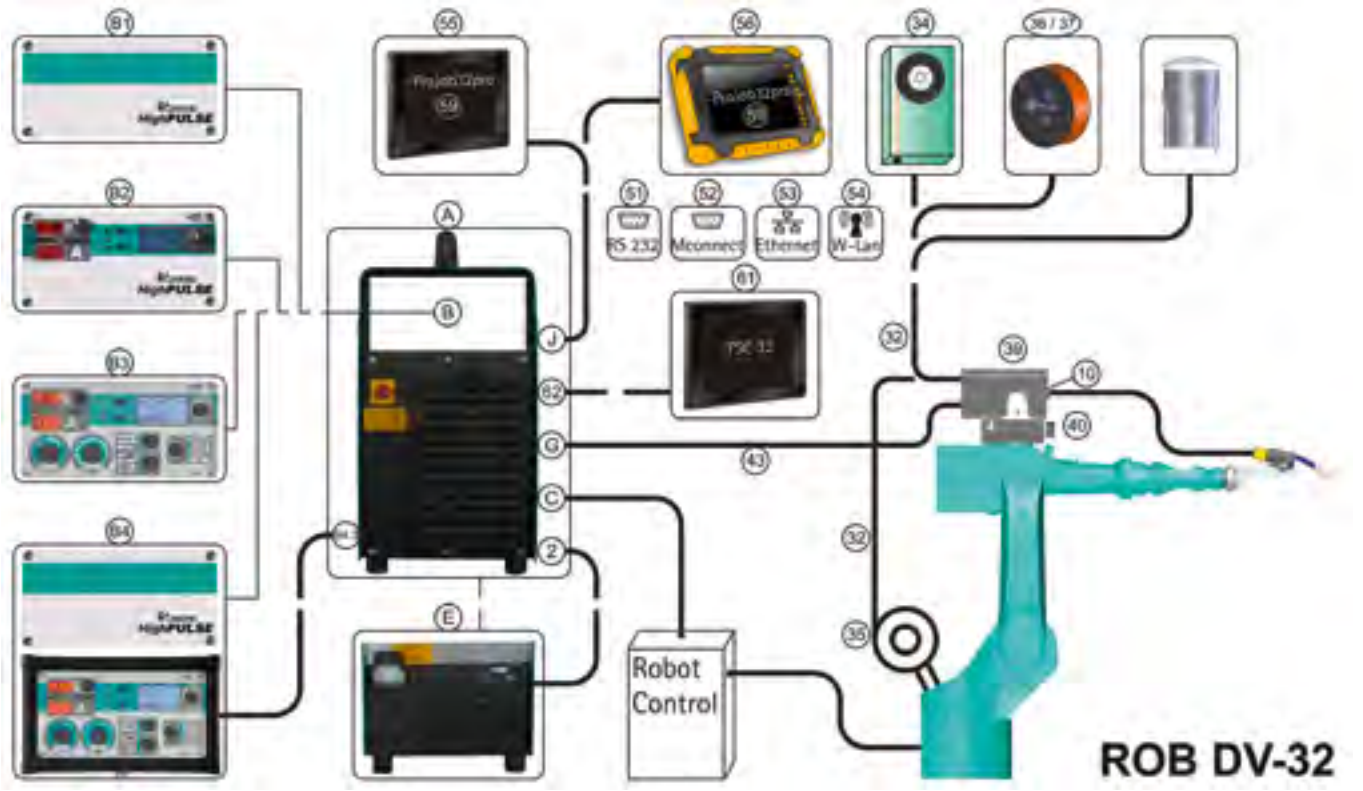
	57	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	58	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
	59	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00

N WeldFACTORY:
control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)

O TANDEM welding:

	70	Synchronisation for TANDEM welding of one synergic pulse welding unit		46	102417	1.942,00
	71	Synchronisation cable for TANDEM welding, 4 m long		46	102418	120,00

3.3.5. Wire feeder ROB DV-32



Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Robot Synergic Pulse welding units:**				
A1	**Robot MIG Pulse Welding Unit Model HighPULSE 352 RS (without front, interface and motor controller)**		**30**	**SET144020**	**4.820,00**
A2	**Robot MIG Pulse Welding Unit Model HighPULSE 452 RS (without front, interface and motor controller)**		**30**	**SET144022**	**5.920,00**
A3	**Robot MIG Pulse Welding Unit Model HighPULSE 552 RS (without front, interface and motor controller)**		**30**	**SET144024**	**6.420,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**				
	Motor controller (please select):				
	Motor controller for ROB DV-31/32 for series HighPULSE RS		46	118628	275,00
B	**Operation panel/front (please select one):**				
B1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
B2	Front panel MC-30 with MTC32 for series HighPULSE with digital display (V, m/min, mm, %) and multi-function display with process controller		46	154424	990,00
B3	Front panel MC-20 with MTC32 for series HighPULSE with digital display and display field incl. process controller		46	153838	1.480,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
External operation panel:						
	B4.1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
	B4.2	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	B4.3	MAG Remote Control MRC-21 mounted in ext. controller incl. displays for series HighPULSE with 5 m cable (only with 117.440)		46	113809	1.340,00
	B4.4	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	B4.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
C Interface connection (please select one):						
	C1	Interface CANopen for RS series		17	117428	1.980,00
	C2	Bus interface Profibus-DP for RS series		17	117430	1.980,00
	C3	Bus interface DeviceNet for RS series		17	117432	1.980,00
	C4	Bus interface Interbus for RS series		17	117436	1.980,00
	C5	Bus interface ProfiNET-IO for RS series		17	117438	1.980,00
	C6	Bus interface RS485 for RS series		17	139818	597,00
	C7	Interface Ethercat for RS series		17	141746	1.980,00
	C8	Bus interface EtherNet/IP for RS series		17	146338	1.980,00
	C9	Bus interface Modbus RTU RS485 for RS series		17	158834	1.850,00
	C10	Bus interface Modbus TCP for RS series		17	158836	1.850,00
	C11a	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	C11b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C12a	Analogue interface for RS series incl. socket 24 pol.		17	113788	1.300,00
	C12b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C13a	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	450,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C13b	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

E Water cooling:

	1	Water cooling unit model WK 350		46	144008	1.200,00
	2	Water flow control device mounted in the water cooler		46	02610156	265,00
	3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

F Wire feeder ROB DV-32:

	39	Robot wire feeding unit model ROB DV-32 (connection wire feeding liner) incl. tacho motor, robot gear, wire straightener, button gas test and wire inching, blow-out device 0.5 - 30 m/min, 9.7 kg		38	143660	2.420,00
	40	Assembly plate for mounting of ROB DV-32 on 3rd axis of robot (please specify the robot model)		05	144056	290,00
	32	Wire feeding liner from unspool device to wire feeder, 4 m		38	02200340	95,00
	33	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	34	Box for wire spool incl. connection for wire feeding liner		38	101464	420,00
	34.1	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	35	Mounting device for wire spool (K300) incl. housing for KUKA robot		38	118474	178,00
	36	Reel-Off Device ASV 300 for non-returnable large spools 300 kg		05	02900100	5.020,00
	37	Reel-Off Device ASV 40 for aluminium wire spools, heated incl. wire end recognition		05	110130	8.500,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
G	**Connection cables:**					
	43.1	Connection cable, 5 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144088	625,00
	43.2	Connection cable, 10 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144090	899,00
	43.3	Connection cable, 15 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144092	1.290,00
	43.4	Connection cable, 20 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144094	1.650,00
H	**Options and accessories:**					
	10	Push-Pull kit incl. sockets and switches		46	02110403	630,00
	13	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	14	Regulator argon/CO2, single stage		46	01200300	68,00
	15.1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	15.2	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	16	Protective gas control		46	01903578	111,00
	17	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
	18	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
I	**Welding software (free of charge):**					
DeepARC	50.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	50.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	50.3	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	50.4	Software for Interpulse process for series HighPULSE		17	120490	280,00
J	**Interface power source <-> computer:**					
	53	Ethernet interface for HighPULSE		17	126506	1.245,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	54	Option Wifi equipment		17	144106	145,00

K Software:

	57	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	58	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
	59	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00

L WeldFACTORY:
control, documentation and evaluation of welding parameters, job management
(see section 10.5 of the general catalogue)

M TANDEM welding:

	70	Synchronisation for TANDEM welding of one synergic pulse welding unit		46	102417	1.942,00
	71	Synchronisation cable for TANDEM welding, 4 m long		46	102418	120,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

3.3.6. Wire feeder AUTO DV-31

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Robot Synergic Pulse welding units:**					
	A1	**Robot MIG Pulse Welding Unit Model HighPULSE 352 RS (without front, interface and motor controller)**		**30**	**SET144020**	**4.820,00**
	A2	**Robot MIG Pulse Welding Unit Model HighPULSE 452 RS (without front, interface and motor controller)**		**30**	**SET144022**	**5.920,00**
	A3	**Robot MIG Pulse Welding Unit Model HighPULSE 552 RS (without front, interface and motor controller)**		**30**	**SET144024**	**6.420,00**
!	**Software DeepARC, ColdMIG, HighUP included for free (worth 2.640,00 €)**					
	Motor controller (please select):					
		Motor controller for ROB DV-31/32 for series HighPULSE RS		46	118628	275,00
B	**Operation panel/front (please select one):**					
	B1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
	B2	Front panel MC-30 with MTC32 for series HighPULSE with digital display (V, m/min, mm, %) and multi-function display with process controller		46	154424	990,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	B3	Front panel MC-20 with MTC32 for series HighPULSE with digital display and display field incl. process controller		46	153838	1.480,00
		External operation panel:				
	B4.1	Front panel MC-10 without displays without selectors for series HighPULSE incl. process controller		46	117440	750,00
	B4.2	MAG Remote Control MRC-20 in housing for manual process control incl. displays for series HighPULSE with 5 m cable (only with 117.440 and job panel)		46	113808	1.340,00
	B4.3	MAG Remote Control MRC-21 mounted in ext. controller incl. displays for series HighPULSE with 5 m cable (only with 117.440)		46	113809	1.340,00
	B4.4	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	B4.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
		C Interface connection (please select one):				
	C1	Interface CANopen for RS series		17	117428	1.980,00
	C2	Bus interface Profibus-DP for RS series		17	117430	1.980,00
	C3	Bus interface DeviceNet for RS series		17	117432	1.980,00
	C4	Bus interface Interbus for RS series		17	117436	1.980,00
	C5	Bus interface ProfiNET-IO for RS series		17	117438	1.980,00
	C6	Bus interface RS485 for RS series		17	139818	597,00
	C7	Interface Ethercat for RS series		17	141746	1.980,00
	C8	Bus interface EtherNet/IP for RS series		17	146338	1.980,00
	C9	Bus interface Modbus RTU RS485 for RS series		17	158834	1.850,00
	C10	Bus interface Modbus TCP for RS series		17	158836	1.850,00
	C11a	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	C11b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C12a	Analogue interface for RS series incl. socket 24 pol.		17	113788	1.300,00
	C12b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C13a	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	450,00
	C13b	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

E Water cooling:

	1	Water cooling unit model WK 350		46	144008	1.200,00
	2	Water flow control device mounted in the water cooler		46	02610156	265,00
	3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

F Wire feeding system AUTO DV-31:

	39	Robot wire feeder box AUTO DV-31 with GN tacho motor, robot gear		38	01910031	1.700,00
	32	Wire feeding liner from unspool device to wire feeder, 4 m		38	02200340	95,00
	33	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	36	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	38	Suspension device for wire feeder electrically isolated		46	00502878	79,00
	36	Reel-Off Device ASV 300 for non-returnable large spools 300 kg		05	02900100	5.020,00
	37	Reel-Off Device ASV 40 for aluminium wire spools, heated incl. wire end recognition		05	110130	8.500,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Connection cables:						
	43.1	Connection cable, 5 m, 95 mm² robot - wire feeder box incl. water hoses		38	02010928	530,00
	43.2	Connection cable, 10 m, 95 mm², robot - wire feeder box incl. water hoses		38	02010930	770,00
	43.3	Connection cable, 15 m, 95 mm², robot - wire feeder box incl. water hoses		38	144922	1.010,00
	43.4	Connection cable, 20 m, 95 mm², robot - wire feeder box incl. water hoses		38	144924	1.250,00
G **Wire feeder ROB DV-32:**						
	40	Robot wire feeding unit model ROB DV-32 (connection wire feeding liner) incl. tacho motor, robot gear, wire straightener, button gas test and wire inching, blow-out device 0.5 - 30 m/min, 9.7 kg		38	143660	2.420,00
	32	Wire feeding liner from unspool device to wire feeder, 4 m		38	02200340	95,00
	33	Dinse adapter for Euro torch connector (MIG/MAG)		46	01900544	320,00
	34	Box for wire spool incl. connection for wire feeding liner		38	101464	420,00
	34.1	Control 'end of welding wire', installed in the wire feeder box		46	103365	215,00
	35	Mounting device for wire spool (K300) incl. housing for KUKA robot		38	118474	178,00
	36	Reel-Off Device ASV 300 for non-returnable large spools 300 kg		05	02900100	5.020,00
	37	Reel-Off Device ASV 40 for aluminium wire spools, heated incl. wire end recognition		05	110130	8.500,00
Connection cables:						
	44.1	Connection cable, 5 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144088	625,00
	44.2	Connection cable, 10 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144090	899,00
	44.3	Connection cable, 15 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144092	1.290,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	44.4	Connection cable, 20 m, 95 mm², w. robot - ROB DV-32 wire feeder high flex., incl. water hoses		38	144094	1.650,00

H Options and accessories:

	10	Push-Pull kit incl. sockets and switches		46	02110403	630,00
	13	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	14	Regulator argon/CO2, single stage		46	01200300	68,00
	15.1	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	15.2	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	16	Protective gas control		46	01903578	111,00
	17	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
	18	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

I Welding software (free of charge):

DeepARC	50.1	Software for DeepARC process for series HighPULSE/SpeedMIG		17	120488	880,00
ColdMIG	50.2	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
HighUP	50.3	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	50.4	Software for Interpulse process for series HighPULSE		17	120490	280,00

J Interface power source <-> computer:

	53	Ethernet interface for HighPULSE		17	126506	1.245,00
	54	Option Wifi equipment		17	144106	145,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
K	**Software:**					
	57	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	58	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
	59	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
L	**WeldFACTORY:** **control, documentation and evaluation of welding parameters, job management** **(see section 10.5 of the general catalogue)**					
M	**TANDEM welding:**					
	70	Synchronisation for TANDEM welding of one synergic pulse welding unit		46	102417	1.942,00
	71	Synchronisation cable for TANDEM welding, 4 m long		46	102418	120,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4. MIG/MAG welding torches

4.1 Hand welding torches
SB/SBT series
HSB/HSBT series

4.2 Fume extraction welding torches
RSB/RSBT series

4.3 Push-Pull welding torches
PP/PPT series

4.4 Machine and Robot welding torches
MSB and ROB series

4.1. Hand welding torches

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.1.1. SB/SBT 157 G

MIG/MAG hand welding torch SB/SBT 157 G

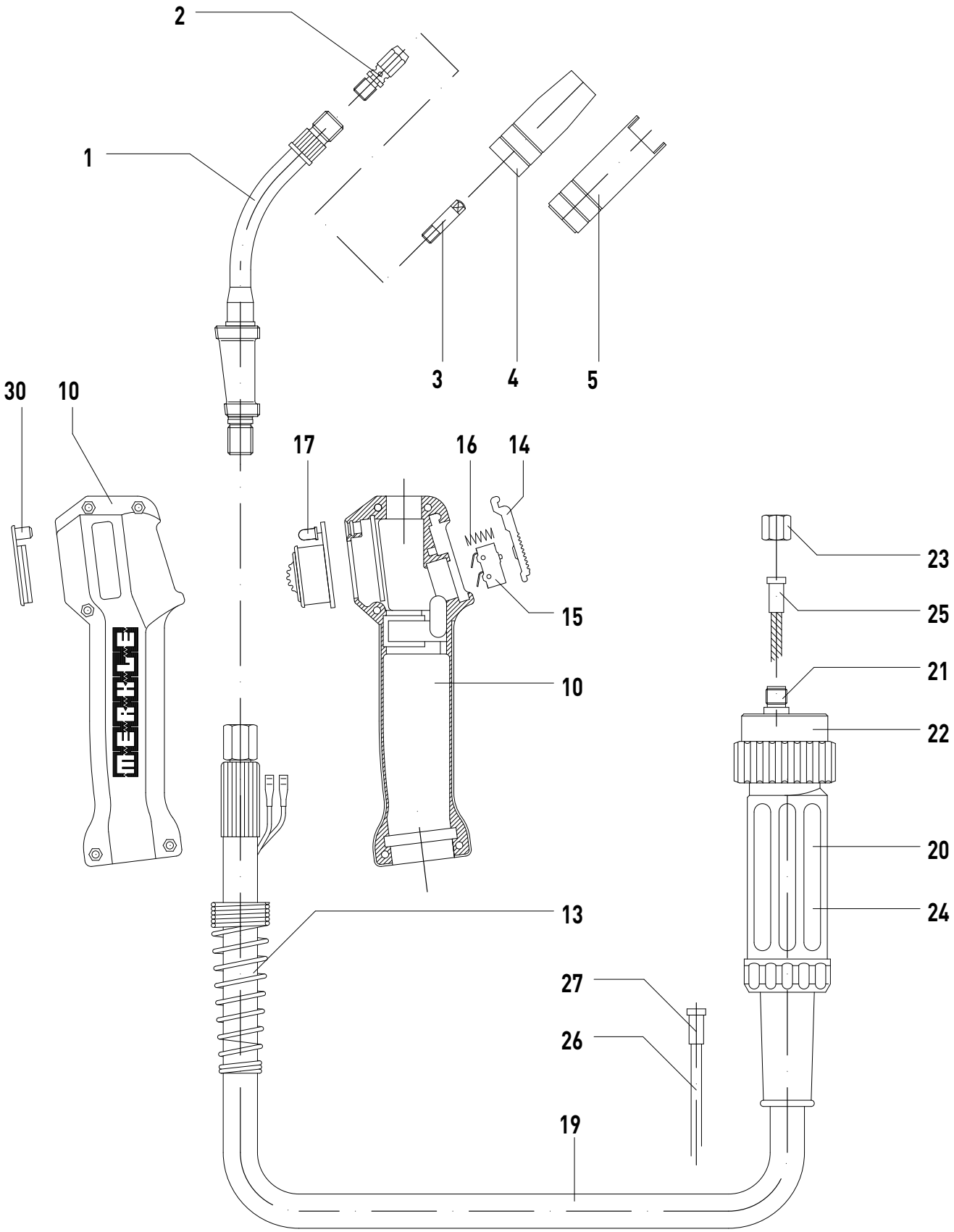
gas cooled

VERSIONS:

Standard

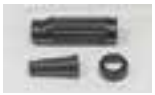
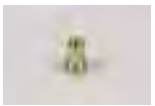
TEDAC

TECHNICAL DATA:	
Cooling:	gas cooled
Mixed gas:	150 A 60% duty cycle
CO_2:	180 A 60% duty cycle
Solid wire:	0.6 - 0.8 mm ∅
Aluminium wire:	0.8 - 1.0 mm ∅
Weight:	approx. 930 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/SBT 157 G						
		MIG/MAG hand welding torch model SB 157 G, 3 m		**06**	**118700**	**112,00**
		MIG/MAG hand welding torch model SB 157 G, 4 m		**06**	**118702**	**119,00**
		MIG/MAG hand welding torch TEDAC, model SBT 157 G, 3 m		**06**	**118704**	**197,00**
		MIG/MAG hand welding torch TEDAC, model SBT 157 G, 4 m		**06**	**118706**	**204,00**
Standard wire equipment: mild steel 0.8 mm						
Spare parts and consumables:						
	1	Torch neck SB/SBT 157 G		22	152216	31,50
	2	Tip adapter SB/SBT 157 G	10 pcs	22	152218	5,90
	3.1	Contact tip 0.6 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152181	1,73
	3.2	Contact tip 0.8 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152180	1,73
	3.3	Contact tip 1.0 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152182	1,73
	4	Gas nozzle SB/SBT 154/157 G		52	02210095	5,80
	5	Spot welding gas nozzle SB/SBT 154/157 G	10 pcs	52	02210096	6,80
	10	Handle for MIG/MAG torch without ball joint complete set left and right incl. screws		22	142536	29,00
	13	Kinking protection spring for gas cooled MIG torches		22	113068	4,90
	14	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	15	Micro switch for torch trigger		22	113638	8,90
	16	Spring for switch	10 pcs	22	02210131	0,85
Only for SBT 157 G:						
	17	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	19.1	Complete cable assembly SB/SBT 154/157 G 3 m, with Euro connector, without torch, without liner		22	02210316	68,00
	19.2	Complete cable assembly SB/SBT 154/157 G 4 m, with Euro connector, without torch, without liner		22	02210317	75,00
	20	Central connector MAG,gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	39,00
	21	Brass body central connector MAG gas cooled		22	02511401	21,00
	22	Sleeve nut black		22	02510300	9,80
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	27	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90

Only for SB 157 G:

	30	Cover cap for TEDAC handle		22	02210604	3,90

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.1.2. SB/SBT 307 G

MIG/MAG hand welding torch SB/SBT 307 G

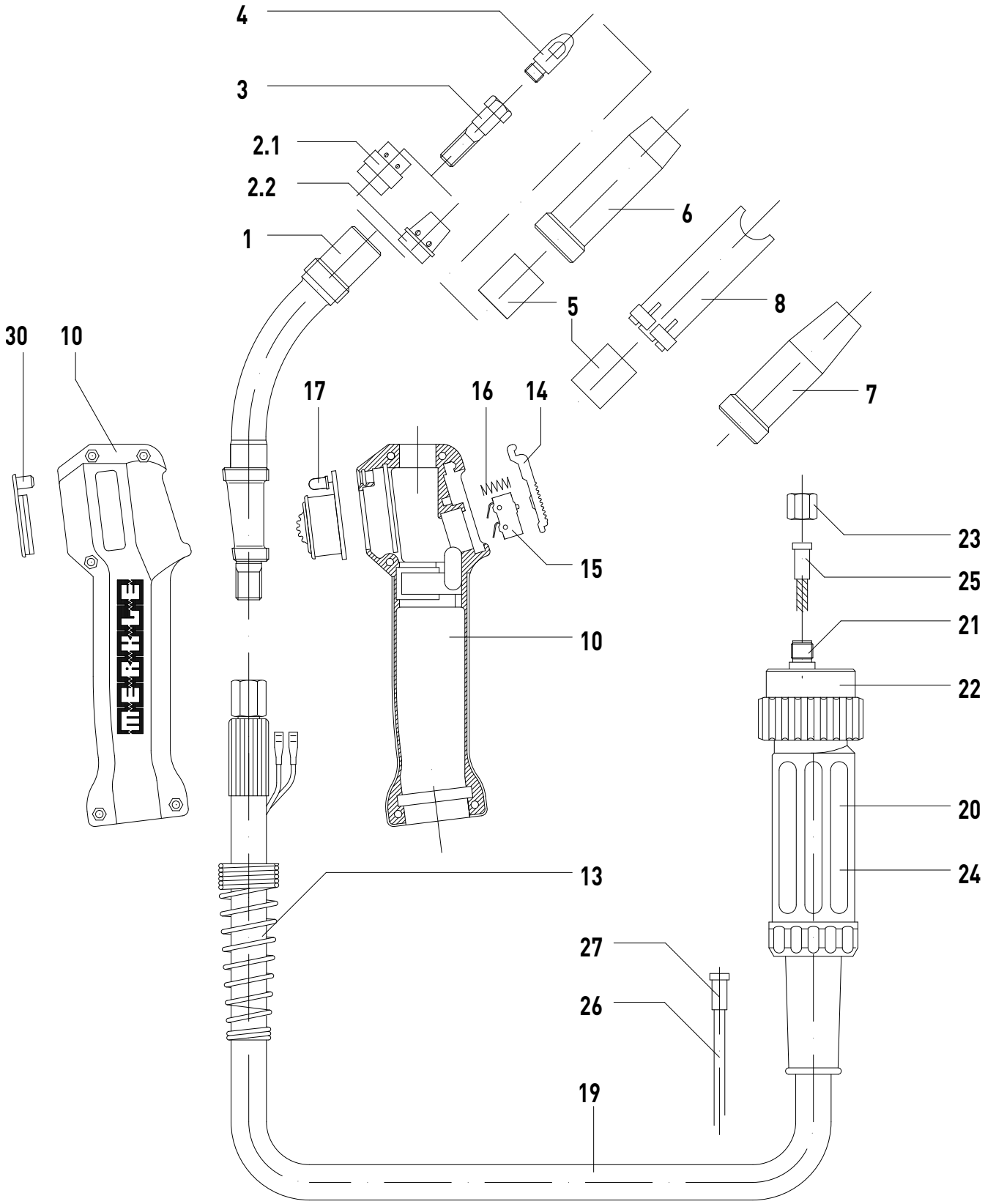
gas cooled

VERSIONS:

Standard

TEDAC®

TECHNICAL DATA:	
Cooling:	gas cooled
Mixed gas:	280 A 60% duty cycle
CO_2:	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm ∅
Aluminium wire:	0.8 - 1.0 - 1.2 mm ∅
Weight:	approx. 1100 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



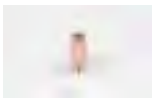
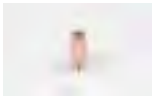
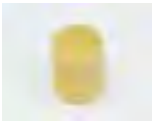
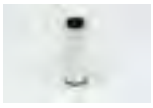
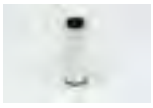
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

MIG/MAG hand welding torch SB/SBT 307 G

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		MIG/MAG hand welding torch model SB 307 G, 3 m		**06**	**02210758**	**158,00**
		MIG/MAG hand welding torch model SB 307 G, 4 m		**06**	**02210759**	**188,00**
		MIG/MAG hand welding torch model SB 307 G, 5 m		**06**	**154992**	**218,00**
		MIG/MAG hand welding torch TEDAC, model SBT 307 G, 3 m		**06**	**02210858**	**243,00**
		MIG/MAG hand welding torch TEDAC, model SBT 307 G, 4 m		**06**	**02210859**	**273,00**
		MIG/MAG hand welding torch TEDAC, model SBT 307 G, 5 m		**06**	**154994**	**303,00**

Standard wire equipment: mild steel 1.0 mm

Spare parts and consumables:

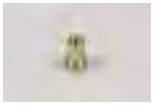
	1	Torch body SB/SBT 307 G		22	02210757	59,00
	2.1a	Gas diffusor SB/SBT 307 G ceramic spatter resistent	20 pcs	22	02210219	6,90
	2.1b	Gas diffusor SB/T 307 G plastic, black, for gas nozzle 022.1.0267, 022.1.0310	10 pcs	22	02210222	5,70
	2.2	Gas diffusor SB/T 307 G, plastic for gas nozzle 111.462	10 pcs	22	111938	12,00
	3	Tip adapter, SB 307 G, 38 mm	10 pcs	22	02210217	3,90
	4.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	4.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	4.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	4.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	4.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	4.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	5	Insulation ring SB 300/307	20 pcs	22	02210369	2,25
	6	Gas nozzle SB/SBT 300/307, with thread		52	02210267	8,90
	7	Gas nozzle 12 mm screw fixing (only with gas diffusor 111.938)	10 pcs	52	111462	18,30

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	8	Spot welding gas nozzle 300/307 with fastening ring		52	02210310	9,30
	10	Handle for MIG/MAG torch without ball joint complete set left and right incl. screws		22	142536	29,00
	13	Kinking protection spring for gas cooled MIG torches		22	113068	4,90
	14	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	15	Micro switch for torch trigger		22	113638	8,90
	16	Spring for switch	10 pcs	22	02210131	0,85

Only for SBT 307 G:

	17	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
	19.1	Complete cable assembly 35mm² 3 m, with Euro connector, without torch, without liner		22	02210296	97,00
	19.2	Complete cable assembly 35mm² 4 m, with Euro connector, without torch, without liner		22	02210297	127,00
	20	Central connector MAG,gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	39,00
	21	Brass body central connector MAG gas cooled		22	02511401	21,00
	22	Sleeve nut black		22	02510300	9,80
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	25.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	25.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	27	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90

Only for SB 307 G:

	30	Cover cap for TEDAC handle		22	02210604	3,90

Max. length of torch lead for alu: 3 m.

4.1.3. SB/SBT 351 G

MIG/MAG hand welding torch SB/SBT 351 G

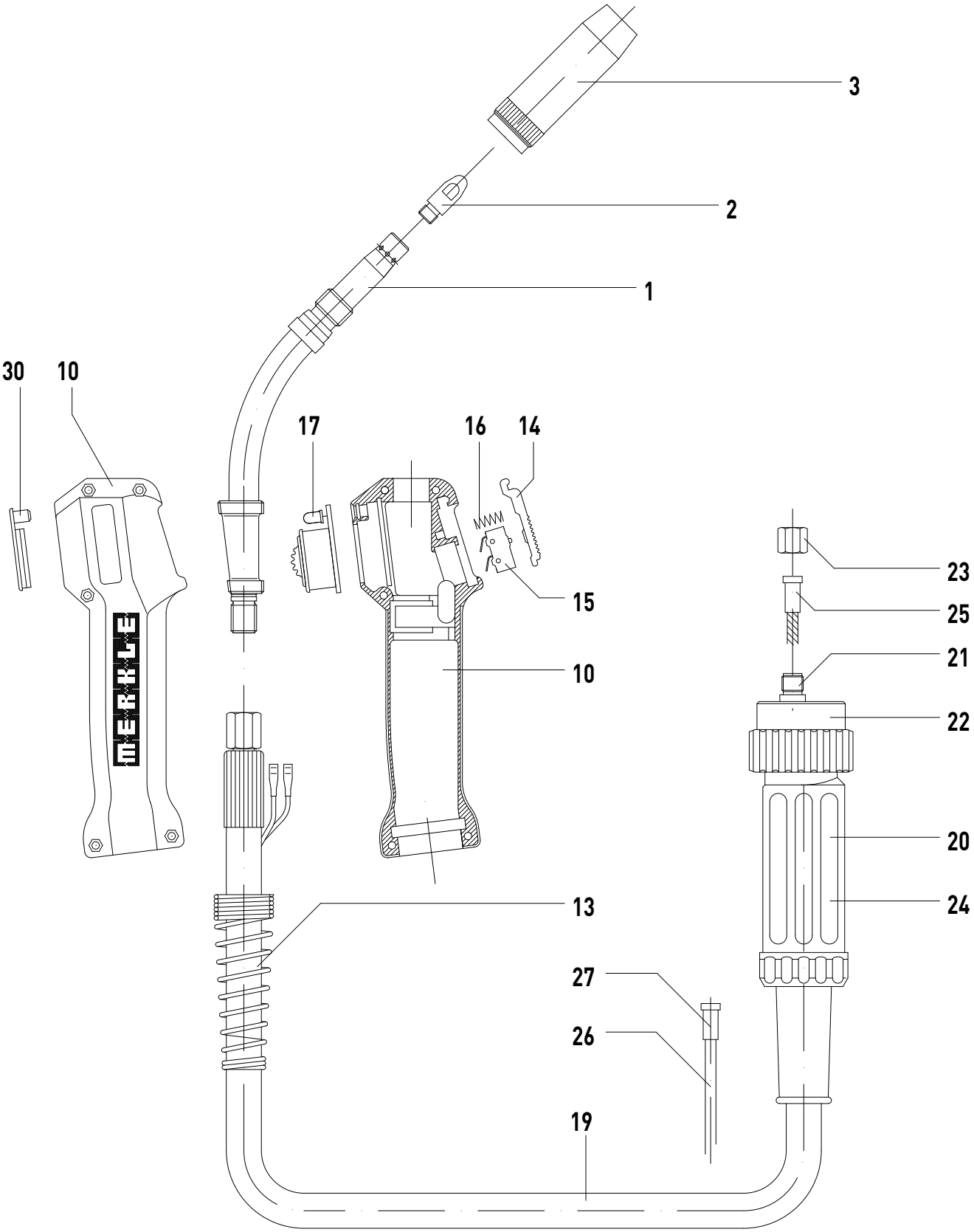
gas cooled

VERSIONS:

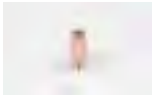
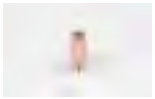
Standard

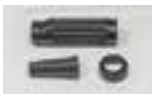
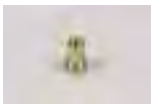
TEDAC®

TECHNICAL DATA:	
Cooling:	gas cooled
Mixed gas:	250 A 60% duty cycle
CO_2:	280 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm ∅
Aluminium wire:	0.8 - 1.0 - 1.2 mm ∅
Weight:	approx. 1350 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/SBT 351 G						
		MIG/MAG hand welding torch model SB 351 G, 3 m		**06**	**112934**	**168,00**
		MIG/MAG hand welding torch model SB 351 G, 4 m		**06**	**112936**	**198,00**
		MIG/MAG hand welding torch model SB 351 G, 5 m		**06**	**112376**	**228,00**
		MIG/MAG hand welding torch TEDAC, model SBT 351 G, 3 m		**06**	**112938**	**253,00**
		MIG/MAG hand welding torch TEDAC, model SBT 351 G, 4 m		**06**	**112940**	**283,00**
		MIG/MAG hand welding torch TEDAC, model SBT 351 G, 5 m		**06**	**118520**	**313,00**
Standard wire equipment: mild steel 1.0 mm						
Spare parts and consumables:						
	1	Torch neck SB/SBT 351 G		22	110628	60,00
	2.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	2.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	2.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	2.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	2.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	2.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	2.7	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60
	3	Gas nozzle 15 mm SB/T, RSB/T 351 G with thread and insulation		52	104170	9,80
	10	Handle for MIG/MAG torch without ball joint complete set left and right incl. screws		22	142536	29,00
	13	Kinking protection spring for gas cooled MIG torches		22	113068	4,90
	14	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	15	Micro switch for torch trigger		22	113638	8,90
	16	Spring for switch	10 pcs	22	02210131	0,85
Only for SBT 351 G:						
	17	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	19.1	Complete cable assembly, 3 m with Euro connector, without torch, without liner		22	02210323	107,00
	19.2	Complete cable assembly, 4 m with Euro connector, without torch, without liner		22	02210324	127,00
	20	Central connector MAG,gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	39,00
	21	Brass body central connector MAG gas cooled		22	02511401	21,00
	22	Sleeve nut black		22	02510300	9,80
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	24	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	25.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	25.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	25.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	25.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	26.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	26.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	26.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	26.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	27.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	27.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52

Only for SB 351 G:

	30	Cover cap for TEDAC handle		22	02210604	3,90

Max. length of torch lead for alu: 3 m.

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.1.4. SB/SBT 352 W

MIG/MAG hand welding torch SB/SBT 352 W

water cooled

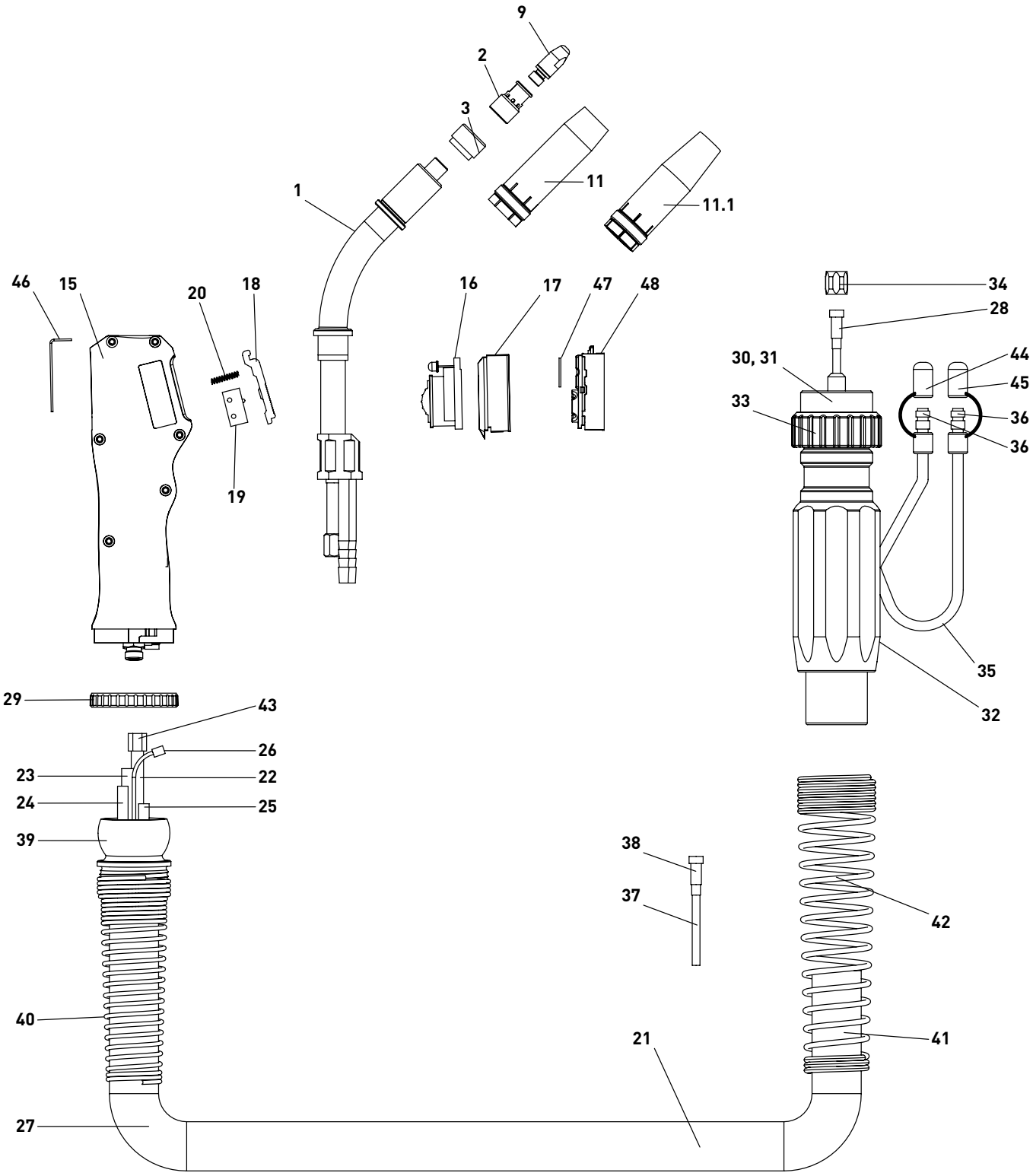
VERSIONS:

Standard

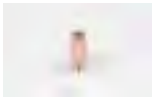
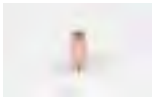
TEDAC®

TEDAC® DIGITAL

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm ∅
Aluminium wire:	1.0 - 1.2 mm ∅
Weight:	approx. 1350 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	

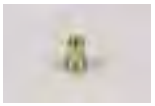


All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch SB/SBT 352 W						
		MIG/MAG hand welding torch model SB 352 W, 3 m		**06**	**142544**	**365,00**
		MIG/MAG hand welding torch model SB 352 W, 4 m		**06**	**142550**	**375,00**
		MIG/MAG hand welding torch TEDAC, model SBT 352 W, 3 m		**06**	**142546**	**440,00**
		MIG/MAG hand welding torch TEDAC, model SBT 352 W, 4 m		**06**	**142548**	**450,00**
TEDAC® digital		**Option torch with TEDAC DIGITAL system when not using standard TEDAC torch for HighPULSE and SpeedMIG**		**25**	**155840**	**100,00**
Standard wire equipment: mild steel 1.0 mm						
Spare parts and consumables:						
	1	Torch body SB/SBT 352 W 45° bent		22	142540	105,00
	2	Tip adapter SB/SBT 351/352 W		22	138292	6,50
	3	Insulation nut SB/SBt 300/351/352 W	10 pcs	22	138812	1,20
	9.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	9.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	9.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	9.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	9.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	9.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	9.7	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60
	11	Gas nozzle 15 mm SB/SBT 351/352 W		52	138270	4,90
	11.1	Gas nozzle 12 mm SB/SBT 351/352 W		52	138352	4,90
	15	Handle for MIG/MAG torch with ball joint complete set left and right incl. screws (without ball joint)		22	131272	35,00
Only for SBT 352 W:						
	16	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	17	Frame for TEDAC left and right for torches with ball joint		22	134478	7,90
	18	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	19	Micro switch for torch trigger		22	113638	8,90
	20	Spring for switch	10 pcs	22	02210131	0,85
	21.1	Hose assembly 3 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142520	136,00
	21.2	Hose assembly 4 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142522	146,00
	22.1	Water-power-cable 3.0 m long for SB/T 352/504 W		22	142524	57,00
	22.2	Water-power-cable 4.0 m long for SB/T 352/504 W		22	142526	65,00
	23.1	Wire feeding hose complete 3.0 m long for SB/T 503/504 W		22	134498	31,50
	23.2	Wire feeding hose complete 4.0 m long for SB/T 503/504 W		22	134500	32,50
	23.3	Wire feeding hose 28 red, 5.5 x 1.75 per m		22	134438	2,40
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	26.1	Cable H07V-K 1.5 mm, black per m		22	00800200	0,45
	26.2	Cable H07V-K 1.5 mm red per m		22	00800204	0,45
	27.1	Protection hose 3 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134490	39,00
	27.2	Protection hose 4 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134492	45,00
	27.3	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	6,50
	28.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	28.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	28.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	28.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	29	Bayonet ring for all torches with ball joint		22	131788	7,80
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	31	Brass neck for Euro-connection water cooled		22	02510200	29,00
	32	Kinking protection, intake water cooled		22	02510100	14,20
	33	Sleeve nut black		22	02510300	9,80
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	36	Coupling nipple for water	10 pcs	22	02510400	1,80
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	38.2	Collet for teflon liner 2.3 x 4.7	10 pcs	22	133140	2,52
	39	Ball joint connector V4		22	142302	5,90
	40	Spring for kinking protection for MIG/MAG torch watercooled		22	142286	9,80
	41	Kinking protection for MIG torches water cooled		22	02211580	9,80
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	43	Connection nipple M8x1 for water-current-cable, torch side		22	141508	10,50
	44	Blue cap for torch water connector	10 pcs	22	130959	1,80
	45	Red cap for water torch connector	10 pcs	22	130958	1,80

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Only for SB 352 W:						
	46	Cover cap for torches with ball joint		22	134496	7,68
Only for TEDAC DIGITAL:						
	47	Protective plastic glas for handle TEDAC DIGITAL torch		22	153900	7,80
	48	TEDAC DIGITAL module complete with display and control button		22	154048	209,00

Max. length of torch lead for alu: 3 m.

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.1.5. SB/SBT 504 W

MIG/MAG hand welding torch SB/SBT 504 W

water cooled

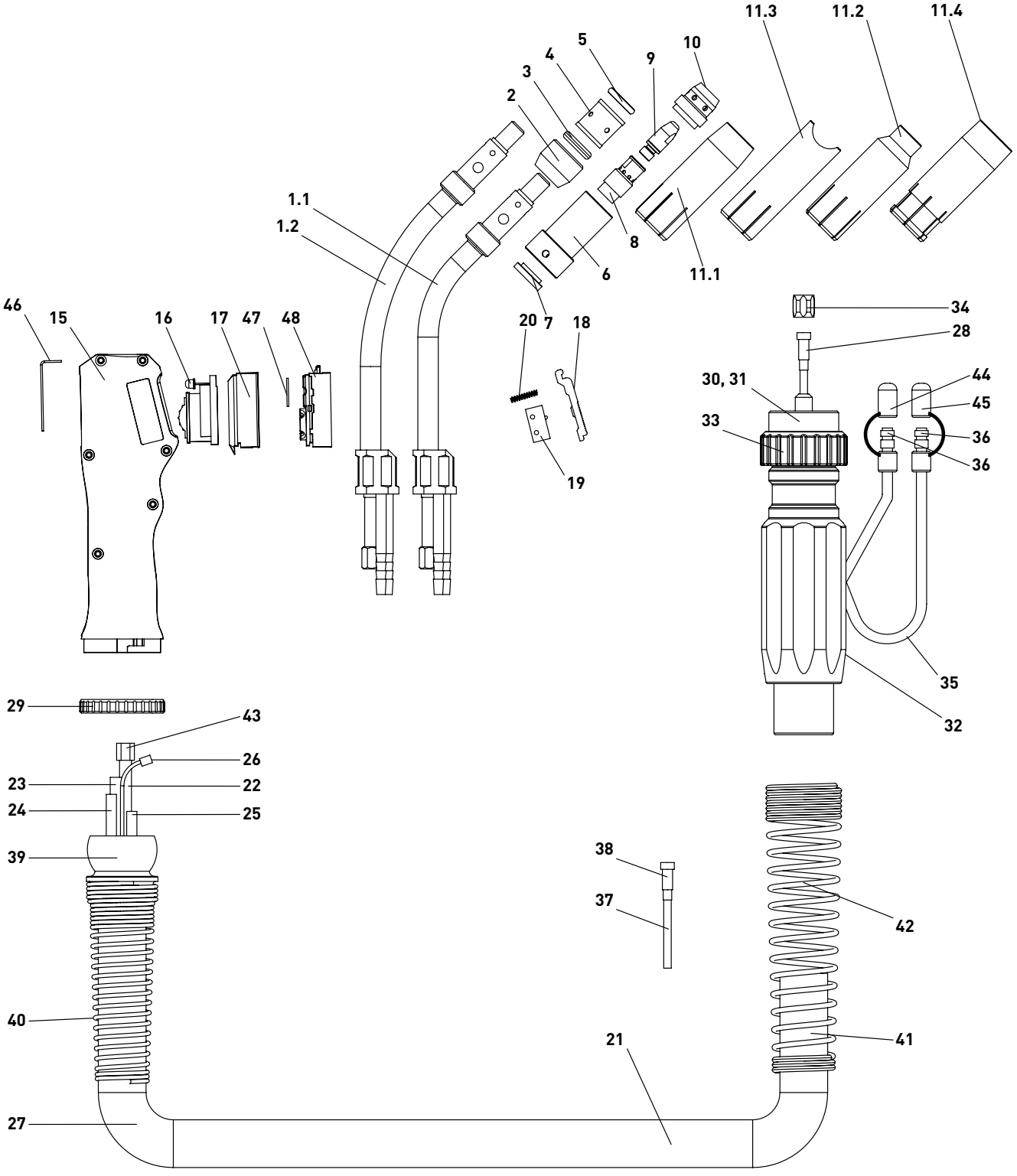
VERSIONS:

Standard

TEDAC®

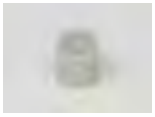
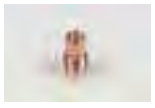
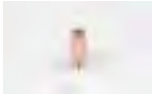
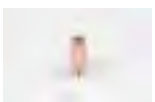
TEDAC® DIGITAL

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO_2:	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm ∅
Aluminium wire:	1.0 - 1.2 - 1.6 mm ∅
Weight:	approx. 1400 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Standard version, short torch neck:**					
	A1	MIG/MAG hand welding torch model SB 504 W, 3 m, short version		06	142494	350,00
	A2	MIG/MAG hand welding torch model SB 504 W, 4 m, short version		06	142496	360,00
	A3	MIG/MAG hand welding torch model SB 504 W, 5 m, short version		06	142666	370,00
B	**Standard version, long torch neck:**					
	B1	MIG/MAG hand welding torch model SB 504 W, 3 m, long version		06	142492	380,00
	B2	MIG/MAG hand welding torch model SB 504 W, 4 m, long version		06	142490	390,00
	B3	MIG/MAG hand welding torch model SB 504 W, 5 m, long version		06	142664	400,00
	B4	MIG/MAG hand welding torch model SB 504 W-Alu, 3 m, long version special equipment for aluminium welding		06	142670	410,00
C	**With TEDAC system, short torch neck:**					
	C1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, short vers.		06	142482	425,00
	C2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, short vers.		06	142484	435,00
	C3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, short vers.		06	142660	445,00
D	**With TEDAC system, long torch neck:**					
	D1	MIG/MAG hand welding torch TEDAC, SBT 504 W, 3 m, long vers.		06	142486	455,00
	D2	MIG/MAG hand welding torch TEDAC, SBT 504 W, 4 m, long vers.		06	142488	465,00
	D3	MIG/MAG hand welding torch TEDAC, SBT 504 W, 5 m, long vers.		06	142662	475,00
	D4	MIG/MAG hand welding torch TEDAC, SBT 504 W-Alu, 3 m, long vers. special equipment for aluminium welding		06	142672	485,00
E	**TEDAC DIGITAL, short torch neck:**					
	E1	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, short vers.		25	154244	525,00
	E2	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, short vers.		25	154248	535,00
	E3	MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 5 m, short vers.		25	154252	545,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
F	**TEDAC DIGITAL, long torch neck:**					
	F1	**MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 3 m, long vers.**		**25**	**154254**	**555,00**
	F2	**MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 4 m, long vers.**		**25**	**154260**	**565,00**
	F3	**MIG/MAG hand welding torch TEDAC DIGITAL, SBT 504 W digital, 5 m, long vers.**		**25**	**154262**	**575,00**
	Standard wire equipment: mild steel 1.2 mm					
	Spare parts and consumables:					
	1.1	Torch body complete, short version SB/SBT 504 W		22	142498	105,00
	1.2	Torch body complete, long version SB/SBT 504 W		22	142500	155,00
	2	Thread piece 503/504 W for water coat 131.280		22	131276	7,90
	3	O-ring 14 x 4	10 pcs	22	02210077	1,89
	4	Pressure bushing SB/SBT 502/503/504 W double wall	10 pcs	22	02211424	10,45
	5	O-ring 12 x 4	10 pcs	22	02210076	1,89
	6	Water coat SB503/504 W for thread piece 131.276		22	131280	11,00
	7	Isolator 503/504 W for water coat 131.280		22	131278	2,30
	8	Tip adapter SB/SBT 300/502/503/504 W	10 pcs	22	02211578	5,24
	9.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	9.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	9.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	9.4	Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	52	04511817	1,95
	9.5	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	9.6	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	9.7	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	9.8	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60
	10.1	Gas diffusor 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	7,61

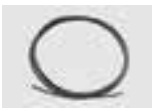
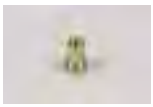
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	10.2	Gas diffusor 455/502/503/504 W, plastic	10 pcs	22	02211568	7,61
	11.1	Gas nozzle 17 mm with fastening ring	10 pcs	52	04514300	4,90
	11.2	Gas nozzle 14 mm with fastening ring	10 pcs	52	04514301	11,80
	11.3	Spot welding gas nozzle with fastening ring	10 pcs	52	04514304	15,50
	11.4	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	52	04514305	18,70
	15	Handle for MIG/MAG torch with ball joint complete set left and right incl. screws (without ball joint)		22	131272	35,00

Only for TEDAC torch:

	16	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
	17	Frame for TEDAC left and right for torches with ball joint		22	134478	7,90
	18	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	19	Micro switch for torch trigger		22	113638	8,90
	20	Spring for switch	10 pcs	22	02210131	0,85
	21.1	Hose assembly 3 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142520	136,00
	21.2	Hose assembly 4 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142522	146,00
	21.3	Hose assembly 5 m water cooled SB/T 352/504 W incl. kinking protection and ball joint, without torch head, liner, Euro connector		22	142650	156,00
	22.1	Water-power-cable 3.0 m long for SB/T 352/504 W		22	142524	57,00
	22.2	Water-power-cable 4.0 m long for SB/T 352/504 W		22	142526	65,00
	22.3	Water power cable 5.0 m long for SB/T 352/504 W		22	142656	72,00
	23.1	Wire feeding hose complete 3.0 m long for SB/T 503/504 W		22	134498	31,50

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	23.2	Wire feeding hose complete 4.0 m long for SB/T 503/504 W		22	134500	32,50
	23.3	Wire feeding hose complete 5.0 m long for SB/T 503/504 W		22	134502	34,00
	23.4	Wire feeding hose 28 red, 5.5 x 1.75 per m		22	134438	2,40
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	26.1	Cable H07V-K 1.5 mm, black per m		22	00800200	0,45
	26.2	Cable H07V-K 1.5 mm red per m		22	00800204	0,45
	27.1	Protection hose 3 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134490	39,00
	27.2	Protection hose 4 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134492	45,00
	27.3	Protection hose 5 m complete incl. ball joint, and kinking protection, for water cooled torches		22	134494	50,00
	27.4	Protection hose 25 x 1.5 black for water cooled torches, per m		22	134436	6,50
	28.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	28.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	28.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	28.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	28.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	28.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	29	Bayonet ring for all torches with ball joint		22	131788	7,80
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	31	Brass neck for Euro-connection water cooled		22	02510200	29,00
	32	Kinking protection, intake water cooled		22	02510100	14,20
	33	Sleeve nut black		22	02510300	9,80
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,20

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36	Coupling nipple for water	10 pcs	22	02510400	1,80
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	37.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	37.6	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	38.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	39	Ball joint connector V4		22	142302	5,90
	40	Spring for kinking protection for MIG/MAG torch watercooled		22	142286	9,80
	41	Kinking protection for MIG torches water cooled		22	02211580	9,80
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	43	Connection nipple M8x1 for water-current-cable, torch side		22	141508	10,50
	44	Blue cap for torch water connector	10 pcs	22	130959	1,80
	45	Red cap for water torch connector	10 pcs	22	130958	1,80

Only for SB 504 W:

	46	Cover cap for torches with ball joint		22	134496	7,68

Only for TEDAC DIGITAL:

	47	Protective plastic glas for handle TEDAC DIGITAL torch		22	153900	7,80
	48	TEDAC DIGITAL module complete with display and control button		22	154048	209,00

4.1.6. SB/SBT 603 W

MIG/MAG hand welding torch SB/SBT 603 W

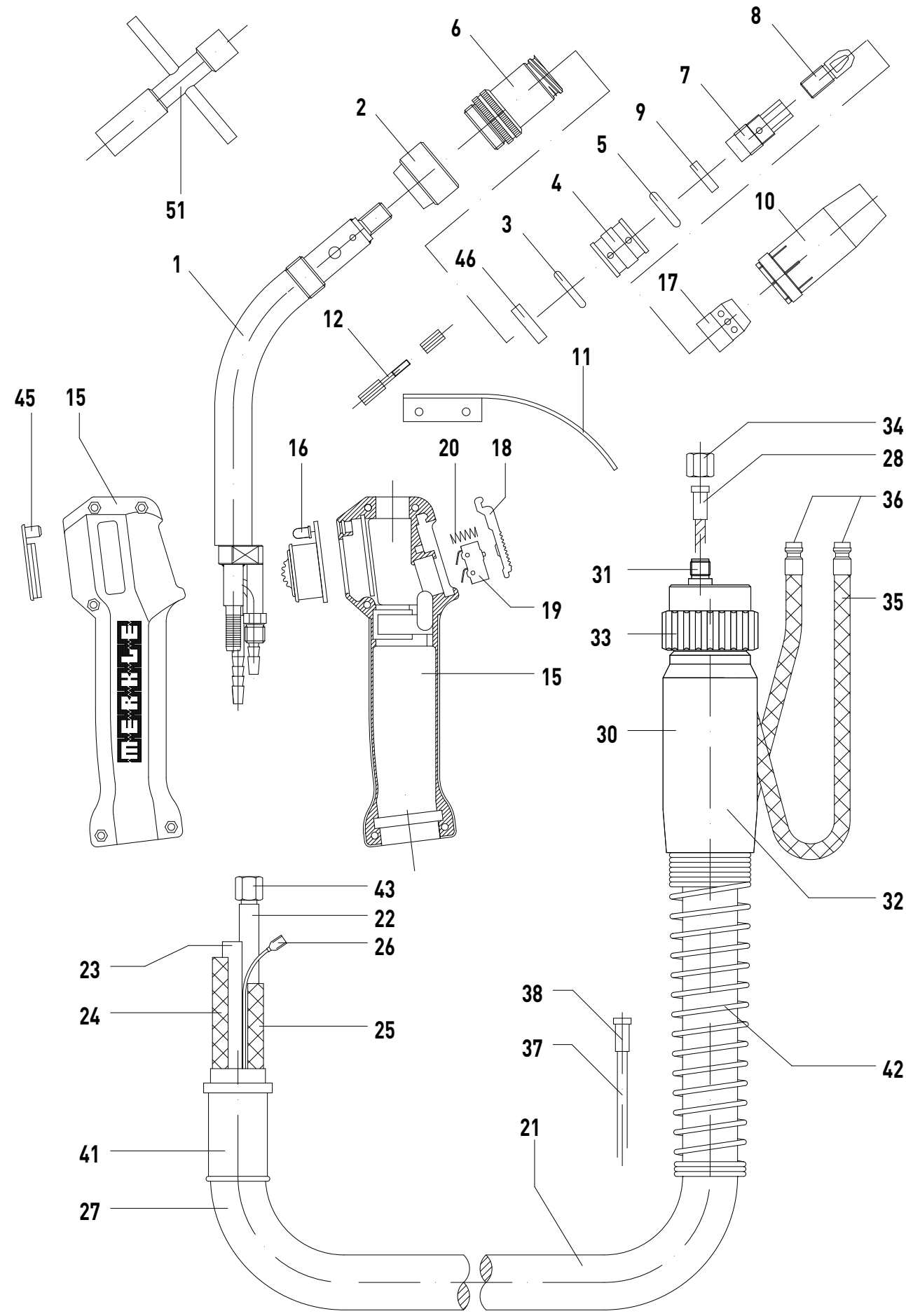
water cooled

VERSIONS:

Standard

TEDAC®

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO_2:	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1.6 mm ∅
Aluminium wire:	1.6 - 2.0 - 2.4 mm ∅
Weight:	approx. 1480 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

MIG/MAG hand welding torch SB/SBT 603 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	MIG/MAG hand welding torch model SB 603 W, 3 m		**06**	**02211790**	**450,00**
	MIG/MAG hand welding torch model SB 603 W, 4 m		**06**	**02211791**	**465,00**

	MIG/MAG hand welding torch TEDAC, model SBT 603 W, 3 m		**06**	**02211792**	**555,00**
	MIG/MAG hand welding torch TEDAC, model SBT 603 W, 4 m		**06**	**02211793**	**570,00**

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:

1	Torch neck for HSB/HSBT 600 W, short		22	02211740	140,00
2	Thread ring for ROB 504 W and SB 603 W		22	111982	9,80
3	O-ring 16 x 3.5	10 pcs	22	02211777	1,37
4	Internal sleeve 504/600/603 W	2 pcs	22	02211753	10,50
5	O-ring 14 x 4	10 pcs	22	101059	5,20
6	Water coat 504/603 W for gas nozzle 110.136		22	110138	20,90
7	Tip holder 504/603 W	2 pcs	22	108258	8,61
8.1	High performance contact tip 1.0 mm for 504/600/603	20 pcs	52	02211758	3,20
8.2	High performance contact tip 1.2 mm for 504/600/603	20 pcs	52	02211759	3,20
8.3	High performance contact tip 1.6 mm for 504/600/603	20 pcs	52	02211761	3,20
8.4	Contact tip 1.0 mm, alu for 504/600/603 W	20 pcs	52	107894	3,90
8.5	Contact tip 1.2 mm, alu for 504/600/603 W	20 pcs	52	107896	3,90
8.6	Contact tip 1.6 mm, alu for 504/600/603 W	20 pcs	52	107898	3,90
9	Ceramic ring 504/603 W	2 pcs	22	02210340	2,70
10	Gas nozzle d = 17 mm, l = 67 mm standard B 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	110136	14,80
11	Hand protection shield		22	02210850	21,00
12	Kit for mounting hand protection		22	02210851	11,00

15	Handle for MIG/MAG torch without ball joint complete set left and right incl. screws		22	142536	29,00

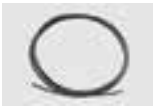
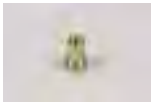
Only for SBT 603 W:

16	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
17	Gas diffusor 504/300/603 W ceramic	5 pcs	22	107966	4,50

18	Trigger for MIG/MAG torch (red)		22	02210796	8,70

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	19	Micro switch for torch trigger		22	113638	8,90
	20	Spring for switch	10 pcs	22	02210131	0,85
	21.1	Complete cable assembly, w.c. 3 m, with Euro-connector, without torch, without liner		22	130012	129,00
	21.2	Complete cable assembly, w. c. 4 m, with Euro-connector, without torch, without liner		22	130014	139,00
	22.1	Water-power-cable 3.0 m long SB 502/603/455/450/350		22	02210281	48,00
	22.2	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	56,00
	23.1	Wire feeding hose cpl. 3.0 m long		22	02211662	31,50
	23.2	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	35,00
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	26.1	Switch-cable, 3 m long		22	02210148	21,00
	26.2	Switch-cable, 4 m long		22	02210149	23,00
	27	Protective hose 28 x 1,5 black		22	00600405	6,90
	28.1	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	28.2	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	28.3	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	28.4	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	31	Brass neck for Euro-connection water cooled		22	02510200	29,00
	32	Kinking protection, intake water cooled		22	02510100	14,20
	33	Sleeve nut black		22	02510300	9,80
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,20

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36	Coupling nipple for water	10 pcs	22	02510400	1,80
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	37.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	37.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	38.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	41	Kinking protection for MIG torches water cooled		22	02211580	9,80
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	43	Connection nipple for water-current-cable, torch side		22	04510201	5,36

Only for SB 603 W:

	45	Cover cap for TEDAC handle		22	02210604	3,90
	46	Distance ring 21,8 x 5,5 504/603 W		22	02211815	2,15
	51	Key for 504/600/603 W		22	01370043	23,00

Spare parts kit:

	52	**Spare parts kit for SB/T 603 W**		**22**	**02211720**	**310,00**

with following parts:

		Thread ring for ROB 504 W and SB 603 W		22	111982	9,80
		O-ring 16 x 3.5	10 pcs	22	02211777	1,37
		O-ring 14 x 4	10 pcs	22	02210077	1,89
		Internal sleeve 504/600/603 W	2 pcs	22	02211753	10,50
		Tip holder 504/603 W	2 pcs	22	108258	8,61
		Ceramic ring 504/603 W	2 pcs	22	02210340	2,70
		Gas diffusor 504/300/603 W ceramic	5 pcs	22	107966	4,50

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	High performance contact tip 1.0 mm for 504/600/603	20 pcs	52	02211758	3,20
	High performance contact tip 1.2 mm for 504/600/603	20 pcs	52	02211759	3,20
	Gas nozzle d = 17 mm, l = 67 mm standard B 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	110136	14,80

Max. length of torch lead for alu: 3 m.

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.1.7. HSB/HSBT 600 W

MIG/MAG hand welding torch HSB/HSBT 600 W

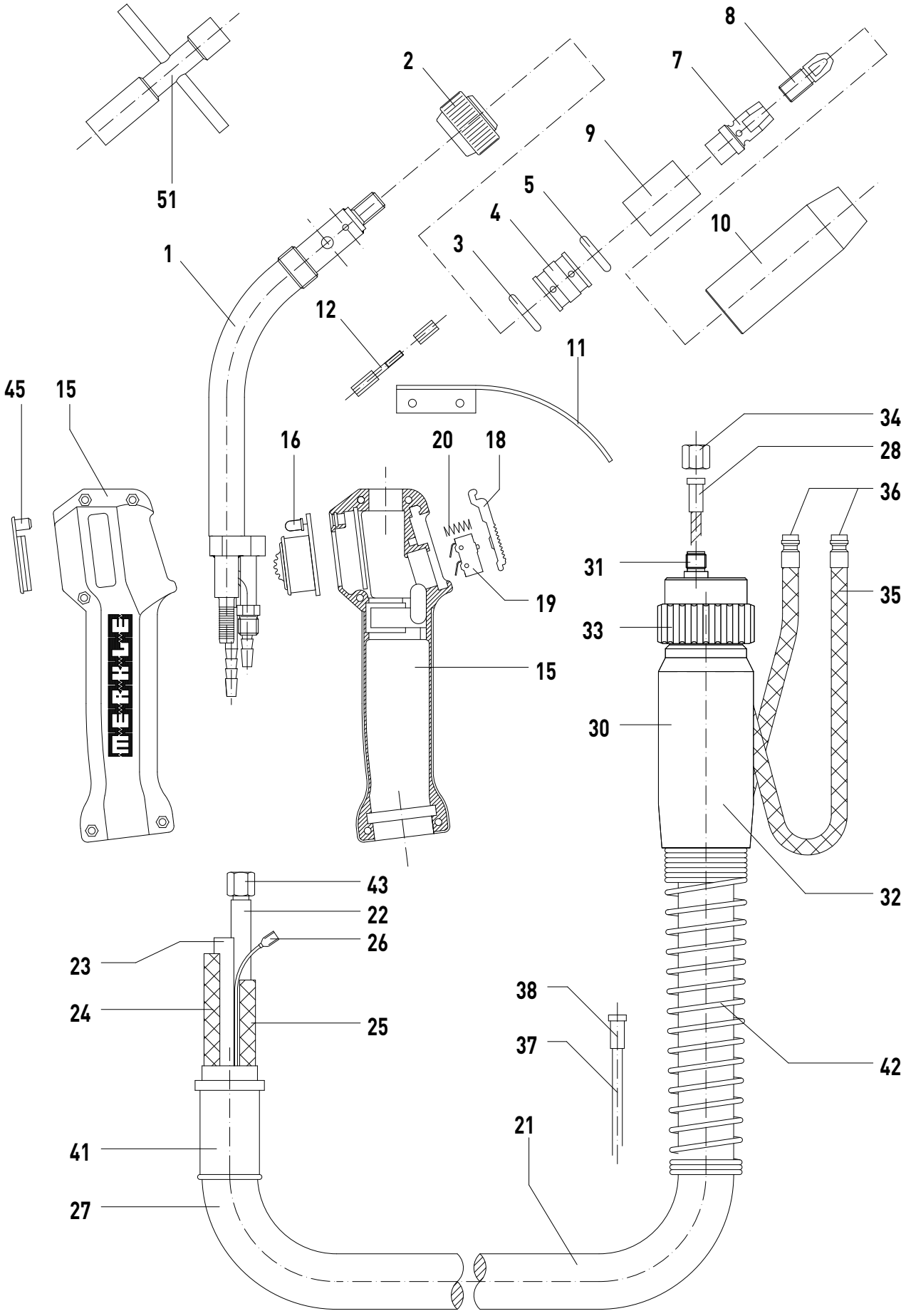
water cooled, high performance gas nozzle

VERSIONS:

Standard

TEDAC®

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO_2:	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1. 6 mm ∅
Weight:	approx. 1480 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	

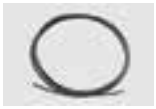
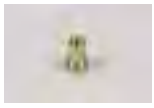


All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG hand welding torch HSB/HSBT 600 W						
		High performance MIG/MAG hand torch model HSB 600 W, 3 m, long version with high performance gas nozzle		**06**	**02211731**	**520,00**
		High performance MIG/MAG hand torch model HSB 600 W, 4 m, long version with high performance gas nozzle		**06**	**02211732**	**535,00**
		High performance MIG/MAG hand torch TEDAC, HSBT 600 W, 3 m, long vers. with high performance gas nozzle		**06**	**02211734**	**625,00**
		High performance MIG/MAG hand torch TEDAC, HSBT 600 W, 4 m, long vers. with high performance gas nozzle		**06**	**02211735**	**640,00**
Standard wire equipment: mild steel 1.2 mm						
Spare parts and consumables:						
	1	Torch neck for HSB/HSBT 600 W, short		22	02211740	140,00
	2	Fastening ring for HSB/HSBT 600 W		22	02211752	7,88
	3	O-ring 16 x 3.5	10 pcs	22	02211777	1,37
	4	Internal sleeve 504/600/603 W	2 pcs	22	02211753	10,50
	5	O-ring 14 x 4	10 pcs	22	101059	5,20
	7	Tip holder HSB 600 W (and 603 old)	2 pcs	22	02211755	8,61
	8.1	High performance contact tip 1.0 mm for 504/600/603	20 pcs	52	02211758	3,20
	8.2	High performance contact tip 1.2 mm for 504/600/603	20 pcs	52	02211759	3,20
	8.3	High performance contact tip 1.6 mm for 504/600/603	20 pcs	52	02211761	3,20
	9	Insulation sleeve	2 pcs	22	02211763	11,55
	10.1	Gas nozzle 17 mm (short 85 mm) HSB 600, high performance vers.	3 pcs	52	02211765	68,00
	10.2	Gas nozzle 17 mm (long 90 mm) HSB 600, high performance vers.		52	02211769	66,00
	11	Hand protection shield		22	02210850	21,00
	12	Kit for mounting hand protection		22	02210851	11,00
	15	Handle for MIG/MAG torch without ball joint complete set left and right incl. screws		22	142536	29,00
Only for HSBT 600 W:						
	16	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
	18	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	19	Micro switch for torch trigger		22	113638	8,90
	20	Spring for switch	10 pcs	22	02210131	0,85

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	21.1	Complete cable assembly, w.c. 3 m, with Euro-connector, without torch, without liner		22	130012	129,00
	21.2	Complete cable assembly, w. c. 4 m, with Euro-connector, without torch, without liner		22	130014	139,00
	22.1	Water-power-cable 3.0 m long SB 502/603/455/450/350		22	02210281	48,00
	22.2	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	56,00
	23.1	Wire feeding hose cpl. 3.0 m long		22	02211662	31,50
	23.2	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	35,00
	24	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	25	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	26.1	Switch-cable, 3 m long		22	02210148	21,00
	26.2	Switch-cable, 4 m long		22	02210149	23,00
	27	Protective hose 28 x 1,5 black		22	00600405	6,90
	28.1	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	28.2	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	28.3	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	28.4	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	30	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	31	Brass neck for Euro-connection water cooled		22	02510200	29,00
	32	Kinking protection, intake water cooled		22	02510100	14,20
	33	Sleeve nut black		22	02510300	9,80
	34	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	35	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	36	Coupling nipple for water	10 pcs	22	02510400	1,80
	37.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	37.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	37.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	37.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	37.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	37.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	38.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	38.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	41	Kinking protection for MIG torches water cooled		22	02211580	9,80
	42	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	43	Connection nipple for water-current-cable, torch side		22	04510201	5,36

Only for HSB 600 W:

	45	Cover cap for TEDAC handle		22	02210604	3,90
	51	Key for 504/600/603 W		22	01370043	23,00

Spare parts kit:

	52	**Spare part box for HSB/HSBT 600 W**		**22**	**02211737**	**250,00**

with following parts:

	1 Stk	Fastening ring for HSB/HSBT 600 W		22	02211752	7,88
	10 Stk	O-ring 16 x 3.5		22	02211777	1,37
	10 Stk	O-ring 14 x 4		22	02210077	1,89
	1 Stk	Internal sleeve 504/600/603 W		22	02211753	10,50
	2 Stk	Tip holder HSB 600 W (and 603 old)		22	02211755	8,61
	2 Stk	Insulation sleeve		22	02211763	11,55
	10 Stk	High performance contact tip 1.0 mm for 504/600/603		52	02211758	3,20
	10 Stk	High performance contact tip 1.2 mm for 504/600/603		52	02211759	3,20
	3 Stk	Gas nozzle 17 mm (short 85 mm) HSB 600, high performance vers.		52	02211765	68,00

4.2. Fume extraction welding torches

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.2.1. RSB/RSBT 351 G

MIG/MAG fume extraction torch RSB/RSBT 351 G

gas cooled

VERSIONS:

Standard

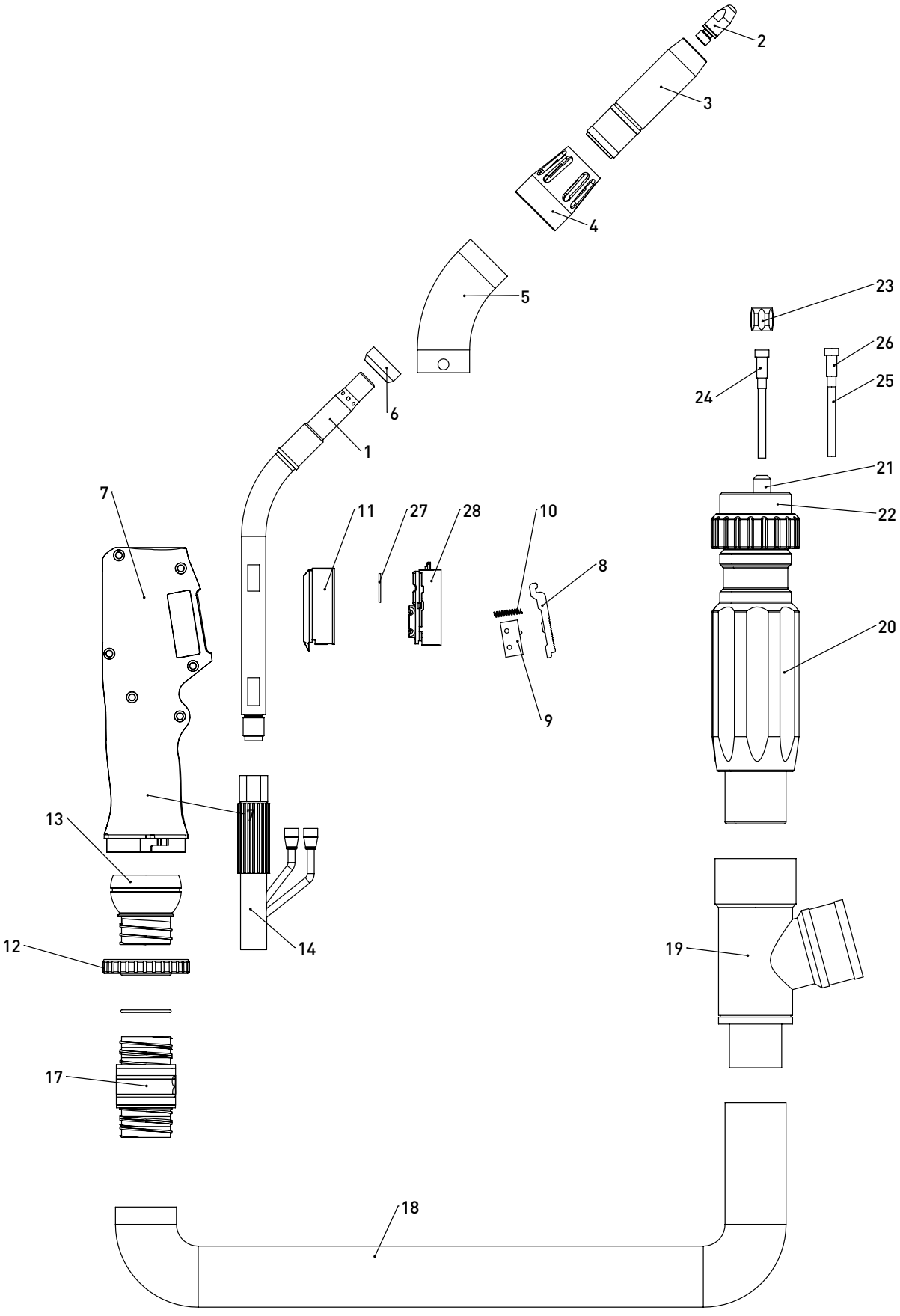
TEDAC®

TEDAC® DIGITAL

TECHNICAL DATA:	
Cooling:	gas cooled
Mixed gas:	250 A 60% duty cycle
CO_2:	280 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm ∅
Aluminium wire:	0.8 - 1.0 - 1.2 mm ∅
The data are corresponding to (U = 14 + 0.05 x I)	

- Integrated TEDAC system for remote control and display
- Extremely slim torch body: outer tube only 30 mm, fume nozzle only 32 mm diameter
- High fume extraction performance
- Same spare parts and consumables as SB/SBT 351 G
- TEDAC slide switch mounted in totally closed area
- High flexibility of the hose package due to ball joint
- Bypass control for adjustment of the vacuum

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020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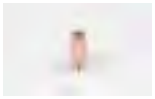
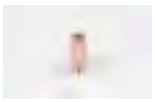
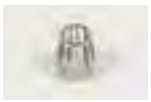
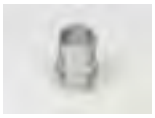
MIG/MAG fume extraction torch RSB/RSBT 351 G

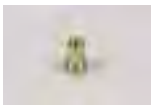
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		Fume extraction torch model RSB 351 G, 3 m		**11**	**129270**	**425,00**
		Fume extraction torch model RSB 351 G, 4 m		**11**	**129272**	**460,00**
		Fume extraction torch TEDAC, model RSBT 351 G, 3 m		**11**	**129276**	**520,00**
		Fume extraction torch TEDAC, model RSBT 351 G, 4 m		**11**	**129278**	**555,00**
TEDAC® digital		**Option torch with TEDAC DIGITAL system when not using standard TEDAC torch for HighPULSE and SpeedMIG**		**25**	**155840**	**100,00**

Spare parts and consumables:

	1	Torch neck RSB/T 351 G		53	130322	82,00
	2.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	2.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	2.2	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	2.3	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	2.4	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	2.5	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	2.6	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60
	3	Gas nozzle 15 mm SB/T, RSB/T 351 G with thread and insulation		52	104170	9,80
	4	Fume extraction nozzle RSB/T 351 G		53	129074	23,50
	5	Fume extraction tube FT RSB/T 351 G		53	129094	59,00
	6	Isolation piece RSB/T 351 G		53	129080	5,20
	7	Handle fume extraction torch left and right		53	130320	112,00
	8	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	9	Micro switch for torch trigger		22	113638	8,90
	10	Spring for switch	10 pcs	22	02210131	0,85

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Only for RSBT 351 G:						
	11	TEDAC pcb incl. slide switch and frame for RSBT 351/503		53	131274	125,00
	12	Bajonet ring RSB/T		53	129636	13,80
	13	Ball joint connection RSB/T 351 G		53	129638	13,50
Only for RSB 351 G:						
	15	Cover cap for RSB torches with ball joint		53	131996	8,90
	16	Closing ring RSB/T 351 G		53	129650	9,80
	17.1	Bypass piece complete RSB/T 351 G		53	132594	48,00
	17.2	Bypass piece for RSB/T 351 G		53	130962	39,00
	17.3	Bypass controller ring RSB/T 351 G		53	130964	19,80
	18.1	Fume extraction hose D=29 mm (per m)		53	129626	39,00
	18.2	Coax cable, 3 m, 35 mm², for RSB/T 351 G		22	130968	96,00
	18.3	Coax cable, 4 m, 35 mm², for RSB/T 351 G		22	130982	109,00
	18.4	Coax cable, 5 m, 35 mm², for RSB/T 351 G		22	131560	122,00
	19	T-connector RSB/RSBT D=38 mm		53	103635	47,00
	20.1	Central connector MAG,gas cooled brass body, sleeve nut 3-part. kink protection		22	02511350	39,00
	20.2	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	21	Brass body central connector MAG gas cooled		22	02511401	21,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	22	Sleeve nut black		22	02510300	9,80
	23	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	24.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	24.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	24.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	24.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	25.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	25.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	25.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	25.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	26.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	26.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52

Only for TEDAC DIGITAL:

	27	Protective plastic glas for handle TEDAC DIGITAL torch		22	153900	7,80
	28	TEDAC DIGITAL module complete with display and control button		22	154048	209,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.2.2. RSB/RSBT 503 W

MIG/MAG fume extraction torch RSB/RSBT 503 W

water cooled

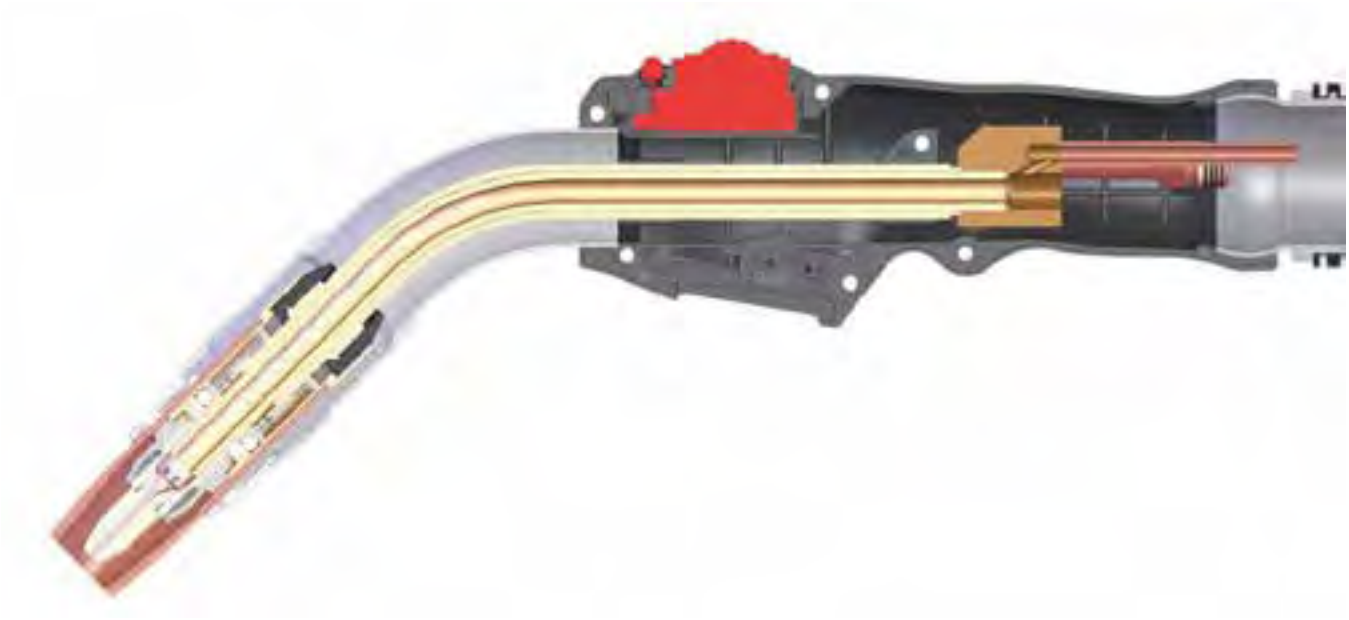
VERSIONS:

Standard

TEDAC®

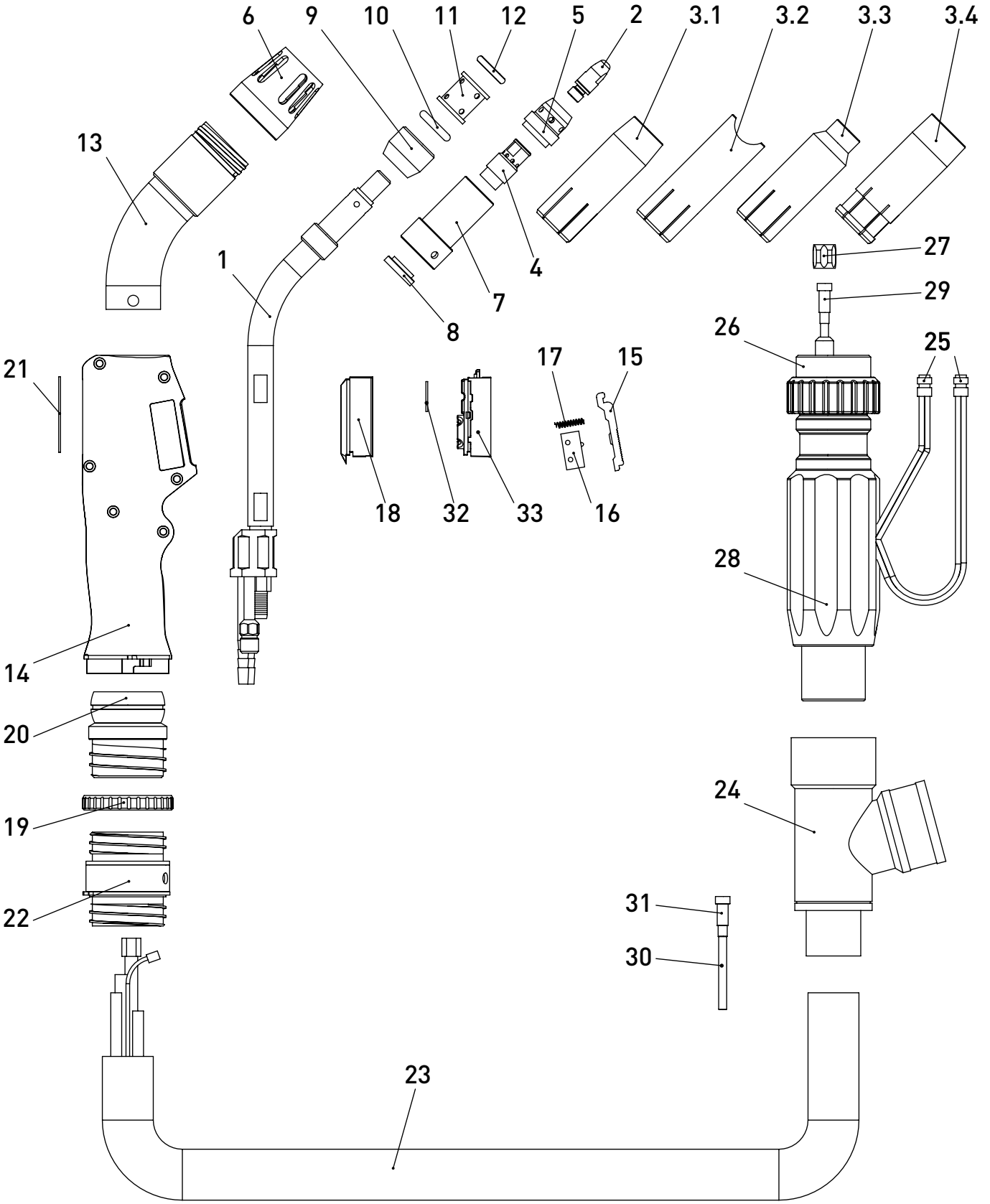
TEDAC® DIGITAL

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO_2:	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm ∅
Aluminium wire:	1.0 - 1.2 - 1.6 mm ∅
The data are corresponding to (U = 14 + 0.05 x I)	



- Integrated TEDAC system for remote control and display
- Extremely slim torch body: outer tube only 34 mm,
  fume nozzle only 36 mm diameter
- High fume extraction performance
- Same spare parts and consumables as SB/SBT 503 W
- TEDAC slide switch mounted in totally closed area
- High flexibility of the hose package due to ball joint
- Bypass control for adjustment of the vacuum

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020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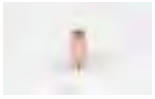
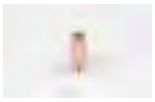
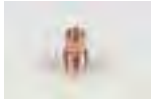
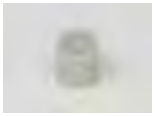
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG fume extraction torch RSB/RSBT 503 W						
		Fume extraction torch model RSB 503 W, 3 m		**11**	**131422**	**578,00**
		Fume extraction torch model RSB 503 W, 4 m		**11**	**131424**	**608,00**
		Fume extraction torch TEDAC, model RSBT 503 W, 3 m		**11**	**131426**	**673,00**
		Fume extraction torch TEDAC, model RSBT 503 W, 4 m		**11**	**131428**	**703,00**
TEDAC® DIGITAL		**Option torch with TEDAC DIGITAL system when not using standard TEDAC torch for HighPULSE and SpeedMIG**		**25**	**155840**	**100,00**
Standard wire equipment: mild steel 1.2 mm						
Spare parts and consumables:						
	1	Torch body RSB/T 503 W		53	131786	99,00
	2.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	2.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	2.2	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	2.3	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	2.4	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	2.5	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	2.6	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60
	3.1	Gas nozzle 17 mm with fastening ring	10 pcs	52	04514300	4,90
	3.2	Spot welding gas nozzle with fastening ring	10 pcs	52	04514304	15,50
	3.3	Gas nozzle 14 mm with fastening ring	10 pcs	52	04514301	11,80
	3.4	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	52	04514305	18,70
	4	Tip adapter SB/SBT 300/502/503/504 W	10 pcs	22	02211578	5,24
	5.1	Gas diffusor 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	7,61
	5.2	Gas diffusor 455/502/503/504 W, plastic	10 pcs	22	02211568	7,61

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	6	Fume extraction nozzle RSB/T 503 W		53	130992	23,50
	7	Water coat SB503/504 W for thread piece 131.276		22	131280	11,00
	8	Isolator 503/504 W for water coat 131.280		22	131278	2,30
	9	Thread piece 503/504 W for water coat 131.280		22	131276	7,90
	10	O-ring 14 x 4	10 pcs	22	02210077	1,89
	11	Pressure bushing SB/SBT 502/503/504 W double wall	10 pcs	22	02211424	10,45
	12	O-ring 12 x 4	10 pcs	22	02210076	1,89
	13	Fume extraction tube RSB/T 503 W		53	130990	65,00
	14	Handle fume extraction torch left and right		53	130320	112,00
	15	Trigger for MIG/MAG torch (red)		22	02210796	8,70
	16	Micro switch for torch trigger		22	113638	8,90
	17	Spring for switch	10 pcs	22	02210131	0,85

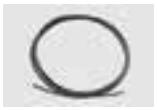
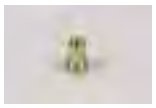
Only for RSBT 503 W:

	18	TEDAC pcb incl. slide switch and frame for RSBT 351/503		53	131274	125,00
	19	Bajonet ring RSB/T		53	129636	13,80
	20	Ball joint connection RSB/T 503 W		53	131778	13,50

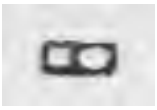
Only for RSB 503 W:

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	21	Cover cap for RSB torches with ball joint		53	131996	8,90
	22.1	Bypass piece complete RSB/T 503 W		53	132596	44,00
	22.2	Bypass piece for RSB/T 503 W		53	131196	39,00
	22.3	Bypass controller ring RSB/T 503 W		53	131194	5,20
	23.1	Fume extraction hose 38 mm (per m)		22	103634	58,00
	23.2	Complete cable assembly, RSB/T 503 W 3 m, with Euro-connector, without torch, without liner		53	108836	358,00
	23.3	Complete cable assembly, RSB/T 503 W 4 m, with Euro-connector, without torch, without liner		53	110328	418,00
	24	T-connector RSB/RSBT D=38 mm		53	103635	47,00
	25	Coupling nipple for water	10 pcs	22	02510400	1,80
	26	Brass neck for Euro-connection water cooled		22	02510200	29,00
	27	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	28	Kinking protection, intake water cooled		22	02510100	14,20
	29.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	29.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	29.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	29.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	29.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	29.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	30.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	30.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	30.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	30.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	30.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	30.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	31.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	31.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52

Only for TEDAC DIGITAL:

	32	Protective plastic glas for handle TEDAC DIGITAL torch		22	153900	7,80
	33	TEDAC DIGITAL module complete with display and control button		22	154048	209,00

4.3. Push-Pull welding torches

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.3.1. PP/PPT 307 G

MIG/MAG Push-Pull torch PP/PPT 307 G

gas cooled

45° bent

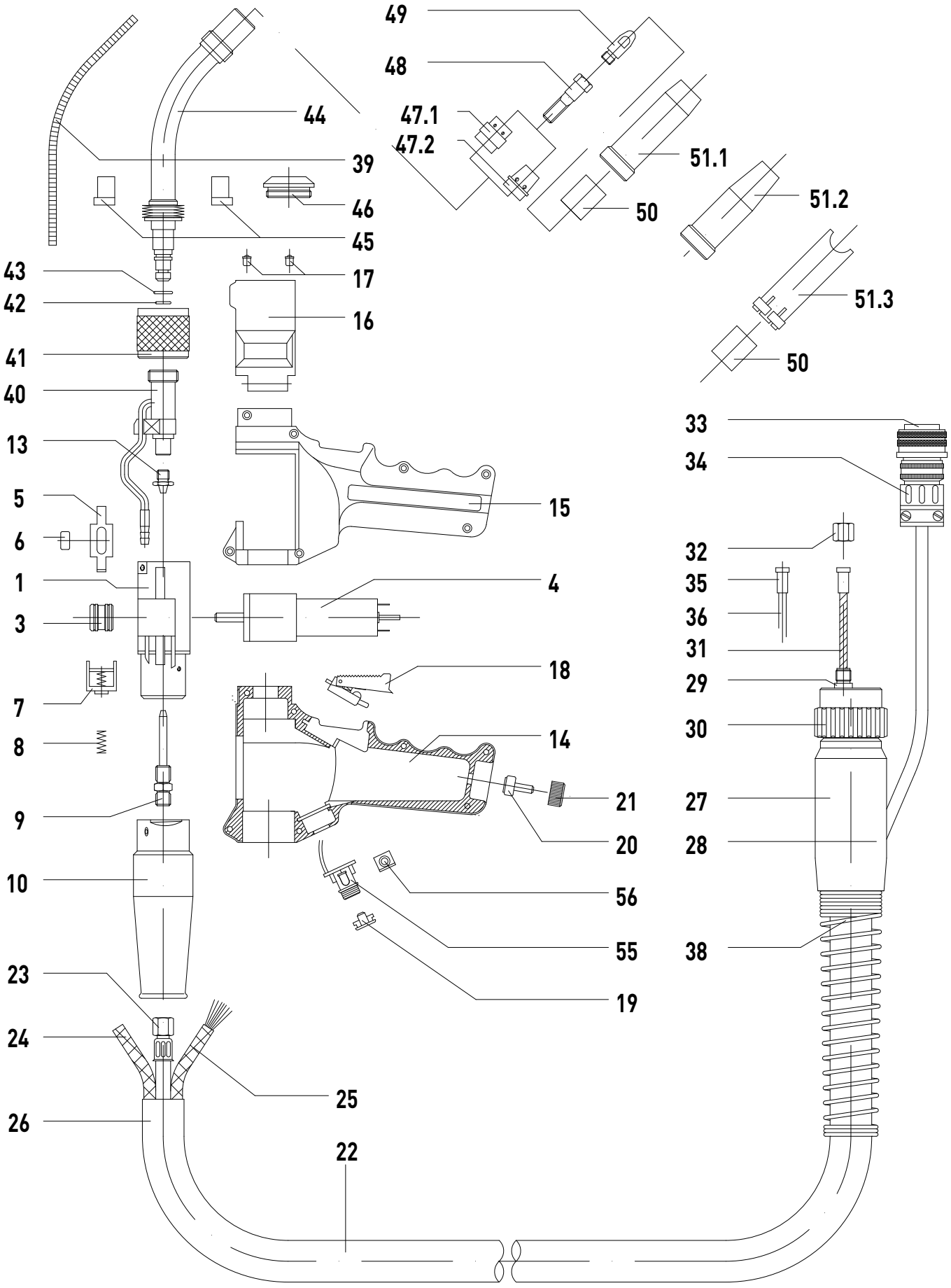
22° bent

VERSIONS:

Standard

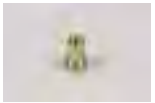
TEDAC®

TECHNICAL DATA:	
Cooling:	gas cooled
Mixed gas:	280 A 60% duty cycle
CO_2:	300 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 mm ∅
Aluminium wire:	0.8 - 1.0 - 1.2 mm ∅
Weight:	approx. 1200 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	

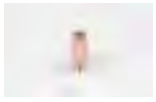
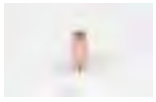
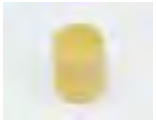
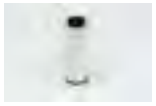
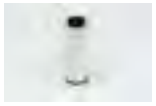


All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG-Push-Pull welding torch PP/PPT 307 G						
		Push pull hand welding torch model PP 307 G, 22° bent, 8 m with rotatable torch head		**12**	**02110292**	**1.790,00**
		Push pull hand welding torch model PP 307 G, 45° bent, 8 m with rotatable torch head		**12**	**02110293**	**1.790,00**
		Push pull hand welding torch TEDAC, PPT 307 G, 22° bent, 8 m, with rotatable torch head		**12**	**02110294**	**1.990,00**
		Push pull hand welding torch TEDAC, PPT 307 G, 45° bent, 8 m, with rotatable torch head		**12**	**02110295**	**1.990,00**
Standard wire equipment: mild steel 1.0 mm						
Spare parts and consumables:						
	1	Motor-block PP torch		53	02110151	98,00
	3.1	Wire feeding roller st. 0.8 mm (PP)		53	02110251	36,00
	3.2	Wire feeding roller st. 1.0 mm (PP)		53	02110252	36,00
	3.3	Wire feeding roller st. 1.2 mm (PP)		53	02110253	36,00
	3.4	Wire feeding roller alu 0.8 mm (PP)		53	02110255	36,00
	3.5	Wire feeding roller alu 1.0 mm (PP)		53	02110256	36,00
	3.6	Wire feeding roller alu 1.2 mm (PP)		53	02110257	36,00
	4	Wire feeding motor, PP-torch		53	02110272	850,00
	5	Pressure bracket PPL/PPW		53	02110160	18,00
	6	Pressure roller PPL/PPW		53	02110170	22,00
	7	Pressure bracket complete		53	02110181	79,00
	8	Spring DFO, 7x4, 3x9, 3x4x1.12 for fastening yoke 021.1.0181		53	02110182	2,10
	9	Motor block/feed Insertion nozzle PP 307/502		53	02110190	14,90
	10	Kinking protection		53	02110279	22,00
	13	Nozzle (outgoing) PP 307/502		53	02110205	12,20
	14, 15	Handle for Push-Pull hand welding torch PP/T 307 and PP/T 502 with fixed torch body, left and right side		53	134468	130,00
	16	Cover for PP torch		53	02110237	26,25

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	17	Spring lock		53	02110185	2,50
	18	Torch interruptor		53	02110335	18,90
	19	Cover cap for TEDAC handle		22	02210604	3,90
	20	Variable resistor PP-torch		53	00100506	39,90
	21	Turn-knob		53	00301508	10,00
	22	Torch lead cpl. 8 m, PP/PPT 307 without torch, with Euro-connector		53	02110119	355,00
	23	Coax cable, cpl. 8 m, PP-torch		22	02110288	185,00
	24	Gas hose 8 m		22	02110260	
	25	Control cable 7 x 0.75 LIYY		22	02110331	2,94
	26	Protective hose 28 x 1,5 black		22	00600405	6,90
	27	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	28	Kinking protection, intake water cooled		22	02510100	14,20
	29	Brass body central connector MAG gas cooled		22	02511401	21,00
	30	Sleeve nut black		22	02510300	9,80
	31	Liner for steel uncoated 2,5 x 4,5 0.6 -1.6 mm, 8 m long		53	02110325	10,40
	32	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	33	Socket 10-pole (-) (for push pull torch)		53	02110384	33,50
	34	Cable support for 10 pol. plug		07	02110388	19,00
	35	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	36	Teflon liner 2.0 x 4.0 Alu/stainl. steel 0.8 - 1.6 mm, 8 m		22	02110326	37,80
	38	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	39	Brass liner 0.2 m, (2.0 x 4.0)		22	107810	3,78
	40	Torch neck support		53	02110020	72,45
	41	Sleeve		53	02110021	16,64
	42	O-ring 7.5 x 1.5, PP-torch 307		53	02110022	1,42
	43	O-ring 9.5 x 1.5, PP-torch 307		53	02110023	1,94

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	44.1	Torch neck PP/PPT 307, 22°, cpl.		53	02110024	106,05
	44.2	Torch neck PP/PPT 307 G, 45°		53	02110025	106,05
	45	Bearing bush, seperated, PP 307		53	02110026	6,50
	46	Thread sleeve, PP 307		53	02110027	10,66
	47.1a	Gas diffusor SB/SBT 307 G ceramic spatter resistent	20 pcs	22	02210219	6,90
	47.1b	Gas diffusor SB/T 307 G plastic, black, for gas nozzle 022.1.0267, 022.1.0310	10 pcs	22	02210222	5,70
	47.2	Gas diffusor SB/T 307 G, plastic for gas nozzle 111.462	10 pcs	22	111938	12,00
	48	Tip adapter, SB 307 G, 38 mm	10 pcs	22	02210217	3,90
	49.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	49.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	49.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	49.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	49.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	49.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	50	Insulation ring SB 300/307	20 pcs	22	02210369	2,25
	51.1	Gas nozzle SB/SBT 300/307, with thread		52	02210267	8,90
	51.2	Gas nozzle 12 mm screw fixing (only with gas diffusor 111.938)	10 pcs	52	111462	18,30
	51.3	Spot welding gas nozzle 300/307 with fastening ring		52	02210310	9,30
	55	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
	56	Insertion element		53	02110337	5,00

4.3.2. PP/PPT 502 W

MIG/MAG Push-Pull torch PP/PPT 502 W

water cooled

45° bent

straight

45° bent with rotatable torch head

VERSIONS:

Standard

TEDAC®

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	400 A 60% duty cycle
CO_2:	450 A 60% duty cycle
Solid wire:	0.8 - 1.0 - 1.6 mm ∅
Aluminium wire:	0.8 - 1.0 - 1.6 mm ∅
Weight:	approx. 1850 g/1 m H
The data are corresponding to (U = 14 + 0.05 x I)	

All prices per piece plus VAT and material surcharge.
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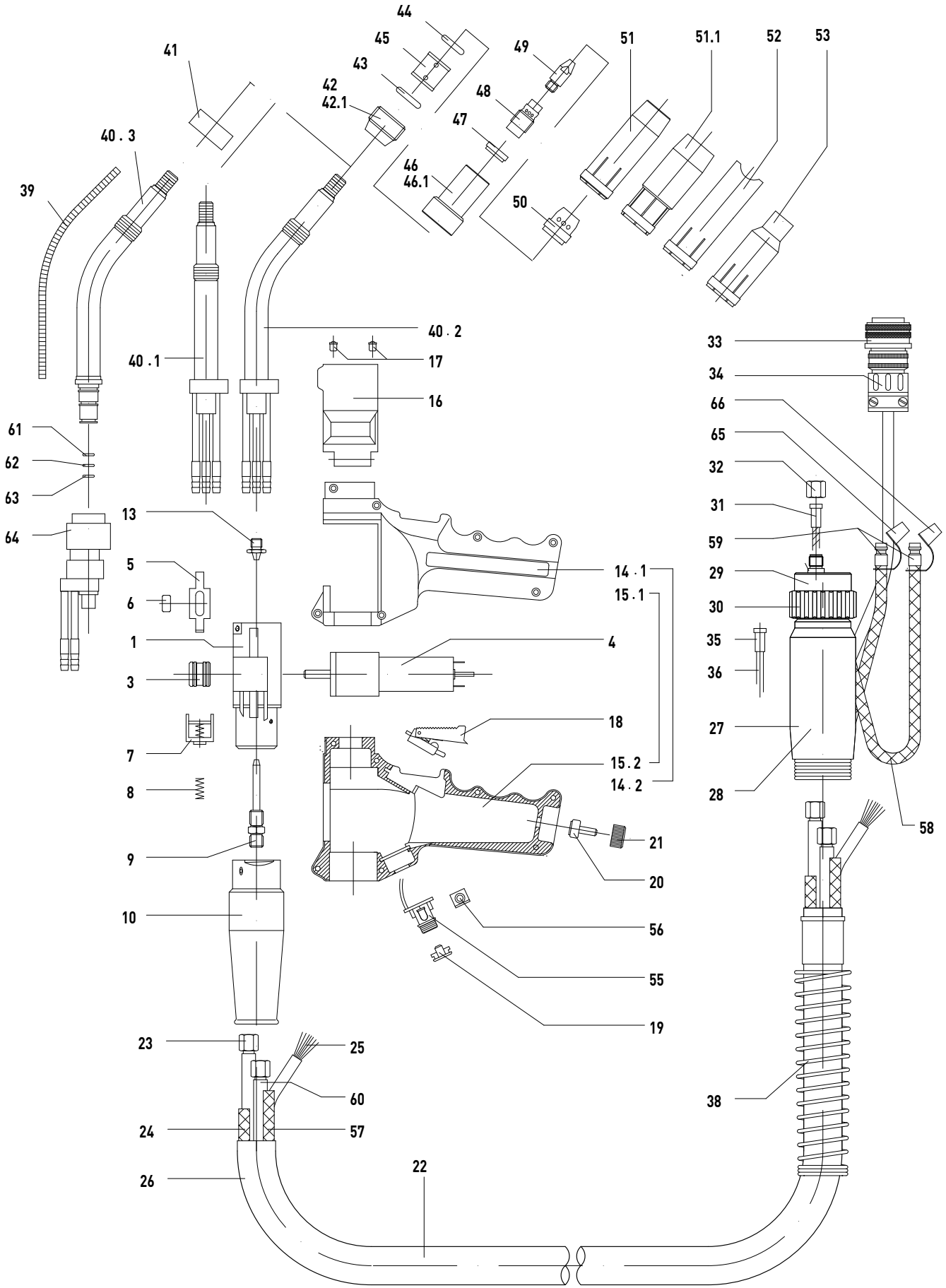
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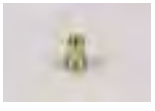
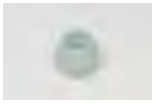
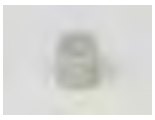
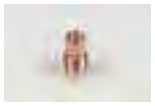
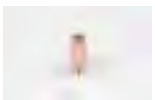
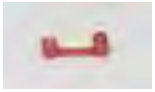
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG-Push-Pull welding torch PP/PPT 502 W						
		Push pull hand welding torch model PP 502 W, straight, 8 m		**12**	**02110296**	**1.890,00**
		Push pull hand welding torch model PP 502 W, 45° bent, 8 m		**12**	**02110297**	**1.890,00**
		Push pull hand welding torch TEDAC, PPT 502 W, straight, 8 m		**12**	**02110298**	**2.090,00**
		Push pull hand welding torch TEDAC, PPT 502 W, 45° bent, 8 m		**12**	**02110299**	**2.090,00**
With rotatable torch head:						
		Push-Pull hand welding torch model PP 504 W, 45° bent, 8 m with rotatable torch head		**12**	**131789**	**2.090,00**
		Push-Pull hand welding torch TEDAC, model PPT 504 W, 45 ° bent, 8 m with rotatable torch head		**12**	**131790**	**2.290,00**
Standard wire equipment: mild steel 1.0 mm						
Spare parts and consumables:						
	1	Motor-block PP torch		53	02110151	98,00
	3.1	Wire feeding roller st. 0.8 mm (PP)		53	02110251	36,00
	3.2	Wire feeding roller st. 1.0 mm (PP)		53	02110252	36,00
	3.3	Wire feeding roller st. 1.2 mm (PP)		53	02110253	36,00
	3.4	Wire feeding roller st. 1.6 mm (PP)		53	02110254	36,00
	3.5	Wire feeding roller alu 0.8 mm (PP)		53	02110255	36,00
	3.6	Wire feeding roller alu 1.0 mm (PP)		53	02110256	36,00
	3.7	Wire feeding roller alu 1.2 mm (PP)		53	02110257	36,00
	4	Wire feeding motor, PP-torch		53	02110272	850,00
	5	Pressure bracket PPL/PPW		53	02110160	18,00
	6	Pressure roller PPL/PPW		53	02110170	22,00
	7	Pressure bracket complete		53	02110181	79,00
	8	Spring DFO, 7x4, 3x9, 3x4x1.12 for fastening yoke 021.1.0181		53	02110182	2,10
	9	Motor block/feed Insertion nozzle PP 307/502		53	02110190	14,90

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	10	Kinking protection		53	02110279	22,00
	13	Nozzle (outgoing) PP 307/502		53	02110205	12,20
	14	Handle for Push-Pull hand welding torch PP/T 307 and PP/T 502 with fixed torch body, left and right side		53	134468	130,00
	15	Handle for Push-Pull hand welding torch PP/T 502 with rotatable torch body, left and right side		53	134472	165,00
	16	Cover for PP torch		53	02110237	26,25
	17	Spring lock		53	02110185	2,50
	18	Torch interruptor		53	02110335	18,90
	19	Cover cap for TEDAC handle		22	02210604	3,90
	20	Variable resistor PP-torch		53	00100506	39,90
	21	Turn-knob		53	00301508	10,00
	22	Torch lead cpl. 8 m, PP/PPT 502 without torch, without Euro-connection		53	134466	340,00
	23	Wire feeding hose 8 m		22	02110283	93,45
	24	Gas hose 8 m		22	02110260	
	25	Control cable 7 x 0.75 LIYY		22	02110331	2,94
	26	Protective hose 28 x 1,5 black		22	00600405	6,90
	27	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	28	Kinking protection, intake water cooled		22	02510100	14,20
	29	Brass neck for Euro-connection water cooled		22	02510200	29,00
	30	Sleeve nut black		22	02510300	9,80
	31	Liner for steel uncoated 2,5 x 4,5 0.6 -1.6 mm, 8 m long		53	02110325	10,40
	32	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	33	Socket 10-pole (-) (for push pull torch)		53	02110384	33,50
	34	Cable support for 10 pol. plug		07	02110388	19,00
	35	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36	Teflon liner 2.0 x 4.0 Alu/stainl. steel 0.8 - 1.6 mm, 8 m		22	02110326	37,80
	38	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	39	Brass liner 0.2 m, (2.0 x 4.0)		22	107810	3,78
	40.1	Torch neck PP/PPT 502 W, straight		53	02110097	160,00
	40.2	Torch neck PP/PPT 502 W, 45° for torch with fixed torch body		53	02110096	165,00
	40.3	Torch neck PP/PPT 504 W, 45° bent for torch with rotatable torch neck		53	158492	195,00
	41	Secure nut for PP/T 504 W with rotatable torch neck		53	158494	43,00
	42	Insulation sleeve for SB/SBT 502W		22	02211574	7,25
	42.1	Thread piece 503/504 W for water coat 131.280		22	131276	7,90
	43	O-ring 14 x 4	10 pcs	22	02210077	1,89
	44	O-ring 12 x 4	10 pcs	22	02210076	1,89
	45	Pressure bushing SB/SBT 502/503/504 W double wall	10 pcs	22	02211424	10,45
	46	Water coat for SB/SBT 502 W		22	02211572	9,40
	46.1	Water coat SB503/504 W for thread piece 131.276		22	131280	11,00
	47	Insualtion ring SB/SBT 502 W	20 pcs	22	02211421	1,79
	48	Tip adapter SB/SBT 300/502/503/504 W	10 pcs	22	02211578	5,24
	49.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	49.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	49.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	49.4	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	49.5	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	49.6	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	50	Gas diffusor 322/455/502/503/504, ceramics spatter resistant (for aluminium)	10 pcs	22	02211567	7,61
	50.1	Gas diffusor 455/502/503/504 W, plastic	10 pcs	22	02211568	7,61
	51	Gas nozzle 17 mm with fastening ring	10 pcs	52	04514300	4,90
	51.1	Gas nozzle 21 mm heavy duty with fastening ring	10 pcs	52	04514305	18,70
	52	Spot welding gas nozzle with fastening ring	10 pcs	52	04514304	15,50
	53	Gas nozzle 14 mm with fastening ring	10 pcs	52	04514301	11,80
	55	TEDAC pc-board ME-BE-10.0 incl. slide switch and micro switch		22	02210800	115,00
	56	Insertion element		53	02110337	5,00
	57	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	58	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	59	Coupling nipple for water	10 pcs	22	02510400	1,80
	60	Water-power-cable 8.0 m long		53	02110321	100,80
	61	O ring 12 x 1.5	10 pcs	22	131898	1,80
	62	O ring 11 x 1.5	10 pcs	22	131896	1,80
	63	O ring 9.25 x 1.78	10 pcs	22	02110040	1,80
	64	Water distributor for PP/T 504 W with rotatable torch neck		53	158496	205,00
	65	Red cap for water torch connector	10 pcs	22	130958	1,80
	66	Blue cap for torch water connector	10 pcs	22	130959	1,80

4.4. Machine and robot welding torches

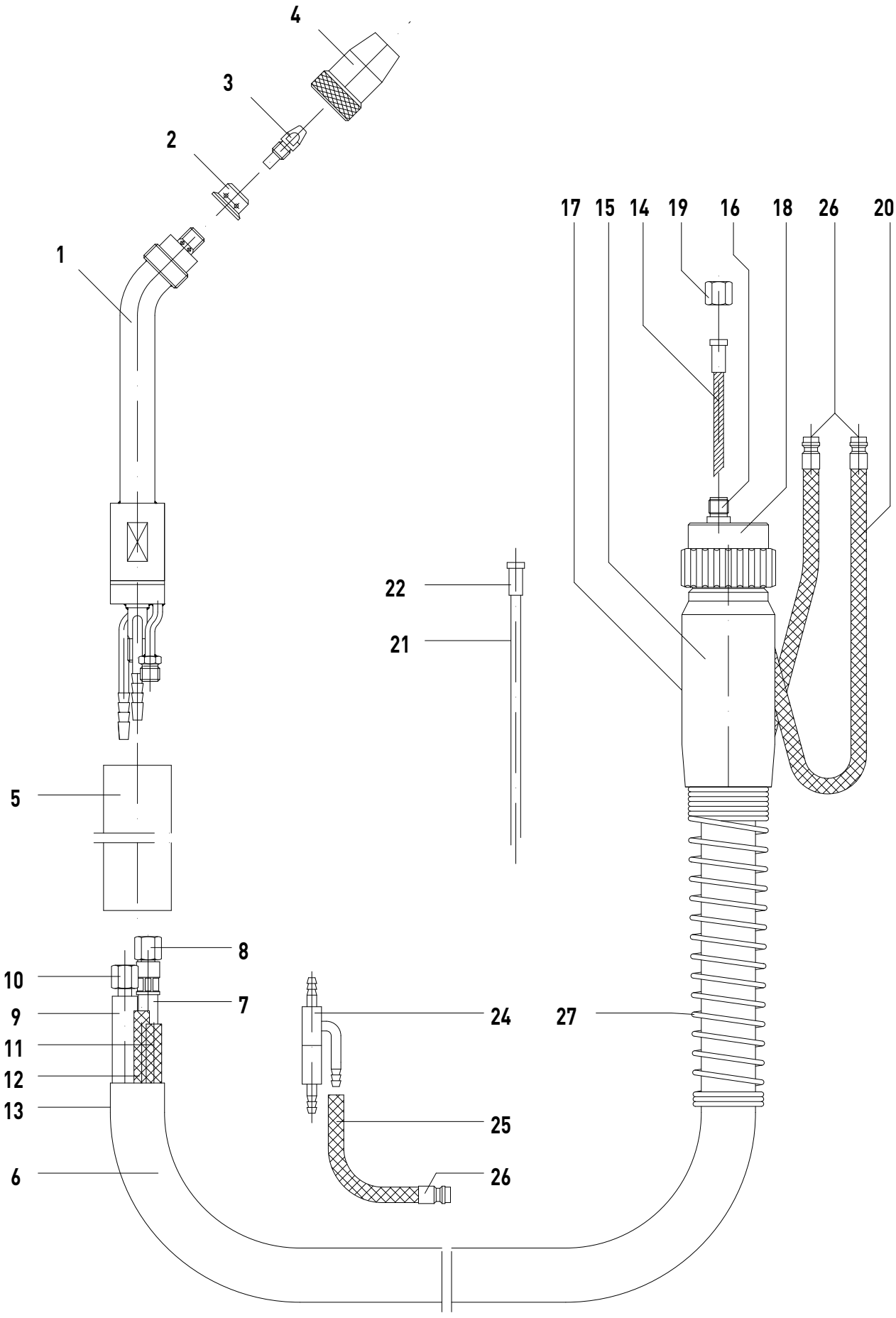
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.4.1. MSB 400 W

MIG/MAG machine welding torch MSB 400 W

water cooled

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	380 A 60% duty cycle
CO_2:	350 A 100% duty cycle
Solid wire:	0.8 - 1.0 - 1.2 - 1.6 mm ∅
Aluminium wire:	1.0 - 1.2 - 1.6 mm ∅
The data are corresponding to (U = 14 + 0.05 x I)	

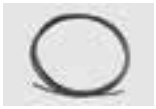
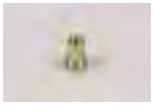


All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Pos.	Description	Pu	PrGrp	Part No.	Price/€
MIG/MAG machine welding torch MSB 400 W					
	MIG/MAG machine welding torch Model MSB 400 W, 1.5 m, bent		**11**	**111812**	**1.106,00**
	MIG/MAG machine welding torch Model MSB 400 W, 2.0 m, bend		**11**	**111816**	**1.111,00**
	MIG/MAG machine welding torch Model MSB 400 W, 2.5 m, bent		**11**	**111820**	**1.116,00**
	MIG/MAG machine welding torch Model MSB 400 W, 3.0 m, bent		**11**	**111824**	**1.121,00**
	MIG/MAG machine welding torch Model MSB 400 W, 4.0 m, straight		**11**	**111830**	**1.087,00**
	Blow-out device for MIG/MAG machine welding torch		**11**	**02211810**	**115,50**
Standard wire equipment: mild steel 1.2 mm					
Spare parts and consumables:					
1	Torch neck MSB 400 W, bent		22	111810	899,00
2	Gas diffusor MSB 400 W ceramic		53	111802	30,45
3.1	Contact tip 0.8 MSB 400 W, Cu-Cr-Zr	20 pcs	53	111776	4,70
3.2	Contact tip 1.0 MSB 400 W, Cu-Cr-Zr	20 pcs	53	111780	4,70
3.3	Contact tip 1.2 MSB 400 W, Cu-Cr-Zr	20 pcs	53	111782	4,70
3.4	Contact tip 1.6 MSB 400 W, Cu-Cr-Zr	20 pcs	53	111786	4,70
3.5	Contact tip alu 0.8 for MSB 400 W Cu-Cr-Zr	20 pcs	53	111788	4,70
3.6	Contact tip alu 1.0 for MSB 400 W Cu-Cr-Zr	20 pcs	53	111790	4,70
3.7	Contact tip alu 1.2 for MSB 400 W Cu-Cr-Zr	20 pcs	53	111792	4,70
3.8	Contact tip alu 1.6 for MSB 400 W Cu-Cr-Zr	20 pcs	53	111794	4,70
4	Gas nozzle for MSB 400 W		53	111796	18,00
5	Carrier pipe for MSB 400 W		22	111988	19,50
6.1	Hose-package MSB, 1.5 m long with Euro-connection		53	02210157	190,00
6.2	Hose-package MSB, 2.0 m long with Euro-connection		53	02210158	198,00
6.3	Hose-package MSB, 2.5 m long with Euro-connection		53	02210159	205,00
6.4	Hose-package MSB, 1.5 m long with Euro-connection, blow-out-device		53	02210910	220,00
6.5	Hose-package MSB, 2.0 m long with Euro-connection, blow-out-device		53	02210911	228,00
6.6	Hose-package MSB, 2.5 m long with Euro-connection, blow-out-device		53	02210912	238,00
7.1	Water-power-cable 1.5 m long		22	02210283	55,00
7.2	Water-power-cable 2.0 m long		22	02210284	60,00
7.3	Water-power-cable 2.5 m long		53	02210285	65,00
8	Connection-nipple for water-power-cable, at torch side		22	04510200	12,00
9.1	Wire feeding hose cpl. 1.5 m long		53	02211659	20,86
9.2	Wire feeding hose cpl. 2.0 m long		53	02211660	25,90

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	9.3	Wire feeding hose cpl. 2.5 m long		53	02211661	28,35
	10	Nipple for wire feeding hose at torch side		22	04510310	5,70
	11	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	12	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	12.1	Gas-hose cpl. 1.5 mm long with blow-out-value		53	02210920	31,92
	12.2	Gas-hose cpl. 2.0 m long with blow-out-value		53	02210921	32,24
	12.3	Gas-hose cpl. 2.5 m long with blow-out-value		53	02210922	32,24
	13	Protective hose 28 x 1,5 black		22	00600405	6,90
	14.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	14.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	14.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	14.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	14.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	14.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	15	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75
	16	Brass neck for Euro-connection water cooled		22	02510200	29,00
	17	Kinking protection, intake water cooled		22	02510100	14,20
	18	Sleeve nut black		22	02510300	9,80
	19	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	20	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	21.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	21.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	21.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	21.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

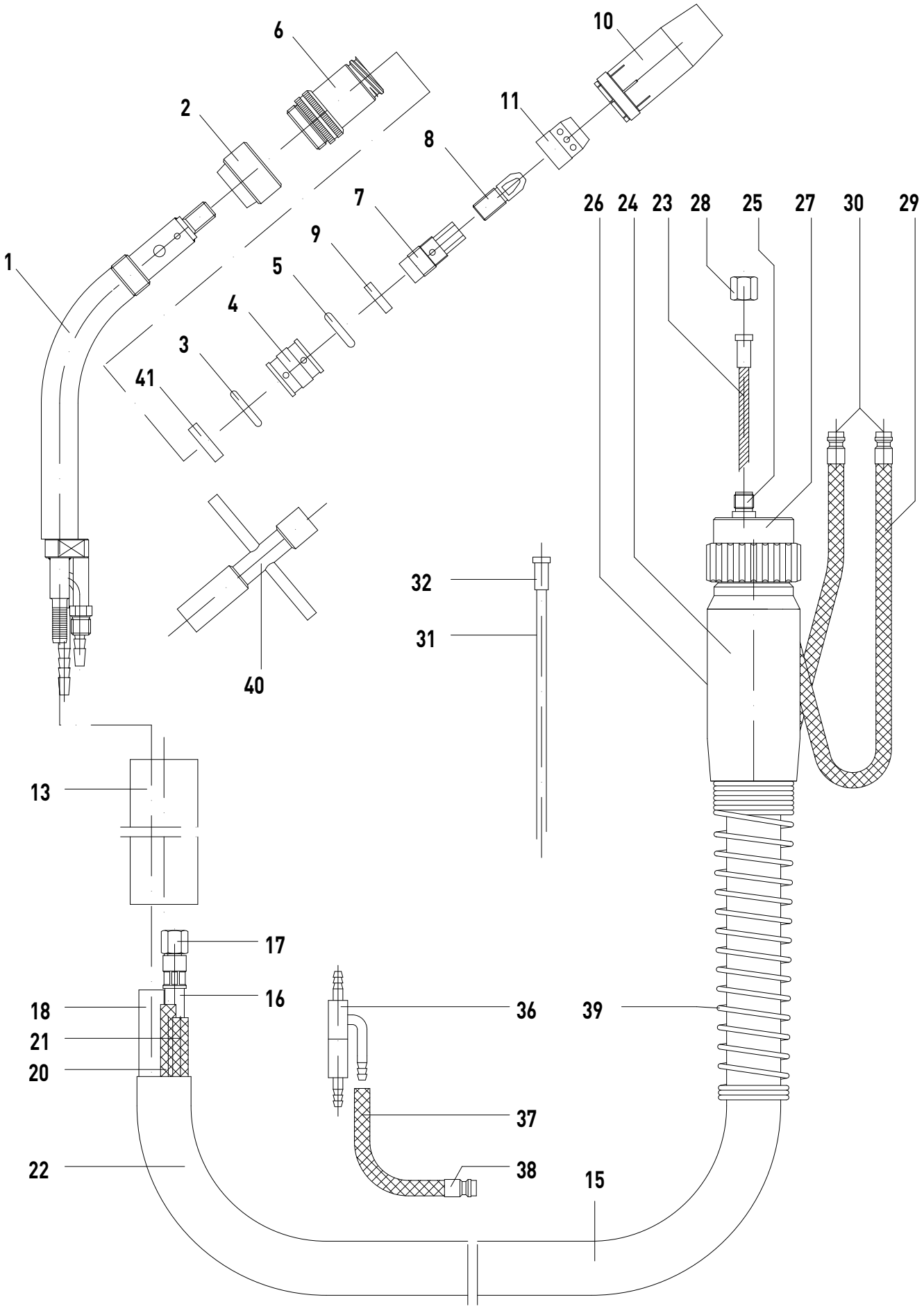
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	21.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	21.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	22.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	22.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	24	Blow-out-valve		53	02210055	38,00
	25	Hose highly flexible 5,0 x 1,5, black		53	104332	3,75
	26	Coupling nipple for water	10 pcs	22	02510400	1,80
	27	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80

4.4.2. MSB 603 W

MIG/MAG machine welding torch MSB 603 W

water cooled

TECHNICAL DATA:	
Cooling:	water cooled
Mixed gas:	600 A 60% duty cycle
CO_2:	600 A 100% duty cycle
Solid wire:	1.0 - 1.2 - 1.6 mm ∅
Aluminium wire:	1.0 - 1.2 - 1.6 mm ∅
The data are corresponding to (U = 14 + 0.05 x I)	



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

MIG/MAG machine welding torch MSB 603 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	MIG/MAG machine welding torch model MSB 603 W, 1.5 m, straight		**11**	**02211801**	**535,00**
	MIG/MAG machine welding torch model MSB 603 W, 2.0 m straight		**11**	**02211803**	**540,00**
	MIG/MAG machine welding torch model MSB 603 W, 2.5 m , straight		**11**	**02211805**	**545,00**
	MIG/MAG machine welding torch model MSB 603 W, 3.0 m, straight		**11**	**02211807**	**550,00**
	MIG/MAG machine welding torch model MSB 603 W, 4.0 m, straight		**11**	**02211809**	**560,00**
	MIG/MAG machine welding torch model MSB 603 W, 1.5 m, bent		**11**	**02211800**	**550,00**
	MIG/MAG machine welding torch model MSB 603 W, 2.0 m, bent		**11**	**02211802**	**555,00**
	MIG/MAG machine welding torch model MSB 603 W, 2.5 m, bent		**11**	**02211804**	**560,00**
	MIG/MAG machine welding torch model MSB 603 W, 3.0 m, bent		**11**	**02211806**	**565,00**
	MIG/MAG machine welding torch model MSB 603 W, 4.0 m, bent		**11**	**02211808**	**575,00**
	Blow-out device for MIG/MAG machine welding torch		**11**	**02211810**	**115,50**

Standard wire equipment: mild steel 1.2 mm

Spare parts and consumables:

1.1	Torch neck MSB 603 W, straight		53	02211729	155,00
1.2	Torch neck MSB 603 W, bent		22	02211730	170,00
2	Thread ring for ROB 504 W and SB 603 W		22	111982	9,80
3	O-ring 16 x 3.5	10 pcs	22	02211777	1,37
4	Internal sleeve 504/600/603 W	2 pcs	22	02211753	10,50
5	O-ring 14 x 4	10 pcs	22	101059	5,20
6	Water coat 504/603 W for gas nozzle 110.136		22	110138	20,90
7	Tip holder 504/603 W	2 pcs	22	108258	8,61
8.1	High performance contact tip 1.0 mm for 504/600/603	20 pcs	52	02211758	3,20
8.2	High performance contact tip 1.2 mm for 504/600/603	20 pcs	52	02211759	3,20
8.3	High performance contact tip 1.6 mm for 504/600/603	20 pcs	52	02211761	3,20
8.4	Contact tip 1.0 mm, alu for 504/600/603 W	20 pcs	52	107894	3,90
8.5	Contact tip 1.2 mm, alu for 504/600/603 W	20 pcs	52	107896	3,90
8.6	Contact tip 1.6 mm, alu for 504/600/603 W	20 pcs	52	107898	3,90
9	Ceramic ring 504/603 W	2 pcs	22	02210340	2,70

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	10	Gas diffusor 504/300/603 W ceramic	5 pcs	22	107966	4,50
	11	Gas nozzle d = 17 mm, l = 67 mm standard B 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	110136	14,80
	13	Handle tube MSB 455/603 W		53	02210125	49,00
	15.1	Hose-package MSB, 1.5 m long with Euro-connection		53	02210157	190,00
	15.2	Hose-package MSB, 2.0 m long with Euro-connection		53	02210158	198,00
	15.3	Hose-package MSB, 2.5 m long with Euro-connection		53	02210159	205,00
	15.4	Hose-package MSB, 1.5 m long with Euro-connection, blow-out-device		53	02210910	220,00
	15.5	Hose-package MSB, 2.0 m long with Euro-connection, blow-out-device		53	02210911	228,00
	15.6	Hose-package MSB, 2.5 m long with Euro-connection, blow-out-device		53	02210912	238,00
	16.1	Water-power-cable 1.5 m long		22	02210283	55,00
	16.2	Water-power-cable 2.0 m long		22	02210284	60,00
	16.3	Water-power-cable 2.5 m long		53	02210285	65,00
	16.4	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	56,00
	17	Connection-nipple for water-power-cable, at torch side		22	04510200	12,00
	18.1	Wire feeding hose cpl. 1.5 m long		53	02211659	20,86
	18.2	Wire feeding hose cpl. 2.0 m long		53	02211660	25,90
	18.3	Wire feeding hose cpl. 2.5 m long		53	02211661	28,35
	20	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	21	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	21.1	Gas-hose cpl. 1.5 mm long with blow-out-value		53	02210920	31,92
	21.2	Gas-hose cpl. 2.0 m long with blow-out-value		53	02210921	32,24
	21.3	Gas-hose cpl. 2.5 m long with blow-out-value		53	02210922	32,24
	22	Protective hose 28 x 1,5 black		22	00600405	6,90
	23.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	23.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	23.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	23.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	23.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	23.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	24	Euro-connector, torch side for water cooled version incl. spring		22	02510150	57,75

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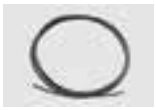
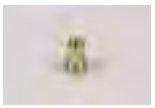
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	25	Brass neck for Euro-connection water cooled		22	02510200	29,00
	26	Kinking protection, intake water cooled		22	02510100	14,20
	27	Sleeve nut black		22	02510300	9,80
	28	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	29	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	31.1	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	31.2	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	31.3	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	31.4	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	31.5	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	31.6	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	32.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	32.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	36	Blow-out-valve		53	02210055	38,00
	37	Hose highly flexible 5,0 x 1,5, black		53	104332	3,75
	38	Coupling nipple for water	10 pcs	22	02510400	1,80
	39	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	40	Key for 504/600/603 W		22	01370043	23,00
	41	Distance ring 21,8 x 5,5 504/603 W		22	02211815	2,15

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

4.4.3. ROB W HW

MIG/MAG machine welding torch ROB W HW

water cooled / Euro connector
separate torch head
for connection to HW cut off protection
Versions of the torch head: straight, 22° bent, 45° bent

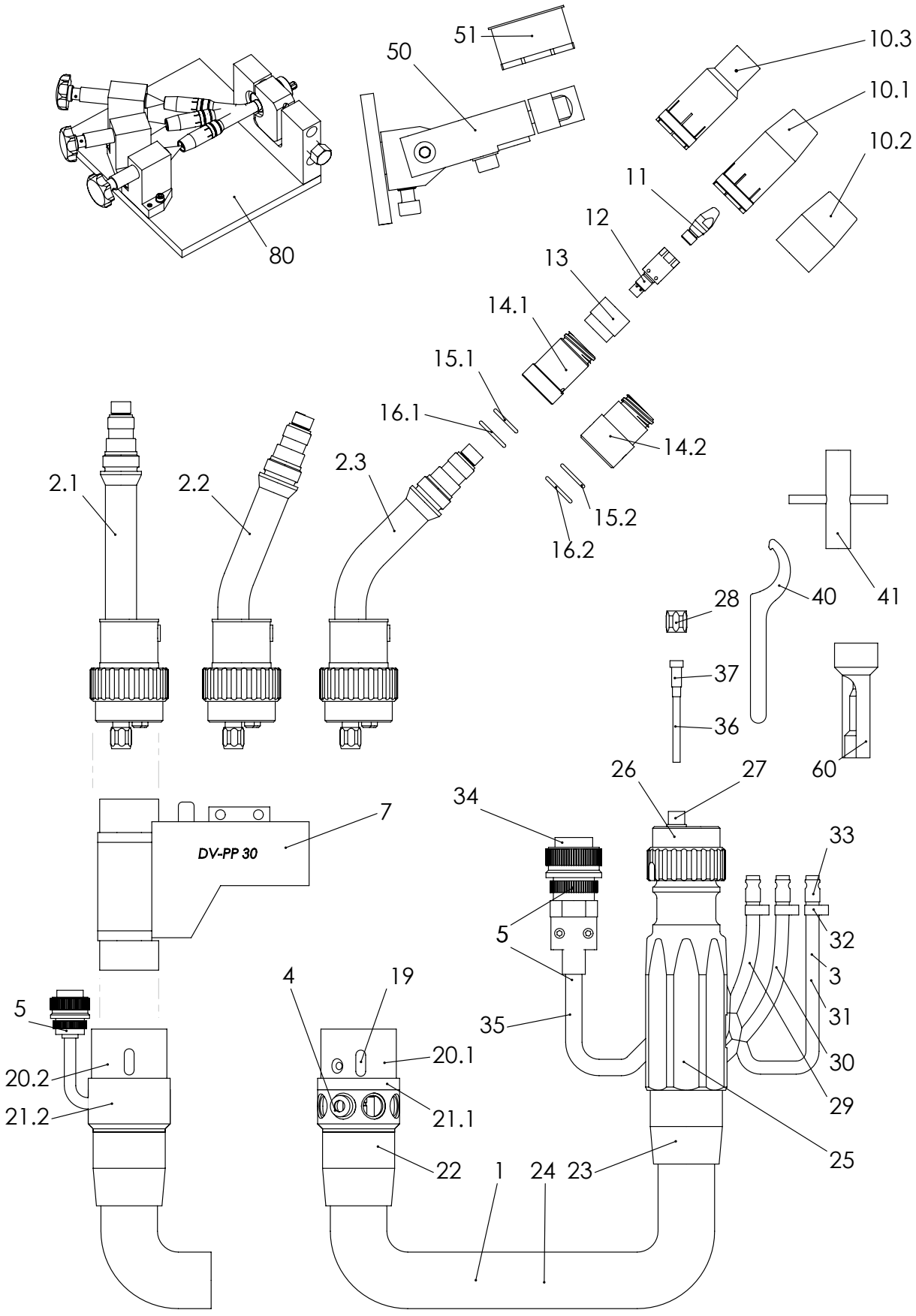
on request

4.4.4. ROB 505 W

MIG/MAG machine welding torch ROB 505 W

water cooled / Euro connector
separate torch head
Versions of the torch head: straight, 22° bent, 45° bent

TECHNICAL DATA:		
Gas nozzle	Standard	High performance
60% duty cycle:	450 A (36.5 V)*	500 A (39.0 V)*
100% duty cycle:	400 A (34.0 V)*	450 A (36.5 V)*
*Mixed gas (Ar/CO_2 82/18)		
Cooling:	water cooled	
Wire diameter:	0.8 - 1.0 - 1.2 - 1.6 mm ∅	
Weight torch head:	0.75 kg	
The data are corresponding to (U = 14 + 0.05 x I)		



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Pos.	Description	Pu	PrGrp	Part No.	Price/€

Hose assemblies ROB 505 W

1.1	Hose assembly 1.2 m, ROB 505 W	11		118503	565,00
1.2	Hose assembly 1.5 m, ROB 505 W	11		118504	570,00
1.3	Hose assembly 2.0 m, ROB 505 W	11		119264	580,00
1.4	Hose assembly 2.5 m, ROB 505 W	11		119266	590,00

For use with WCM tractor:

1.5	Hose assembly up to 4 m, ROB 505 W (only for WCM)	11		133770	620,00
1.6	Hose assembly up to 8 m, ROB 505 W (only for WCM and PP)	11		133772	780,00

Torch bodies ROB 505 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
2.1	**Torch body ROB 505 W, 0°**		**11**	**151829**	**540,00**
2.2	**Torch body ROB 505 W, 22°**		**11**	**118478**	**560,00**
2.3	**Torch body ROB 505 W, 45°**		**11**	**118480**	**560,00**

Options for ROB 505 W:

3	Blow-out device for hose assembly ROB 505 W		11	120478	65,00
4	Buttons "wire inching" and "gas test" at torch connector of hose assembly ROB 505 W incl. control cable with plug		11	120476	158,00
5.1	Connection cable for TBi crash sensor mounted in hose assembly ROB 505 W		11	120132	135,00
5.2	Connection cable and socket for Dinse crash sensor mounted in hose assembly ROB 505 W		11	120134	195,00
5.3	Connection cable for AbicorBinzel crash sensor mounted in hose assembly ROB 505 W		11	120136	135,00
5.4	Connection cable for external buttons in torch holder or for push pull feeder ROB-PP mounted in hose assembly ROB 505 W		11	120138	135,00
6	Dinse torch connector for ROB 505 W		11	125334	180,00
7	Wire feed unit DV-PP 30 for ROB-W-PP with 4 roller drive		11	110900	2.415,00
8	Flange wire feed unit DV-PP 30 at crash sensor (please indicate crash sensor)		09	126824	120,00
9	Connection cable for touch sensor gas nozzle, mounted in the robot torch hose assembly, incl. cable from hose assembly to torch holder		11	146784	75,00
60.1	Torch cleaning station BRG 2000 incl. spray unit and milling head		09	117726	1.980,00
60.2	Milling head for torch cleaning station BRG 2000 for ROB 505 W		09	120492	39,00
60.3	Wire cutting unit DA 2000 KPL		09	117728	475,00
60.4	Stand for BRS 20, BRG 2000		09	111716	130,00
70.1	Crash sensor TBi KS2 without assembly device		09	145790	630,00
70.2	Crash sensor DIX SAS 100 system Dinse without adapter		09	128284	750,00
70.3	Crash sensor Binzel CAT2 without adapter		09	111402	920,00
71.1	Torch holder for ROB 505 W for TBi KS1/KS2 incl. accessories		09	123750	348,00
71.2	Torch holder for ROB 505 W Dinse TCP, for SASS 2000 incl. accessories		09	152325	348,00
71.3	Torch holder for ROB 505 W for Abicor Binzel CAT incl. accessories		09	123748	275,00
72.1	Flange for KUKA robot at crash sensor (please indicate exact robot model)		09	126812	280,00
72.2	Flange for MOTOMAN robot at crash sensor (please indicate exact robot model)		09	126814	
72.3	Flange for Fanuc robot at crash sensor (please indicate exact robot model)		09	126816	

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Subject to change. Valid from 18.05.2020

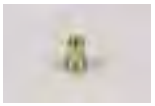
Pos.	Description	Pu	PrGrp	Part No.	Price/€
72.4	Flange for ABB robot at crash sensor (please indicate exact robot model)		09	126818	
72.5	Flange for REIS robot at crash sensor (please indicate exact robot model)		09	128730	

Spare parts and consumables:

10.1a	Gas nozzle d = 17 mm, l = 67 mm standard B 603, ROB 504/505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	110136	14,80
10.1b	Gas nozzle d = 17 mm, l = 61 mm SB 504/603 ROB 505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	138146	21,50
10.1c	Gas nozzle d = 17 mm, l = 64 mm SB 504/603 ROB 505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	138158	21,50
10.2	Gas nozzle d=16 mm ROB 505 W high performance variant push and screw fixing, nickel plated for water jacket 123.328	10 pcs	52	123332	21,50
10.3a	Gas nozzle d = 15.5 mm, l = 61 mm bottle shape SB 504/603 ROB 505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	144046	21,50
10.3b	Gas nozzle d = 15.5 mm, l = 64 mm bottle shape SB 504/603 ROB 505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	144044	21,50
10.3c	Gas nozzle d = 15.5 mm, l = 67 mm bottle shape SB 504/603 ROB 505 push and screw fixing, nickel plated for water jacket 151.656	10 pcs	52	144042	21,50
11.1	Contact tip ROB 355/505, 0.8 mm conical	20 pcs	52	124802	3,15
11.2	Contact tip ROB 355/505, 1.0 mm conical	20 pcs	52	124804	3,15
11.3	Contact tip ROB 355/505, 1.2 mm conical	20 pcs	52	124800	3,15
11.4	Contact tip ROB 355/505, 1.4 mm conical	20 pcs	52	124806	3,15
11.5	Contact tip ROB 355/505, 1.6 mm conical	20 pcs	52	124808	3,15
11.6	Contact tip ROB 355/505, 2.0 mm conical	20 pcs	52	124810	3,15
11.7	Contact tip ROB 355/505, 2.4 mm conical	20 pcs	52	124812	3,15
11.8	Contact tip ROB 355/505, alu 1.0 mm conical	20 pcs	52	125108	3,50
11.9	Contact tip ROB 355/505, alu 1.2 mm conical	20 pcs	52	125110	3,50
11.10	Contact tip ROB 355/505, alu 1.6 mm conical	20 pcs	52	124814	3,50
12.1	Tip adaptor ROB 505 W, conical with forced contacting (max. 1.4 mm)	10 pcs	53	124796	6,60
12.2	Tip adaptor ROB 505 W, conical without forced contacting (from 1.6 mm)	10 pcs	53	124798	6,60
13	Gas diffusor ROB 505 W	10 pcs	53	151695	7,70
14.1	Water coat ROB 505 W for gas nozzle 110.136		53	151656	33,00
14.2	Water coat ROB 505 W high performance version for gas nozzle 123.332		53	123328	39,00
15.1	O-ring 16 x 2, WHW 20	10 pcs	53	01340063	1,85
15.2	O ring 16 x 3 mm	10 pcs	53	00202402	1,85
16.1	O ring 18 x2	10 pcs	53	05011541	1,85
16.2	O ring 18 x 3 mm	10 pcs	53	122942	1,85
19	Keyfixture 6x6x16		53	112242	2,50

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	20.1	Mounting piece for hose assembly ROB-W, ROB-W-PP (for 2 part kinking protection 110.904)		53	111598	75,00
	20.2	Mounting piece for hose assembly ROB-W, ROB-W-PP (for 1 part kinking protection 120.876)		53	120878	75,00
	21.1	Kinking protection (2 parts) for hose assembly ROB-W, ROB-W-PP for button and plug incl. switch connection (for 111.598)		53	110904	175,00
	21.2	Kinking protection (2 parts) for hose assembly ROB-W, ROB-W-PP		53	120876	135,00
	22.1	Nut on torch side ROB-W, ROB-W-PP		53	111588	46,00
	22.2	Ring holder ROB-W, ROB-W-PP		53	111594	31,00
	22.3	Locking ring ROB-W, ROB-W-PP		53	111596	13,90
	23.1	Nut on machine side ROB-W, ROB-W-PP		53	111592	21,00
	23.2	Ring holder ROB-W, ROB-W-PP		53	111594	31,00
	23.3	Locking ring ROB-W, ROB-W-PP		53	111596	13,90
	24	Protection hose for robot and machine welding torch		53	111418	29,30
	25	Kinking protection, intake water cooled		22	02510100	14,20
	26	Sleeve nut black		22	02510300	9,80
	27	Brass neck for Euro-connection water cooled		22	02510200	29,00
	28	Liner nut for Euro connector	10 pcs	22	02511301	2,00
	29	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	30	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	31	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	32	Clamping ring 9.5 GER		07	02210206	1,90
	33	Coupling nipple for water	10 pcs	22	02510400	1,80
	34.1	Socket 10-pole (-) (for push pull torch)		53	02110384	33,50
	34.2	Cable support for 10 pol. plug		07	02110388	19,00
	35	Control cable 7 x 0.75 LIYY		22	02110331	2,94
	36.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	36.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	36.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	36.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
	36.8	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
	36.9	Liner for steel uncoated 2,5 x 4,5 0.6 -1.6 mm, 8 m long		53	02110325	10,40
	36.10	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	36.11	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	36.12	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	36.13	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	135574	37,00
	36.14	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	36.15	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
	37.1	Collet for teflon liner 2.0 x 4.0	10 pcs	22	107554	2,90
	37.2	Collet for teflon liner 2.7 x 4.7	10 pcs	22	102997	2,52
	38.1	Water current cable 1.2 m ROB-W, ROB-W-PP		53	121086	42,00
	38.2	Water current cable 1.5 m ROB-W, ROB-W-PP		53	110912	44,00
	38.3	Water-power-cable 2.0 m long		22	02210284	60,00
	38.4	Water-power-cable 2.5 m long		53	02210285	65,00
	38.5	Water-power-cable 4.0 m long SB 502/603/455/450/350		22	02210282	56,00
	38.6	Water-power-cable 8.0 m long		53	02110321	100,80
	39.1	Wire feed liner 1.2 m ROB-W, ROB-W-PP		53	121088	32,00
	39.2	Wire feed liner 1.5 m ROB-W, ROB-W-PP		53	110914	32,50
	39.3	Wire feed liner 2.0 m ROB-W, ROB-W-PP		53	02210280	33,00
	39.4	Wire feed liner 2.5 m ROB-W, ROB-W-PP		53	02210274	33,50
	39.5	Wire feed liner 4.0 m ROB-W, ROB-W-PP		22	02211664	35,00
	39.6	Wire feed liner 8.0 m ROB-W, ROB-W-PP		53	133774	38,00
	40	Key for water coat		53	121094	15,23
	41	Key for 504/600/603 W		22	01370043	23,00
	50	Machine Torch Mount Ø=35 mm for MIG/MAG torches, isolated		05	152232	158,00
	51	Isolation ring for machine welding torch		53	152225	28,00
	80	Test device for torch head ROB 505 W 0°, 22°, 45°		09	124754	995,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5. TIG welding units

5. TIG welding units

5.1 TIG DC welding units

5.2 TIG AC/DC welding units

5.1. TIG DC welding units

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.1. LiteTIG 190 DC

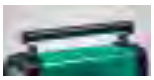
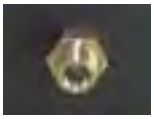
Primary:	
Supply:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (TIG/MMA):	30 A / 35 A
cos phi:	0.98
TIG operation:	
Open circuit voltage:	68 V
Welding voltage:	10.2 - 17.6 V
Welding current:	5 - 190 A
Duty cycle 25 % (10 min.):	190 A (40 °C)
Duty cycle 60 % (10 min.):	140 A (40 °C)
Duty cycle 100 %	115 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Modes:	TIG (DC) / MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Programmable jobs:	15 jobs
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 – 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 16 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.01 - 2.5 s
Hotstart current:	20 - 170 A
Arc force:	up to 170 A
Remote control:	connection via 5pol torch connection
Power source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Cooling torch:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 5 m long with plug Schuko
Gas hose:	2 m
Transport:	adjustable carry/shoulder strap
Norm:	EN 60974/1 S / CE
Weight:	7.4 kg
Dimension l x w x h:	410 x 150 x 240 mm

MMA/stick electrode operation:	
Stick electrode:	1.5 - 4 mm
Open circuit voltage:	68 V
Welding voltage:	20.8 - 26.8 V
Welding current:	20 - 170 A
Duty cycle 30 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	135 A (40 °C)
Duty cycle 100 %	90 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit LiteTIG 190 DC**					
	A	**TIG welding unit LiteTIG 190 DC (Merkle TCG connector)**		**48**	**SET154082**	**1.415,00**
	AB	**TIG welding unit LiteTIG 190 DC with accessories (Merkle TCG connector)**		**48**	**SET154084**	**1.465,00**
	ABC1	**TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET154086**	**1.715,00**
	ABC2	**TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET154088**	**1.795,00**
	Packages:					
	A	**Package 10 pieces TIG welding unit LiteTIG 190 DC (Merkle TCG connector)**		**48**	**SET154090**	**13.200,00**
	ABC1	**Package 10 pieces TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET154092**	**17.000,00**
	ABC2	**Package 10 pieces TIG welding unit LiteTIG 190 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET154094**	**17.900,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1a	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, MobiTIG 180, LiteTIG 190 inner dimensions 59 x 47 x 21 cm		46	n01200372	218,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	D5	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00
	D6	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	D7	Handle set for LiteTIG 190/210		46	158342	32,50
	D8a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D8b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.2. LiteTIG 210 DC

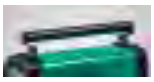
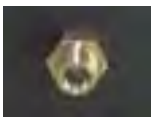
Primary:	
Supply:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (TIG/MMA):	22 A / 25 A
cos phi:	0.99
TIG operation:	
Open circuit voltage:	73 V
Welding voltage:	10.2 - 18.4 V
Welding current:	5 - 210 A
Duty cycle 20 % (10 min.):	210 A (40 °C)
Duty cycle 60 % (10 min.):	145 A (40 °C)
Duty cycle 100 %	135 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Modes:	TIG (DC) / MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Programmable jobs:	15 jobs
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 16 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.01 - 2.5 s
Hotstart current:	20 - 170 A
Arc force:	up to 170 A
Remote control:	connection via 5pol torch connection
Power source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Cooling torch:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 5 m long
Gas hose:	2 m
Transport:	adjustable carry/shoulder strap
Norm:	EN 60974/1 S / CE
Weight:	8.0 kg
Dimension l x w x h:	410 x 150 x 240 mm

MMA/stick electrode operation:	
Stick electrode:	1.5 - 4 mm
Open circuit voltage:	73 V
Welding voltage:	20.8 - 26,8 V
Welding current:	20 - 170 A
Duty cycle 20 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	135 A (40 °C)
Duty cycle 100 %	125 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**TIG DC welding unit LiteTIG 210 DC**				
	A	**TIG welding unit LiteTIG 210 DC (Merkle TCG connector)**		**48**	**SET155876**	**1.970,00**
	AB	**TIG welding unit LiteTIG 210 DC with accessories (Merkle TCG connector)**		**48**	**SET155878**	**2.020,00**
	ABC1	**TIG welding unit LiteTIG 210 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET155880**	**2.270,00**
	ABC2	**TIG welding unit LiteTIG 210 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET155882**	**2.350,00**
B		**Standard accessories:**				
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C		**Welding torches:**				
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D		**Accessories:**				
	D1a	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, MobiTIG 180, LiteTIG 190 inner dimensions 59 x 47 x 21 cm		46	n01200372	218,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	D5	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D6	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	D7	Handle set for LiteTIG 190/210		46	158342	32,50
	D8a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D8b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D9	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

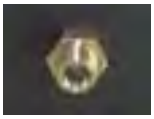
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.3. MobiTIG 194 DC mobil

Primary:		
Supply:	1 x 230 V	
Frequency:	50 / 60 Hz	
Cont. power (TIG/MMA):	2.8 / 3.7 kVA	
Cont. current (TIG/MMA):	12 / 16 A	
Max. current (TIG/MMA):	23 A / 26 A	
cos phi:	0.95	
TIG operation:		
Open circuit voltage:	64 V	
Welding voltage:	10 - 17.6 V	
Welding current:	5 - 190 A	
Duty cycle 20 % (10 min.):		180 A (40 °C)
Duty cycle 35 % (10 min.):	180 A (20 °C)	
Duty cycle 60 % (10 min.):	150 A (20 °C)	110 A (40 °C)
Duty cycle 100 %:	130 A (20 °C)	90 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Modes:	TIG (DC) / MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 12 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 160 A
Arc force:	up to 160 A
LEDs:	mains ON temperature protection failure
Remote control:	connection via 5pol torch connection
Power source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Cooling torch:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 2.5 m long with plug Schuko
Gas hose:	2 m
Handle:	at topside of device
Norm:	EN 60974/1 S / CE
Weight:	12.8 kg
Dimensions l x w x h:	530 x 210 x 445 mm

MMA/stick electrode operation:		
Stick electrode:	1.5 - 3.25 mm	
Open circuit voltage:	64 V	
Welding voltage:	20 - 26 V	
Welding current:	20 - 160 A	
Duty cycle 30 % (10 min.):		150 A (40 °C)
Duty cycle 60 % (10 min.):	150 A (20 °C)	110 A (40 °C)
Duty cycle 100 %:	130 A (20 °C)	90 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit MobiTIG 194 DC mobil**					
	A	**TIG welding unit MobiTIG 194 DC mobil**		**48**	**SET143840**	**1.680,00**
	AB	**TIG welding unit MobiTIG 194 DC mobil with accessories (Merkle TCG connector)**		**48**	**SET143842**	**1.730,00**
	ABC1	**TIG welding unit MobiTIG 194 DC mobil with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET143844**	**1.980,00**
	ABC2	**TIG welding unit MobiTIG 194 DC mobil with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET143846**	**2.060,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	D2	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00
	D3	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	D4a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D4b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D5	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.4. MobiTIG 304 DC

Primary:		
Supply:	3 x 220 - 400 V	1 x 220 - 440 V*
Frequency:	50 / 60 Hz	
Data at mains input:	**3 x 400 V**	**1 x 230 V***
Cont. power (TIG/MMA):	8.3 / 9.7 kVA	3.2 / 3.7 kVA
Cont. current (TIG/MMA):	12 / 14 A	14 /16 A
Max. current (TIG/MMA):	16 / 21 A	26 / 26 A
cos phi	0.98	0.98
TIG operation:		
Open circuit voltage:	90 V	90 V
Welding voltage:	10 - 22 V	10 - 17.2 V
Welding current:	5 - 300 A	5 - 180 A
Duty cycle 35 % (10 min.):	300 A (40 °C)	180 A (40 °C)
Duty cycle 60 % (10 min.):	265 A (40 °C)	110 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)	90 A (40 °C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Modes:	TIG (DC) / MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 12 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.01 - 5 s
Hotstart current:	20 - 280 A
Arc force:	up to 280 A
Electrode type:	selectable rutile, basic
LEDs:	mains ON, welding ON, temperature protection, failure
Socket:	connection remote control
Current source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Torch cooling:	gas, option: water
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 2.5 mm² 5 m long with plug 400 V/16 A
Gas hose:	2 m
Connection water cooling device:	option
Handle:	at topside of device
Norm:	EN 60974/1 S / CE
Weight:	20 kg
Dimensions l x w x h:	495 x 210 x 450 mm

Data at mains input:	**3 x 400 V**	**1 x 230 V***
MMA/stick electrode operation:		
Stick electrode:	1.5 - 5.0 mm	1.5 - 3.25 mm
Open circuit voltage:	90 V	90 V
Welding voltage:	20.6 - 31.2 V	20 - 26 V
Welding current:	20 - 280 A	20 - 160 A
Duty cycle 40 % (10 min.):	280 A (40 °C)	160 A (40 °C)
Duty cycle 60 % (10 min.):	265 A (40 °C)	110 A (40 °C)
Duty cycle 100 %:	250 A** (40 °C)	90 A (40 °C)

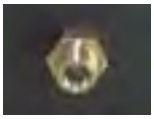
*: BiPowerPLUS: Multi voltage supply system: Automatic switching between 1 and 3 phase in the range 220 – 400 V (option)

**: max. 210 A (40 °C) at duty cycle 100 % with 16 A fuse

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit MobiTIG 304 DC**					
	A	**TIG welding unit model MobiTIG 304 DC (Merkle TCG connector)**		**02**	**SET155888**	**3.130,00**
	AB	**TIG welding unit model MobiTIG 304 DC with accessories (Merkle TCG connector)**		**02**	**SET155890**	**3.210,00**
	ABC1	**TIG welding unit model MobiTIG 304 DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**02**	**SET155892**	**3.460,00**
	ABC2	**TIG welding unit model MobiTIG 304 DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**02**	**SET155894**	**3.540,00**
	With water cooler and trolley TW 112:					
		TIG welding unit MobiTIG 304 DC incl. water cooler WK 210 and trolley TW 112		**02**	**SET155896**	**4.480,00**
		TIG welding unit MobiTIG 304 DC with accessories incl. water cooler WK 210 and trolley TW 112		**02**	**SET155898**	**4.560,00**
		TIG welding unit MobiTIG 304 DC with accessories and torch TH 452 W, 4 m incl. water cooler WK 210 and trolley TW 112		**02**	**SET155900**	**4.810,00**
		TIG welding unit MobiTIG 304 DC with accessories and torch TH 452 W, 8 m incl. water cooler WK 210 and trolley TW 112		**02**	**SET155902**	**4.890,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

D Accessories:

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	160,00
	D2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	39,00
	D3	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00
	D4	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	D5	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D6	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D7	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D8a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D8b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D9	Euro connector for portable TIG welding units		46	110430	55,00
	D10	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D11	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D12	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D13	Connection for automated welding for MobiTIG 284/304 DC - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	123166	345,00
	D14	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D15	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for using water cooler:

	E1	Water cooling unit model WK 210		46	143136	990,00
	E2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321 K		46	124858	169,00
	E3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/fabric hose assembly		10	145080	405,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/fabric hose assembly		10	145082	445,00
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		10	145084	500,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.5. HighTIG W 350 DC

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98
TIG DC-operation:	
Open circuit voltage:	57 V
Welding voltage:	10 - 24 V
Welding current:	5 - 350 A
Duty cycle 50 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	280 A (40 °C)
Prim. cont. power:	13.1 kVA
Prim. cont. current:	19 A
Prim. max. current:	23 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC, MMA
Digital displays.	LED display with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	OFF, high frequency, LiftTIG
Energy control:	at the machine, at the remote control, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming
Job-Operation:	2048 jobs programmable
Program storage:	512 programs
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	0 - 25 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.1 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz-12 kHz
Hotstart time:	0 - 1.5 s
Hotstart current:	10 - 200 %
Arc force:	100 - 250 %
LEDs:	mains ON, temperature protection, failure, display-hold
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pol. plug
Torch cooling:	integrated water cooler
Socket 95 mm²:	earth lead
Socket 50 mm²:	electrode cable
Mains supply cable:	4 x 4 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	10 - 20 - 50 l cylinders
Lifting eyes:	4 pieces (option)
Weight:	115 kg
Dimensions l x w x h:	1100 x 490 x 895 mm incl. gas bottle holder

MMA/stick electrode operation	
Stick electrodes:	1.5 - 6 mm
Open circuit voltage:	57 V
Welding voltage:	20 - 34 V
Welding current:	20 - 350 A
Duty cycle 50 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	280 A (40 °C)
Prim. cont. power:	15.2 kVA
Prim. cont. current:	22 A
Prim. max. current:	27 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit HighTIG W 350 DC**					
	A	**TIG welding unit HighTIG W 350 DC**		**02**	**SET138882**	**6.610,00**
	AB	**TIG welding unit HighTIG W 350 DC ith accessories**		**02**	**SET138884**	**6.730,00**
	ABC1	**TIG welding unit HighTIG W 350 DC with accessories and torch TH 452 W, 4 m**		**02**	**SET138885**	**7.110,00**
	ABC2	**TIG welding unit HighTIG W 350 DC with accessories and torch TH 452 W, 8 m**		**02**	**SET138886**	**7.150,00**
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/fabric hose assembly**		**10**	**145086**	**415,00**
	C2	**TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/fabric hose assembly**		**10**	**145088**	**455,00**
D	**Accessories:**					
	D1	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/fabric hose assembly		10	145090	510,00
	D2	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D3	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D5	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	D6	Cover with lock, transparent, for power source HighPULSE, SpeedMIG and HighTIG version KW and DW		46	138238	142,00
	D7	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	D8	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	3,50

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D9	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	110,00

E Automation accessories:

	E1	Connection for automated welding for HighPULSE, SpeedMIG, HighTIG, singals: - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	138296	290,00
	E2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.6. HighTIG 452 DC

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98
TIG DC-Operation:	
Open circuit voltage:	72 V
Welding voltage:	10 - 28 V
Welding current:	5 - 450 A
Duty cycle 50 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	350 A (40 °C)
Prim. cont. power:	13.2 kVA
Prim. cont. current:	19 A
Prim. max. current:	29 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC, MMA/stick electrode
Digital displays:	LED display with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	high frequency, LiftTIG
Energy control:	at the machine, at the remote control, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Program storage:	512 storage places
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	5 - 450 A
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection failure, display-hold
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pole plug
Torch cooling:	separate water cooling system (option)
Socket water cooling unit:	6-pol.
Socket 95 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 6 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Weight:	63 kg
Dimensions l x w x h:	740 x 350 x 690 mm

MMA/stick electrode operation:	
Stick electrodes:	1.5 - 6 mm
Open circuit voltage:	72 V
Welding voltage:	20 - 38 V
Welding current:	20 - 450 A
Duty cycle 40 % (10 min.):	450 A (40 °C)
Duty cycle 100 %:	310 A (40 °C)
Prim. cont. power:	15.9 kVA
Prim. cont. current:	23 A
Prim. max. current:	39 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit HighTIG 452 DC**					
	A	**TIG welding unit HighTIG 452 DC with TIG Euro connector**		**02**	**SET144040**	**7.720,00**
	ABC	**TIG welding unit HighTIG 452 DC with water cooling unit WK 350 and trolley TW 114**		**02**	**SET144042**	**9.095,00**
	ABCDE	**TIG welding unit HighTIG 452 DC with water cooling unit WK 350 and trolley TW 114 incl. accessories and torch TH 452 W, 8 m**		**02**	**SET144046**	**9.635,00**
B	**Water cooling unit:**					
		Water cooling unit model WK 350		46	144008	1.200,00
C	**Trolley:**					
		Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
D	**Accessories:**					
		Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
		Regulator argon/CO2, single stage		46	01200300	68,00
E	**Welding torches:**					
		TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/fabric hose assembly		**10**	**145088**	**455,00**
F	**Accessories:**					
	F1	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		10	104410	575,00
	F2	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/fabric hose assembly		10	145090	510,00
	F3	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	615,00
	F4	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	F5	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	F6	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F7	Key switch for locking the system in job mode for HighPULSE and HighTIG series		46	148246	97,00
	F8	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	F9	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	F10	Cover for operation panel RS series 352/452/552		46	145206	132,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.7. HighTIG 552 DC

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98
TIG DC operation:	
Open circuit voltage:	72 V
Welding voltage:	10 - 32 V
Welding current:	5 - 550 A
Duty cycle 50 % (10 min.):	550 A (40 °C)
Duty cycle 100 %:	420 A (40 °C)
Prim. cont. power:	18 kVA
Prim. cont. current:	26 A
Prim. max. current:	40 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC, MMA/stick electrode
Digital displays:	LED display with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation spot welding time
Ignition:	high frequency, liftTIG
Energy control:	at the machine, at the remote control, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Program memory:	512 storage places
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	5 - 550 A
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection failure, hold-function
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pole plug
Torch cooling:	separate water cooling system (option)
Socket water cooling unit:	6-pol.
Socket 95 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 6 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Weight:	65 kg
Dimensions l x w x h:	740 x 350 x 690 mm

MMA/stick electrode operation:	
Stick electrodes:	1.5 - 6 mm
Open circuit voltage:	72 V
Welding voltage:	20 - 42 V
Welding current:	20 - 550 A
Duty cycle 40 %(10 min.):	550 A (40 °C)
Duty cycle 100 %:	410 A (40 °C)
Prim. cont. power:	24.9 kVA
Prim. cont. current:	36 A
Prim. max. current:	52 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG DC welding unit HighTIG 552 DC**					
	A	**TIG welding unit HighTIG 552 DC with TIG Euro connection**		**02**	**SET144050**	**7.870,00**
	ABC	**TIG welding unit HighTIG 552 DC with water cooling unit WK 350 and trolley TW 114**		**02**	**SET144052**	**9.485,00**
	ABCDE	**TIG welding unit HighTIG 552 DC with water cooling unit WK 350 and trolley TW 114 with accessories and torch TH 600 W, 8 m**		**02**	**SET144054**	**10.210,00**
B	**Water cooling unit:**					
		Water cooling unit model WK 350		46	144008	1.200,00
C	**Trolley:**					
		Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
D	**Accessories:**					
		Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
		Regulator argon/CO2, single stage		46	01200300	68,00
E	**Welding torches:**					
		TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		**10**	**104410**	**575,00**
F	**Accessories:**					
	F1	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	615,00
	F2	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	F3	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	F4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	F5	Key switch for locking the system in job mode for HighPULSE and HighTIG series		46	148246	97,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F6	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	F7	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	F8	Cover for operation panel RS series 352/452/552		46	145206	132,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.1.8. HighTIG 452/552 DC RS

Primary:		
Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.98	
TIG DC-operation:		
Model:	**452 DC**	**552 DC**
Open circuit voltage:	72 V	72 V
Welding voltage:	10 - 28 V	10 - 32 V
Welding current:	5 - 450 A	5 - 550 A
Duty cycle 40 %(10 min.):	450 A	550 A
Duty cycle 60 %(10 min.):		
Duty cycle 100 %:	350 A	420 A
Prim. cont. power:	13.2 kVA	18 kVA
Prim. cont. current:	19 A	26 A
Prim. max. current:	29 A	40 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC
Digital displays:	LED display with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	high frequency
Energy control:	at the machine
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	0 - 100 %
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection, failure, hold function
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Sockets 95 mm²:	earth lead and torch
Torch cooling:	external water cooler (option)
Socket water cooling unit:	6-pol.
Mains supply cable:	4 x 6.0 mm², 5 m long (HT 452/552 DC) with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % power mains fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	63 kg (HT 452 DC) 65 kg (HT 552 DC)
Dimensions l x w x h:	740 x 350 x 690 mm (HT 452/552 DC)

Roboter interface:	bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, ethernet 10 Mbit with RJ45 connector (option)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**TIG DC robot and automation welding unit HighTIG 452/552 DC RS**				
	A1	**TIG DC Robot and Automation Welding Unit Model HighTIG 452 DC RS with TIG Euro connector (without interface and front panel)**		**02**	**144014**	**6.290,00**
	A2	**TIG DC Robot and Automation Welding Unit Model HighTIG 552 DC RS with TIG Euro connector (without interface and front panel)**		**02**	**144016**	**6.450,00**
B		**Operation panel/front (please select one):**				
	B1	Front panel for series HighTIG RS with display and controls		46	138894	1.480,00
	B2	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	750,00
B3		**External operation panel:**				
	B3.1	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	750,00
	B3.2	External operation panel in housing for manual process control incl. displays for series HighTIG with 5 m cable (only with 139.042 and job panel)		46	139438	1.340,00
	B3.3	External operation panel mounted in ext. controller incl. displays for series HighTIG with 5 m cable (only with 139.042)		46	139436	1.340,00
	B3.4	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	B3.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
C		**Interface connection (please select one):**				
	C1	Interface CANopen for RS series		17	117428	1.980,00
	C2	Bus interface Profibus-DP for RS series		17	117430	1.980,00
	C3	Bus interface DeviceNet for RS series		17	117432	1.980,00
	C4	Bus interface Interbus for RS series		17	117436	1.980,00
	C5	Bus interface ProfiNET-IO for RS series		17	117438	1.980,00
	C6	Bus interface RS485 for RS series		17	139818	597,00
	C7	Interface Ethercat for RS series		17	141746	1.980,00
	C8	Bus interface EtherNet/IP for RS series		17	146338	1.980,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C9	Bus interface Modbus RTU RS485 for RS series		17	158834	1.850,00
	C10	Bus interface Modbus TCP for RS series		17	158836	1.850,00
	C11a	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	C11b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C12a	Analogue interface for RS series incl. socket 24 pol.		17	113788	1.300,00
	C12b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C13a	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	450,00
	C13b	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	C13c	Connection for automated welding HP, SM, HT - emerg. STOP, welding ON, arc OK - 1 x control volage 0 - 10 V - socket 24 pol.		46	158270	840,00
	C13d	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00
	C14	Internal wiring for HighTIG 452/552 DC for hand welding application without interface		46	144058	375,00

D Trolley:

	D1	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00

E Water cooling:

	E1	Water cooling unit model WK 350		46	144008	1.200,00
	E2	Water flow control device mounted in the water cooler		46	02610156	265,00
	E3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

F Option cold wire:

	F1	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	138921	680,00
	F2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	F3	Cold Wire Feed KDZF with Feed Tube for TM 450 W (Mechanic with Motor) for Push-Pull use		05	141614	2.250,00
	F4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00

G External HF Box:

Required in manual mode when more than 8 m torch and 8 m extension are used, in automated mode when more than 8 m torch assembly are used

	G1	Extra charge for external HF box for HighTIG RS incl. HF ignition and torch connection		31	144068	1.690,00
	G2a	Connection cable 5 m for HighTIG RS to external HF box		38	138922	820,00
	G2b	Connection cable 10 m for HighTIG RS to external HF box		38	138924	1.130,00

H Accessories:

	H1	Regulator argon/CO2, single stage		46	01200300	68,00
	H2a	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	H2b	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	H2c	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	H3a	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	H3b	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	H4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	H5	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	H6	Euro connector for portable TIG welding units		46	110430	55,00
	H7	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

I WeldFACTORY:

control, documentation and evaluation of welding parameters, job management (see section 10.5 of the general catalogue)

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2. TIG AC/DC welding units

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.1. LiteTIG 190 AC/DC

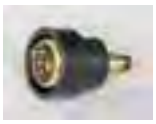
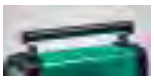
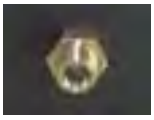
Primary:	
Supply:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (TIG/MMA):	30 A / 35 A
cos phi:	0.98
TIG operation:	
Open circuit voltage:	68 V
Welding voltage:	10 - 17.2 V
Welding current (DC):	5 - 190 A
Welding current (AC):	10 - 180 A
Duty cycle 20 % (10 min.):	180 A (40 °C)
Duty cycle 60 % (10 min.):	140 A (40 °C)
Duty cycle 100 %	115 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Modes:	TIG (AC/DC), MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Programmable jobs:	15 jobs
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 16 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 170 A
Arc force:	up to 170 A
AC frequency:	60 - 200 Hz
Balance:	15 - 70 %
Power socket:	via remote control connection
Power source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Torch cooling:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 5 m long with plug Schuko
Gas hose:	2 m
Transport:	adjustable carry/shoulder strap
Norm:	EN 60974/1 S / CE
Weight:	8.0 kg
Dimensions l x w x h:	410 x 150 x 240 mm

MMA/stick electrode operation:	
Stick electrode:	1.5 - 4 mm
Open circuit voltage:	68 V
Welding voltage:	20 - 26.8 V
Welding current:	20 - 170 A
Duty cycle 30 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	135 A (40 °C)
Duty cycle 100 %	90 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit LiteTIG 190 AC/DC**					
	A	**TIG welding unit LiteTIG 190 AC/DC (Merkle TCG connector)**		**48**	**SET155842**	**2.415,00**
	AB	**TIG welding unit LiteTIG 190 AC/DC with accessories (Merkle TCG connector)**		**48**	**SET155844**	**2.465,00**
	ABC1	**TIG welding unit LiteTIG 190 AC/DC with access. and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET155846**	**2.715,00**
	ABC2	**TIG welding unit LiteTIG 190 AC/DC with access. and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET155848**	**2.795,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1a	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, MobiTIG 180, LiteTIG 190 inner dimensions 59 x 47 x 21 cm		46	n01200372	218,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	D5	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D6	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	D7	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D8	Handle set for LiteTIG 190/210		46	158342	32,50
	D9a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D9b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

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Subject to change. Valid from 18.05.2020

5.2.2. LiteTIG 210 AC/DC

Primary:	
Supply:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (TIG/MMA):	22 A / 25 A
cos phi:	0.99
TIG operation:	
Open circuit voltage:	73 V
Welding voltage:	10.2 - 18.4 V
Welding current (DC):	5 - 210 A
Welding current (AC):	10 - 200 A
Duty cycle 20 % (10 min.):	210 A (40 °C)
Duty cycle 60 % (10 min.):	140 A (40 °C)
Duty cycle 100 %	130 A (40 °C)

Protection class:	IP 23
Insulation class:	F
Cooling:	AF
Modes:	TIG (AC/DC), MMA-welding
Parameter:	current 1, current 2, reduction, final current, gas post flow
Programmable jobs:	15 jobs
Adjustments:	continuously at rotary switch
Current control:	at the unit, at the torch, at the remote control
Functions:	2 stroke, 4 stroke, 4 stroke with current 2
Ignition:	HF / LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 16 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 170 A
Arc force:	up to 170 A
AC frequency:	50 - 200 Hz
Balance:	10 - 70 %
Power socket:	via remote control connection
Power source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Torch cooling:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 5 m long with plug Schuko
Gas hose:	2 m
Transport:	adjustable carry/shoulder strap
Norm:	EN 60974/1 S / CE
Weight:	8.9 kg
Dimensions l x w x h:	410 x 150 x 240 mm

MMA/stick electrode operation:	
Stick electrode:	1.5 - 4 mm
Open circuit voltage:	73 V
Welding voltage:	20 - 26.8 V
Welding current:	20 - 170 A
Duty cycle 30 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)
Duty cycle 100 %	120 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit LiteTIG 210 AC/DC**					
	A	**TIG welding unit LiteTIG 210 AC/DC (Merkle TCG connector)**		**48**	**SET155868**	**2.785,00**
	AB	**TIG welding unit LiteTIG 210 AC/DC with accessories (Merkle TCG connector)**		**48**	**SET155870**	**2.835,00**
	ABC1	**TIG welding unit LiteTIG 210 AC/DC with access. and torch TH 202 G, 4 m (Merkle TCG connector)**		**48**	**SET155872**	**3.085,00**
	ABC2	**TIG welding unit LiteTIG 210 AC/DC with access. and torch TH 202 G, 8 m (Merkle TCG connector)**		**48**	**SET155874**	**3.165,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1a	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	D1b	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, MobiTIG 180, LiteTIG 190 inner dimensions 59 x 47 x 21 cm		46	n01200372	218,00
	D2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00
	D3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	D4	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	D5	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00
	D6	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00

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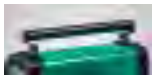
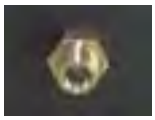
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D8	Handle set for LiteTIG 190/210		46	158342	32,50
	D9a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D9b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

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Subject to change. Valid from 18.05.2020

5.2.3. LogiTIG 221 AC/DC

Primary:		
Supply:	1 x 230 V	
Frequency:	50 / 60 Hz	
cos phi:	0.95	
TIG operation:		
Open circuit voltage:	80 V	
Welding voltage:	10 - 18.8 V	
Welding current (DC):	3 - 220 A	
Welding current (AC):	5 - 220 A	
Duty cycle 25 % (10 min.):		220 A* (40 °C)
Duty cycle 30 % (10 min.):		200 A* (40 °C)
Duty cycle 40 % (10 min.):	220 A** (20 °C)	
Duty cycle 45 % (10 min.):	200 A** (20 °C)	
Duty cycle 60 % (10 min.):	190 A** (20 °C)	150 A (40 °C)
Duty cycle 100 %:	170 A (20 °C)	130 A (40 °C)
Prim. cont. power:	2.8 kVA	
Prim. cont. current:	12 A	
Prim. max. current:	24 A	

Optional: with water cooling unit WK 210 and trolley TW 112, with drawer as an option.

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Operation modes:	TIG (DC and AC), MMA/stick electrode welding
Button:	current 1, current 2, down slope, final current, gas post flow time
Jobs:	1 - 28
Open circuit voltage:	< 24 V (option)
Setting:	continuous at rotary switch
Energy control:	at the unit, at the torch, at the hand remote control, foot pedal
Functions:	2 stroke, 4 stroke, 4 stroke with 2 currents
Ignition:	HF/LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulsation slow:	0.1 - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Pulse shape:	"hard"/"soft"
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre-flow time:	0 - 2 s
Gas post-flow time:	0 - 25 s
Pos. igniton impuls:	0 - 200 ms
Balance:	± 91%
AC frequency:	50 - 200 Hz
AC curve shape:	square, soft, AC special, sinus (50 Hz)
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 220 A
Arc force:	up to 220 A
LED green:	mains ON
LED green:	welding ON
LED yellow:	temperature protection
LED red:	failure
Socket:	remote control

*: slow-blow fuse 16 A
**: slow blow fuse min. 20 A (and CEE plug)

Power source:	inverter
Ignition:	HF ignition generator
Torch connection:	Merkle TCG-connector and 5-pole socket
Torch cooling:	gas option: water
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm² 5 m long with plug schuko
Gas hose:	2 m
Connection for water cooling unit:	option
Handle:	on top of the machine
Norm:	EN 60974/1 S / CE
Weight:	17 kg
Dimensions l x w x h:	495 x 210 x 450 mm

MMA/stick electrode operation:

Stick electrodes:	1.5 - 3.25 mm	
Open circuit voltage:	80 V (with VRD < 24 V)	
Welding voltage:	20 - 27 V	
Welding current:	20 - 180 A	
Duty cycle 30 % (10 min.):		180 A (40 °C)
Duty cycle 60 % (10 min.):	170 A** (20 °C)	130 A (40 °C)
Duty cycle 100 %:	140 A** (20 °C)	110 A (40 °C)
Prim. cont. power:	3.2 kVA	
Prim. cont. current:	14 A	
Prim. max. current:	26 A	

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit LogiTIG 221 AC/DC**					
	A	**TIG welding unit LogiTIG 221 AC/DC (Merkle TCG connector)**		**49**	**SET143074**	**4.570,00**
	AB	**TIG welding unit LogiTIG 221 AC/DC with accessories (Merkle TCG connector)**		**49**	**SET143096**	**4.650,00**
	ABC1	**TIG welding unit LogiTIG 221 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**49**	**SET143098**	**4.900,00**
	ABC2	**TIG welding unit LogiTIG 221 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**49**	**SET143100**	**4.980,00**
	With water cooler and trolley TW 112:					
		TIG welding unit LogiTIG 221 AC/DC incl. water cooler WK 210 and trolley TW 112		**49**	**SET143102**	**5.830,00**
		TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112		**49**	**SET143104**	**5.910,00**
		TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112 and torch TH 452 W, 4 m		**49**	**SET143106**	**6.290,00**
		TIG welding unit LogiTIG 221 AC/DC with accessories incl. water cooler WK 210 and trolley TW 112 and torch TH 452 W, 8 m		**49**	**SET143108**	**6.330,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00

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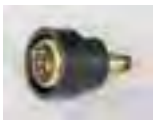
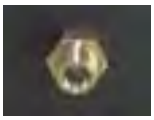
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D2a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D2b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D3	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	D4	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D5	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D6	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D7	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D8	Euro connector for portable TIG welding units		46	110430	55,00
	D9a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D9b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for using water cooler:

	E1	Water cooling unit model WK 210		46	143136	990,00
	E2	Socket for water cooling unit 6-pol. for LogiTIG 220/221 AC/DC		46	125928	169,00
	E3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/fabric hose assembly		10	145080	405,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/fabric hose assembly		10	145082	445,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		10	145084	500,00

F Robot and automation accessories:

	F1	Connection for automated welding for LogiTIG 220/221 AC/DC - emerg. STOP, welding ON, arc OK - socket 6 pol. - increased HF ignition		46	125930	294,00
	F2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	F3	Connection for automated welding - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.		46	01301123	1.099,00
	F4	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.4. Water cooling unit WK 210

Power supply:	1 x 230 V
Frequency:	50 / 60 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr.connection:	cable with 6-pole plug
water connection:	2 quick couplings
Weight:	15 kg
Dimensions l x w x h:	590 x 210 x 210 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Water cooling unit:**					
	A	**Water cooling unit model WK 210**		**46**	**143136**	**990,00**
B	**Accessories:**					
	B1	Socket for water cooling unit 6-pol. for LogiTIG 220/221 AC/DC		46	125928	169,00
	B2	Socket for water cooling unit 6-pol. for MobiTIG 284/304 DC and MobiMIG 320/321 K		46	124858	169,00
	B3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

5.2.5. LogiTIG 240 AC/DC

Primary:	
Supply:	1 x 230 V / 3 x 400 V*
Frequency:	50 / 60 Hz
cos phi:	0.95
TIG operation:	
Open circuit voltage:	95 V
Welding voltage:	10 - 17.2 V / 19.6 V*
Welding current (DC):	3 - 180 A / 240 A*
Welding current (AC):	5 - 180 A / 240 A*
Duty cycle 35 % (10 min.):	240 A* (20 °C)
Duty cycle 60 % (10 min.):	160 A (40 °C)
Duty cycle 100 %:	130 A (40 °C)
Prim. cont. power:	3.7 kVA
Prim. cont. current:	16 A
Prim. max. current:	23 A / 32 A*

Optional: with water cooling unit WK 230 and trolley TW 112, with drawer as an option.

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Operation modes:	TIG (DC and AC), MMA/stick electrode welding
Button:	current 1, current 2, down slope, final current, gas post flow time
Jobs:	1 - 6
Setting:	continuous at rotary switch
Energy control:	at the unit, at the torch, at the hand remote control, foot pedal
Functions:	2 stroke, 4 stroke, 4 stroke with 2 currents
Ignition:	HF/LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulsation slow:	0.1 - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Pulse shape:	"hard" / "soft"
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre-flow time:	0 - 2 s
Gas post-flow time:	0 - 25 s
Pos. igniton impuls:	0 - 200 ms
Balance:	± 91 %
AC frequency:	50 - 200 Hz
AC curve shape:	square, soft, sinus
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 160 A / 200 A*
Arc force:	up to 160 A / 200 A*
LED:	mains ON
LED:	welding ON
LED:	temperature protection
LED:	failure
Socket:	remote control
Power source:	inverter
Ignition:	HF ignition generator
Torch connection:	Merkle TCG-connector and 5-pole socket

Torch cooling:	gas option: water
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	5 x 4.0 mm² 5 m long with plug 400 V/32 A
Gas hose:	2 m
Connection for water cooling unit:	option
Handle:	on top of the machine
Norm:	EN 60974/1 S / CE
Weight:	24.5 kg
Dimensions l x w x h:	535 x 230 x 465 mm

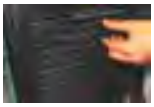
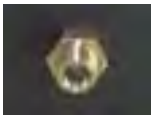
MMA/stick electrode operation:

Stick electrodes:	1.5 - 4 mm
Open circuit voltage:	100 V
Welding voltage:	20 - 26.4 V / 28 V*
Welding current:	5 - 160 A / 200 A*
Duty cycle 40 % (10 min.):	200 A* (20 °C)
Duty cycle 60 % (10 min.):	150 A (40 °C)
Duty cycle 100 %:	120 A (40 °C)
Prim. cont. power:	4.1 kVA
Prim. cont. current:	16 A / 18 A*
Prim. max. current:	26 A / 34 A*

* BiPower-Technology:
Automatic switching to "High Current" mode at supply voltage 3phase 400 V/32 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit LogiTIG 240 AC/DC**					
	A	**TIG welding unit LogiTIG 240 AC/DC (Merkle TCG connector)**		**49**	**SET113226**	**4.990,00**
	AB	**TIG welding unit LogiTIG 240 AC/DC with accessories (Merkle TCG connector)**		**49**	**SET113228**	**5.070,00**
	ABC1	**TIG welding unit LogiTIG 240 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**49**	**SET113230**	**5.320,00**
	ABC2	**TIG welding unit LogiTIG 240 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**49**	**SET113232**	**5.400,00**
	With water cooler and trolley TW 112:					
		TIG welding unit LogiTIG 240 AC/DC incl. water cooler WK 230 and trolley TW 112		**49**	**SET113302**	**6.280,00**
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112		**49**	**SET113304**	**6.360,00**
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112 and torch TH 452 W, 4 m		**49**	**SET113290**	**6.740,00**
		TIG welding unit LogiTIG 240 AC/DC with accessories incl. water cooler WK 230 and trolley TW 112 and torch TH 452 W, 8 m		**49**	**SET113292**	**6.780,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Regulator argon/CO2 standard version		46	107018	58,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1	Coupling 230/400 V 32 Socket 400 V/32 A to plug 230V/16 A		46	110612	45,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D2	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00
	D3a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D3b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D4	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	D5	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D6	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D7	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D8	Filter frame incl. filter for TIG 300 DC, LT 240 AC/DC, C 82		46	112548	105,00
	D9	Filter for TIG/E 300 DC, C 82 LT 240 AC/DC (min. 10 pieces)	10 pcs	46	112550	3,25
	D10	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D11	Euro connector for portable TIG welding units		46	110430	55,00
	D12a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D12b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D13	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for using water cooler:

	E1	Water cooling unit model WK 230		46	02610142	990,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E2	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	57,00
	E3	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	E4	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/fabric hose assembly		10	145080	405,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/fabric hose assembly		10	145082	445,00
	E6	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		10	145084	500,00

F Robot and automation accessories:

	F1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	02010907	240,00
	F2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	F3	Connection for automated welding - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.		46	01301123	1.099,00
	F4	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.6. Water cooling unit WK 230

Power supply:	1 x 400 V / 230 V
Frequency:	50 / 60 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	18 kg
Dimensions l x w x h:	610 x 230 x 215 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Water cooling unit:**					
	A	**Water cooling unit model WK 230**		**46**	**02610142**	**990,00**
B	**Accessories:**					
	B1	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	57,00
	B2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.7. LogiTIG 300 AC/DC

Primary:	
Supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.95
TIG operation:	
Open circuit voltage:	70 V
Welding voltage:	10 - 22 V
Welding current:	5 - 300 A
Duty cycle 50 % (10 min.):	300 A (40 °C)
Duty cycle 60 % (10 min.):	280 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)
Prim. cont. power:	10.4 kVA
Prim. cont. current:	15 A
Prim. max. current:	19 A

Optional: with water cooling unit WK 300 and trolley TW 112, with drawer as an option.

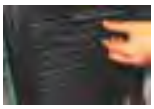
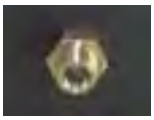
Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Operation modes:	TIG (DC und AC), MMA/stick electrode welding
Button:	current 1, current 2, down slope, final current, gas post flow time
Jobs:	28
Setting:	continuous at rotary switch
Energy control:	at the unit, at the torch, at the hand remote control, foot pedal
Functions:	2 stroke, 4 stroke, 4 stroke with 2 currents
Ignition:	HF/LiftTIG
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulsation slow:	0.1 - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Pulse shape:	"hard" / "soft"
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre-flow time:	0 - 2 s
Gas post-flow time:	0 - 25 s
Pos. igniton impuls:	0 - 200 ms
Balance:	± 91 %
AC frequency:	50 - 200 Hz
AC curve shape:	square, soft, sinus
Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 300 A
Arc force:	up to 300 A
LED green:	mains ON
LED green:	welding ON
LED yellow:	temperature protection
LED red:	failure
Socket:	remote control
Cover:	transparent, to protect the control panel
Power source:	inverter
Ignition:	HF ignition generator
Torch connection:	Merkle TCG-connector and 5-pole socket
Torch cooling:	gas option: water
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	5 x 4.0 mm² 5 m long with plug 400 V/32 A
Gas hose:	2 m
Connection for water cooling unit: option	
Handle:	on top of the machine
Norm:	EN 60974/1 S / CE
Weight:	39.2 kg
Dimensions l x w x h:	600 x 300 x 575 mm

MMA/stick electrode operation:

Stick electrodes:	1.5 - 4 mm
Open circuit voltage:	70 V
Welding voltage:	20 - 32 V
Welding current:	5 -300 A
Duty cycle 40 % (10 min.):	300 A (40 °C)
Duty cycle 60 % (10 min.):	270 A (40 °C)
Duty cycle 100 % ED:	230 A (40 °C)
Prim. cont. power:	13.1 kVA
Prim. cont. current:	19 A
Prim. max. current:	25 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit LogiTIG 300 AC/DC**					
	A	**TIG welding unit LogiTIG 300 AC/DC (Merkle TCG connector)**		**02**	**SET117236**	**6.950,00**
	AB	**TIG welding unit LogiTIG 300 AC/DC with accessories (Merkle TCG connector)**		**02**	**SET117238**	**7.070,00**
	ABC1	**TIG welding unit LogiTIG 300 AC/DC with accessories and torch TH 202 G, 4 m (Merkle TCG connector)**		**02**	**SET117240**	**7.320,00**
	ABC2	**TIG welding unit LogiTIG 300 AC/DC with accessories and torch TH 202 G, 8 m (Merkle TCG connector)**		**02**	**SET117242**	**7.400,00**
		With water cooler and trolley TW 112:				
		TIG welding unit LogiTIG 300 AC/DC incl. water cooler WK 300 and trolley TW 112		**02**	**SET117248**	**8.080,00**
		TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112		**02**	**SET117250**	**8.200,00**
		TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112 and torch TH 452 W, 4 m		**02**	**SET117244**	**8.580,00**
		TIG welding unit LogiTIG 300 AC/DC with accessories incl. water cooler WK 300 and trolley TW 112 and torch TH 452 W, 8 m		**02**	**SET117246**	**8.620,00**
	Option	**Drawer option for trolley TW 112 incl. one drawer**		**46**	**138940**	**298,00**
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly**		**10**	**129516**	**280,00**
	C2	**TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly**		**10**	**129518**	**370,00**
D	**Accessories:**					
	D1	TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		10	129520	425,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D2a	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	D2b	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	D3	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	D4	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D5	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D6	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D7	Filter frame incl. filter for LogiTIG 300 AC/DC, HighTIG 352 DC, MobiMIG 320 K (reduced duty cycle)		46	117530	105,00
	D8	Filter for LogiTIG 300 AC/DC, (min. 10 pieces)	10 pcs	46	117532	3,15
	D9	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00
	D10	Euro connector for portable TIG welding units		46	110430	55,00
	D11a	Option external gas connection TIG units as: 1/4" external thread, current: 50 mm², torch plug: 5-pol		46	153800	29,00
	D11b	Option external gas connection TIG units as: quick coupling 2.7, current: 50 mm², torch plug: 5-pol		46	153802	29,00
	D12	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Accessories for using water cooler:

	E1	Water cooling unit model WK 300		46	02610143	990,00
	E2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	E3	TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/fabric hose assembly		10	145080	405,00
	E4	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/fabric hose assembly		10	145082	445,00
	E5	TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		10	145084	500,00

F Robot and automation accessories:

	F1	Connection for automated welding for LogiTIG 300 AC/DC - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	118068	240,00
	F2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	F3	Connection for automated welding for LogiTIG 300 AC/DC - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.		46	118070	790,00
	F4	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00

G Accessories for synchron welding:

	G1	AC synchron welding incl. switch and socket		46	00503023	290,00
	G2	Test cable for AC synchron welding		46	00503024	124,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.8. Water cooling unit WK 300

Power supply:	1 x 400 V / 230 V
Frequency:	50 / 60 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficient pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Transformer:	400 / 230 V
Water pressure switch:	integrated
Functions:	automatic switch of fan and water pump
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight:	20 kg
Dimensions l x w x h:	600 x 300 x 260 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Water cooling unit:**					
	A	**Water cooling unit model WK 300**		**46**	**02610143**	**990,00**
B	**Accessories:**					
	B1	Connection socket WK, 6-pin. for TIG 300 DC LT 240 AC/DC, HighPULSE RS, HighTIG RS		46	103675	57,00
	B2	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.9. Insquare W 321 AC/DC

Primary:

Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.95

TIG DC- and AC-operation:

Open circuit voltage:	80 V
Welding voltage:	10 - 22.8 V
Welding current:	5 - 320 A
Duty cycle 60 % (10 min.):	320 A (40 °C)
Duty cycle 80 % (10 min.):	300 A (40 °C)
Duty cycle 100 %:	260 A (40 °C)
Prim. cont. power:	13.2 kVA
Prim. cont. current:	19 A
Prim. max. current:	22 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusodial, MMA/stick electrode square arc
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage
Adjusting:	2 rotary switches for selectors 1 and 2
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	OFF, high frequency, LiftTIG
Energy control:	at the machine, at the remote controls, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming
Program storage:	20 programs
AC frequency:	50 - 200 Hz
AC balance:	9 - 91 %
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	0 - 25 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Ignition impulse:	0 - 100 ms
Spot welding time:	0.1 - 2.5 s

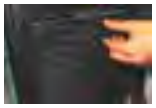
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 5 kHz
Hotstart time:	0 - 1.5 s
Hotstart current:	10 - 200 %
Arc force:	100 - 250 %
Button:	test protection deviceg
Button:	program selection
LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr.
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pole plug
Torch cooling:	integrated water cooling system
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 4 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	10 - 20 - 50 l cylinders
Lifting eyes:	4 pieces (option)
Weight:	140 kg
Dimensions l x w x h:	1020 x 476 x 970 mm incl. gas bottle holder

MMA/stick electrode operation:

Stick electrodes:	1.5 - 6 mm (Cel-suitable)
Open circuit voltage:	80 V
Welding voltage:	20 - 32.8 V
Welding current:	5 - 320 A
Duty cycle 60 % (10 min.):	320 A (40 °C)
Duty cycle 80 % (10 min.):	300 A (40 °C)
Duty cycle 100 %:	260 A (40 °C)
Prim. cont. power:	14.5 kVA
Prim. cont. current:	21 A
Prim. max. current:	27 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit Insquare W 321 AC/DC**					
	A	**TIG welding unit Insquare W 321 AC/DC**		**02**	**SET123790**	**9.995,00**
	AB	**TIG welding unit Insquare W 321 AC/DC with accessories**		**02**	**SET123792**	**10.115,00**
	ABC1	**TIG welding unit Insquare W 321 AC/DC with access. and torch TH 452 W, 4 m**		**02**	**SET123794**	**10.495,00**
	ABC2	**TIG welding unit Insquare W 321 AC/DC with access. and torch TH 452 W, 8 m**		**02**	**SET123796**	**10.535,00**
B	**Standard accessories:**					
	B1	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/fabric hose assembly**		**10**	**145086**	**415,00**
	C2	**TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/fabric hose assembly**		**10**	**145088**	**455,00**
D	**Accessories:**					
	D1	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/fabric hose assembly		10	145090	510,00
	D2	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	D3	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D4	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D6	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D7	Filter frame incl. filter for Insquare W 321 and 421		46	122626	105,00
	D8	Door for control panel with lock for Insquare 321 and 421		46	123836	165,00
	D9	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Robot and automation accessories:

	E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	02010907	240,00
	E2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	E3	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.		17	01903066	830,00
	E4	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	E5	Bus connection (EtherCAT)		17	101687	1.765,00

F Accessories for synchron welding:

	F1	AC synchron welding incl. switch and socket		46	00503023	290,00
	F2	Test cable for AC synchron welding		46	00503024	124,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

5.2.10. Insquare W 421 AC/DC

Primary:

Power supply:	3 x 400 V	
Frequency:	50 / 60 Hz	
cos phi:	0.95	

TIG DC- and AC-Operation:

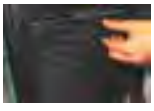
Open circuit voltage:	80 V	
Welding voltage:	10 - 26.8 V	
Welding current DC:	5 - 420 A	
Welding current AC:	5 - 400 A	
Duty cycle 40 % (10 min.):		420 A (40 °C)
Duty cycle 50 % (10 min.):	420 A (20 °C)	
Duty cycle 60 % (10 min.):	400 A (20 °C)	360 A (40 °C)
Duty cycle 100 %:	320 A (20 °C)	310 A (40 °C)
Prim. cont. power:	14.5 kVA	
Prim. cont. current:	21 A	
Prim. max. current:	28 A	

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusodial, MMA/stick electrode square arc
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage
Adjusting:	2 rotary switches for selectors 1 and 2
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	OFF, high frequency, LiftTIG
Energy control:	at the machine, at the remote controls, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming
Program storage:	20 programs
AC frequency:	50 - 200 Hz
AC balance:	9 - 91 %
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	0 - 25 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Ignition impulse:	0 - 100 ms
Spot welding time:	0.1 - 2.5 s

Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 5 kHz
Hotstart time:	0 - 1.5 s
Hotstart current:	10 - 200 %
Arc force:	100 - 250 %
Button:	test protection device
Button:	program selection
LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr.
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pole plug
Torch cooling:	integrated water cooling system
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 4 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	10 - 20 - 50 l cylinders
Lifting eyes:	4 pieces (option)
Weight:	150 kg
Dimensions l x w x h:	1020 x 476 x 970 mm incl. gas bottle holder and handle, without lifting eyes

MMA/stick electrode operation:

Stick electrodes:	1.5 - 6 mm (Cel-suitable)
Open circuit voltage:	80 V
Welding voltage:	20 - 36.8 V
Welding current:	5 - 420 A
Duty cycle 40 % (10 min.):	420 A (40 °C)
Duty cycle 60 % (10 min.):	360 A (40 °C)
Duty cycle 100 %:	300 A (40 °C)
Prim. cont. power:	14.5 kVA
Prim. cont. current:	21 A
Prim. max. current:	28 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit Insquare W 421 AC/DC**					
	A	**TIG welding unit Insquare W 421 AC/DC**		**02**	**SET122624**	**10.650,00**
	AB	**TIG welding unit Insquare W 421 AC/DC with accessories**		**02**	**SET122626**	**10.780,00**
	ABC1	**TIG welding unit Insquare W 421 AC/DC with access. and torch TH 452 W, 4 m**		**02**	**SET122628**	**11.160,00**
	ABC2	**TIG welding unit Insquare W 421 AC/DC with access. and torch TH 452 W, 8 m**		**02**	**SET122630**	**11.200,00**
B	**Standard accessories:**					
	B1	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
	C1	**TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/fabric hose assembly**		**10**	**145086**	**415,00**
	C2	**TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/fabric hose assembly**		**10**	**145088**	**455,00**
D	**Accessories:**					
	D1	TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/fabric hose assembly		10	145090	510,00
	D2	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	D3	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D4	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D6	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	D7	Filter frame incl. filter for Insquare W 321 and 421		46	122626	105,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D8	Door for control panel with lock for Insquare 321 and 421		46	123836	165,00
	D9	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	D10	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Robot and automation accessories:

	E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	02010907	240,00
	E2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	E3	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.		17	01903066	830,00
	E4	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	E5	Bus connection (EtherCAT)		17	101687	1.765,00

F Accessories for synchron welding:

	F1	AC synchron welding incl. switch and socket		46	00503023	290,00
	F2	Test cable for AC synchron welding		46	00503024	124,00

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Subject to change. Valid from 18.05.2020

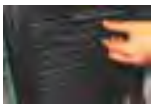
5.2.11. Insquare W 600 AC/DC

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.95
TIG DC- and AC-Operation:	
Open circuit voltage:	80 V
Welding voltage:	10 - 34 V
Welding current:	20 - 600 A
Duty cycle 80 % (10 min.):	600 A
Duty cycle 100 %:	500 A (40 °C)
Prim. cont. power:	24.2 kVA
Prim. cont. current:	35 A
Prim. max. current:	42 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	TIG DC (-), TIG DC (+), TIG DC (-) w. start puls (+), TIG AC "noise reduced", TIG AC "square arc", TIG AC "balanced TIG", MMA/stick electrode (-), MMA/stick electrode (+), MMA/stick electrode sinusodial, MMA/stick electrode square arc
Selector 1:	current 1, time 1, upslope and downslope time, start current, final current, ignition impulse, spot w. time, gas pre- and post-flow time
Selector 2:	current 2, time 2 (for pulsation), AC balance, AC frequency, hotstart time a. current, arc force, stick electrode diameter, display voltage
Adjusting:	2 rotary switches for selectors 1 and 2
Digital displays:	2 LED displays with pre-indication and hold function for current, voltage, time, frequency
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	OFF, high frequency, LiftTIG
Energy control:	at the machine, at the remote controls, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check, test, programming
Program storage:	20 programs
AC frequency:	50 - 200 Hz
AC balance:	9 - 91 %
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	0 - 25 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Ignition impulse:	0 - 100 ms
Spot welding time:	0.1 - 2.5 s

Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 5 kHz
Hotstart time:	0 - 1.5 s
Hotstart current:	10 - 200 %
Arc force:	100 - 250 %
Button:	test protection deviceg
Button:	program selection
LEDs:	mains ON, temperature protection failure, protection device, hold function, start current, up slope, down slope, current 1 + 2, final curr.
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch connection:	Euro connector with 5-pole plug
Torch cooling:	integrated water cooling system
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 6 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Gas bottle holder:	10 - 20 - 50 l cylinders
Lifting eyes:	4 pieces (option)
Weight:	255 kg
Dimensions l x w x h:	1055 x 630 x 1290 mm incl. gas bottle holder and handle, without lifting eyes

MMA/stick electrode operation:	
Stick electrodes:	1.5 - 6 mm (Cel-suitable)
Open circuit voltage:	80 V
Welding voltage:	20 - 44 V
Welding current:	5 - 600 A
Duty cycle 50 % (10 min.):	600 A (40 °C)
Duty cycle 60 % (10 min.):	550 A (40 °C)
Duty cycle 100 %:	450 A (40 °C)
Prim. cont. power:	25.6 kVA
Prim. cont. current:	37 A
Prim. max. current:	50 A

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**TIG AC/DC welding unit Insquare W 600 AC/DC**					
	A	**TIG welding unit Insquare W 600 AC/DC**		**02**	**SET100304**	**20.035,00**
	AB	**TIG welding unit Insquare W 600 AC/DC with accessories**		**02**	**SET100306**	**20.295,00**
	ABC	**TIG welding unit Insquare W 600 AC/DC with accessories and torch TH 600 W, 8 m**		**02**	**SET100308**	**20.870,00**
B	**Standard accessories:**					
	B1	Earth lead 120 mm², 4 m long with plug and earth clamp		46	02210396	243,00
	B2	Regulator argon/CO2, single stage		46	01200300	68,00
C	**Welding torches:**					
		TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		**10**	**104410**	**575,00**
D	**Accessories:**					
	D1	TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		10	104416	615,00
	D2	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
	D3	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	D4	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	D5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	D6	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	D7	Filter frame incl. filter for IQ 300/420/600, CM 350/400, RM 3000/4000, reduced duty cycle	2 pcs	46	00501047	105,00
	D8	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	3,50

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Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	D9	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	D10	Mains plug 5-pol. CEE, 63 A, 400 V		07	01201702	96,00
	D11	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

E Robot and automation accessories:

	E1	Connection for automated welding - emerg. STOP, welding ON, arc OK - socket 6 pol.		46	02010907	240,00
	E2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	E3	Robot interface - 3 control channel (0-10 V) - emerg. STOP, welding ON, arc OK, - socket 24 pol.		17	01903066	830,00
	E4	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	E5	Bus connection (EtherCAT)		17	101687	1.765,00

F Accessories for synchron welding:

	F1	AC synchron welding incl. switch and socket		46	00503023	290,00
	F2	Test cable for AC synchron welding		46	00503024	124,00

6. TIG welding torches

Hand welding torches

6.1 TH 202 G
6.2 TH 452 W
6.3 TH 600 W

Machine welding torch

6.4 TM 452 W
6.5 Cold Wire Feed System KDZF

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

6.1. TH 202 G

TIG hand welding torch TH 202 G

gas cooled

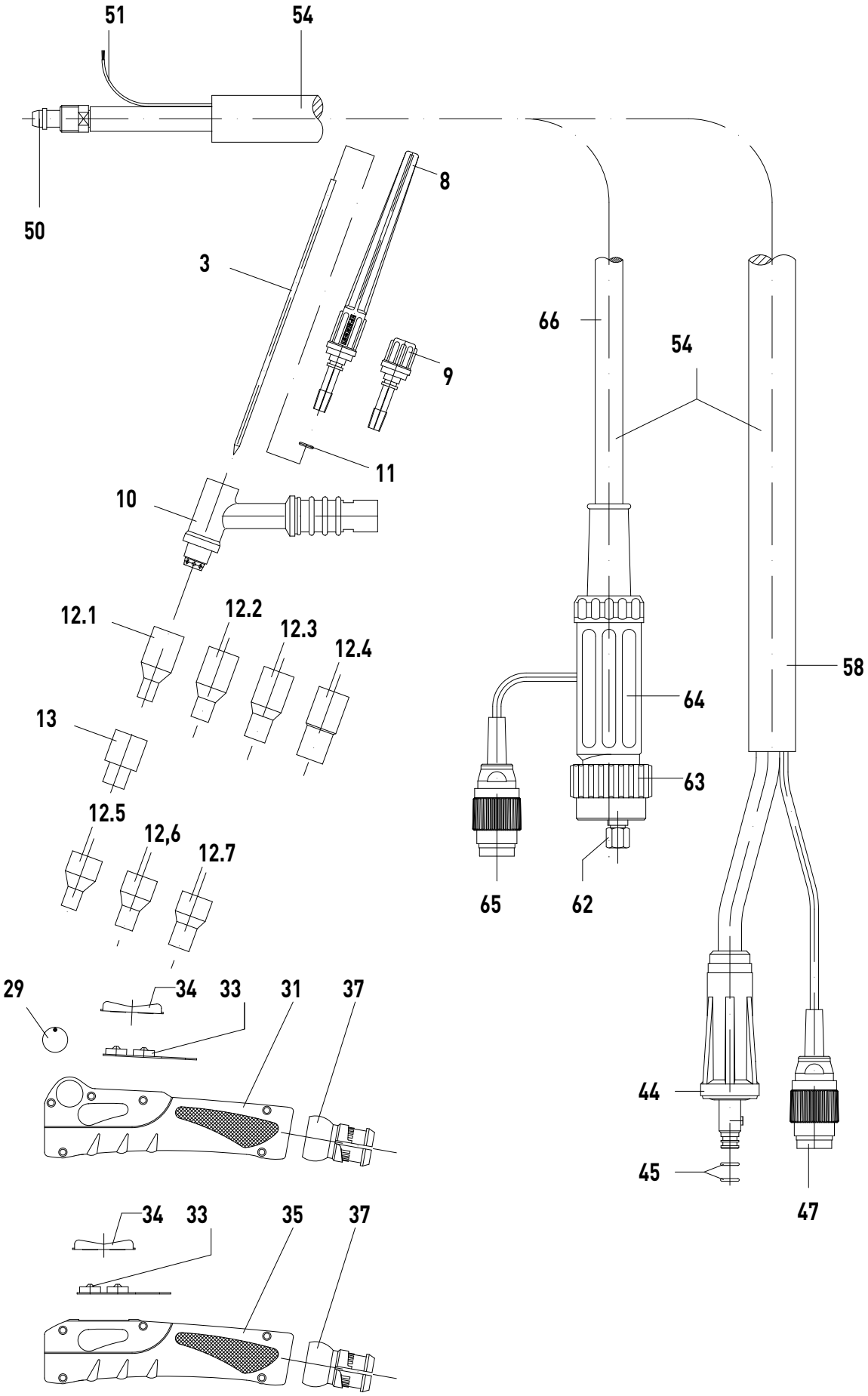
VERSIONS:

Standard

Potentiometer

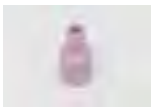
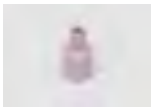
Optional: 4 button

TECHNICAL DATA:	
Cooling:	gas cooled
DC range:	200 A 40% duty cycle
AC range:	180 A 40% duty cycle*
	*at 30% positive polarity
Tungsten electrodes:	1.0 - 2.4 mm ∅
Weight:	230 g without hose assembly



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

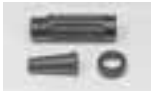
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
With Merkle TCG connection:						
		TIG hand welding torch TH 202 G, 4 m with TCG connector, leather/fabric hose assembly		**10**	**129516**	**280,00**
		TIG hand welding torch TH 202 G, 8 m with TCG connector, leather/fabric hose assembly		**10**	**129518**	**370,00**
		TIG hand welding torch TH 202 G, 8 m with TCG connector & potentiometer leather/fabric hose assembly		**10**	**129520**	**425,00**
With Euro connection:						
		TIG hand welding torch model TH 202 G-EURO, 4 m with Euro connector leather/fabric hose assembly		**10**	**129522**	**290,00**
		TIG hand welding torch model TH 202 G-EURO, 8 m with Euro connector leather/fabric hose assembly		**10**	**129526**	**380,00**
		TIG hand welding torch model TH 202 G-EURO, 8 m with Euro connector & potentiometer leather/fabric hose assembly		**10**	**129528**	**435,00**
With Euro connection for HighPULSE/MobiMIG:						
		TIG hand welding torch TH 202 G-MAG, 4 m for HighPULSE 28x/35x K and MobiMIG with Euro connector leather/fabric hose assembly		**10**	**133632**	**270,00**
		TIG hand welding torch TH 202 G-MAG, 8 m for HighPULSE 28x/35xK and MobiMIG with Euro connector leather/fabric hose assembly		**10**	**129532**	**350,00**
Option 4 buttons:						
		Option 4 buttons for Merkle TH TIG torches functions: torch trigger1 and 2 / up, down		10	156930	135,00
Standard equipment: 2.4 mm, ceramic 10.0						
Spare parts and consumables:						
	3.1	Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,20
	3.2	Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	1,90
	3.3	Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	3,70
	8.1	Back cap "quick TIG" 1.0 mm, long TH 161/201/202 G		26	114184	22,40
	8.2	Back cap "quick TIG" 1.6 mm, long TH 161/201/202 G		26	114186	22,40
	8.3	Back cap "quick TIG" 2.4 mm, long TH 161/201/202 G		26	114188	22,40

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	9.1	Back cap "quick TIG" 1.0 mm, short TH 161/201/202 G		26	114190	20,80
	9.2	Back cap "quick TIG" 1.6 mm, short TH 161/201/202 G		26	114192	20,80
	9.3	Back cap "quick TIG" 2.4 mm, short TH 161/201/202 G		26	114194	20,80
	10	Torch neck TH 202 G		26	129510	55,00
	11	O ring 9 x 1.5	10 pcs	26	02210704	1,89
	12.1	Ceramic nozzle 6.5 mm TH 202 G screwable version	10 pcs	26	128808	2,06
	12.2	Ceramic nozzle 8.0 mm TH 202 G screwable version	10 pcs	26	128806	2,06
	12.3	Ceramic nozzle 10.0 mm TH 202 G screwable version	10 pcs	26	128804	2,06
	12.4	Ceramic nozzle 12.5 mm TH 202 G screwable version	10 pcs	26	127348	2,40
	12.5	Ceramic nozzle 6.5 mm TH 202 G short screwable version, for gas lens	10 pcs	26	128814	2,55
	12.6	Ceramic nozzle 8.0 mm TH 202 G short screwable version, for gas lens		26	128812	2,55
	12.7	Ceramic nozzle 10.0 mm TH 202 G short screwable version, for gas lens		26	128810	2,55
	13.1	Gas lens 1.0 mm TH 202 G		26	129148	23,90
	13.2	Gas lens 1.6 mm TH 202 G		26	129146	23,90
	13.3	Gas lens 2.4 mm TH 202 G		26	129122	23,90
	29	Adjustment wheel incl. potentiometer for TH torch		26	108354	44,00
	31	Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	12,50
	33	Pc board for TIG double button switch (for torch with ball joint)		26	107992	16,80
	34	Switch button (red) for TIG torch with ball joint		26	107994	2,90
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	12,10

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	37	Kinking protection for TIG handle		26	107998	11,70
	44	Merkle TCG connector plug (gas cooled) incl. rubber housing and 2 o-rings		26	109554	18,00
	45	O-ring 8 x 1.6	10 pcs	53	103544	1,20
	47	Torch plug for TIG-torch (standard)		26	02110380	24,00
	50.1	Cable assembly 4 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106868	80,00
	50.2	Power cable 8 m TH 201/202 G		26	106872	130,00
	50.3	Power cable 8 m TH 201/202 G-MAG		26	107048	130,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,21
	51.2	Control cable 5 x 0.5 LiYY no shield		26	107242	2,64
	54.1	Protection hose 4 m rubber / leather for TIG torch		26	114332	35,00
	54.2	Protection hose 8 m rubber / leather for TIG torch		26	114334	49,00
	58.1	Cable assembly 4 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106866	165,00
	58.2	Cable assembly 8 m, TH 201/202 G incl. Merkle TCG connector, control cable 3 x 0.5		26	106870	250,00
	58.3	Cable assembly 8 m, TH 201/202 G incl. Merkle TCG connector, control cable 5 x 1.5		26	106871	255,00

Hose assembly with Euro connector:

	62.1	Brass body for TIG Euro connector incl. nut 5/8"		26	01340048	19,50
	62.2	Brass body central connector MAG gas cooled		22	02511401	21,00
	63	Sleeve nut black	pc	22	02510300	
	64.1	Kinking protection at machine side TIG Euro connector (set 3 pieces)		26	01340049	7,70
	64.2	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	65	Torch plug for TIG-torch (standard)		26	02110380	24,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
66.1	Cable assembly 4 m, TH 201/202 G incl. Euro connector, control cable 3 x 0.5		26	108504	175,00
66.2	Cable assembly 8 m, TH 201/202 G incl. Euro connector, control cable 3 x 0.5		26	108506	260,00
66.3	Cable assembly 8 m, TH 201/202 G for torch with potentiometer incl. Euro connector, control cable 5 x 0.5		26	108507	265,00
66.4	Cable assembly 4 m, TH 201/202 G-MAG incl. Euro connector, control cable 3 x 0.5		26	133634	150,00
66.5	Cable assembly 8 m, TH 201/202 G-MAG incl. Euro connector, control cable 3 x 0.5		26	107047	235,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

6.2. TH 452 W

TIG hand welding torch TH 452 W

water cooled

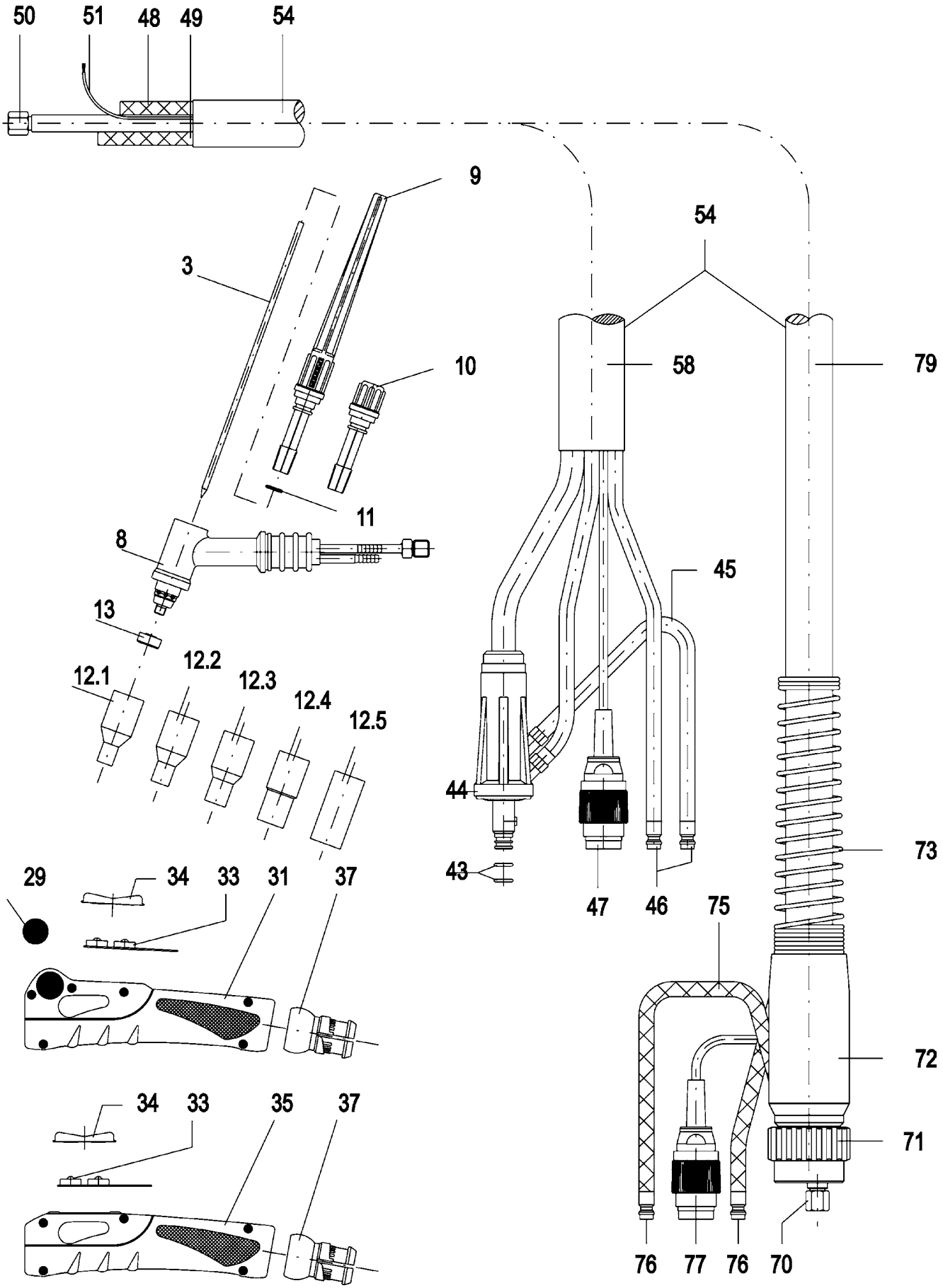
VERSIONS:

Standard

Potentiometer

Optional: 4 button

TECHNICAL DATA:	
Cooling:	water cooled
DC range:	425 A 60% duty cycle
AC range:	385 A 60% duty cycle*
	*at 30% positive polarity
Tungsten electrodes:	1.0 - 4.0 mm ∅
Weight:	240 g without hose assembly



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

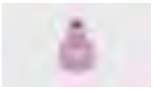
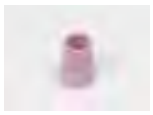
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
With Merkle TCG connection:						
		TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector, leather/fabric hose assembly		**10**	**145080**	**405,00**
		TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector, leather/fabric hose assembly		**10**	**145082**	**445,00**
With Merkle TCG connection and potentiometer:						
		TIG hand welding torch TH 452 W, 4 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		**10**	**145081**	**460,00**
		TIG hand welding torch TH 452 W, 8 m with Merkle TCG connector and potentiometer leather/fabric hose assembly		**10**	**145084**	**500,00**
With Euro connection:						
		TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector leather/fabric hose assembly		**10**	**145086**	**415,00**
		TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector leather/fabric hose assembly		**10**	**145088**	**455,00**
		TIG hand welding torch model TH 452 W-MAG, 8 m for HighPULSE with Euro connector leather/fabric hose assembly		**10**	**145092**	**440,00**
With Euro connection and potentiometer:						
		TIG hand welding torch model TH 452 W-EURO, 4 m with Euro connector and potentiometer leather/fabric hose assembly		**10**	**145087**	**470,00**
		TIG hand welding torch model TH 452 W-EURO, 8 m with Euro connector and potentiometer leather/fabric hose assembly		**10**	**145090**	**510,00**
Option 4 buttons:						
		Option 4 buttons for Merkle TH TIG torches functions: torch trigger1 and 2 / up, down		10	156930	135,00

Standard equipment: 3.2 mm, ceramic 12.5

! **Attention: Select gas nozzle holder (pos. 13) according to tungsten electrode diameter**

Spare parts and consumables:

	3.1	Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,20
	3.2	Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	1,90
	3.3	Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	3,70

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	3.4	Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	6,00
	3.5	Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	9,90
	8	Torch body TH 452 W		26	145016	101,00
	9.1	Back cap "quick TIG" 1.0 mm, long TH 452 W		26	142380	22,40
	9.2	Back cap "quick TIG" 1.6 mm, long TH 452 W		26	142382	22,40
	9.3	Back cap "quick TIG" 2.4 mm, long TH 452 W		26	142384	22,40
	9.4	Back cap "quick TIG" 3.2 mm, long TH 452 W		26	142400	22,40
	9.5	Back cap "quick TIG" 4.0 mm, long TH 452 W		26	142386	22,40
	10.1	Back cap "quick TIG" 1.0 mm, short TH 452 W		26	145430	20,80
	10.2	Back cap "quick TIG" 1.6 mm, short TH 452 W		26	145432	20,80
	10.3	Back cap "quick TIG" 2.4 mm, short TH 452 W		26	145434	20,80
	10.4	Back cap "quick TIG" 3.2 mm, short TH 452 W		26	145436	20,80
	10.5	Back cap "quick TIG" 4.0 mm, short TH 452 W		26	145438	20,80
	11	O ring 9 x 1.5	10 pcs	26	02210704	1,89
	12.1	Ceramic nozzle 6.5 TH 452 W	10 pcs	26	142402	2,60
	12.2	Ceramic nozzle 8.0 TH 452 W	10 pcs	26	142404	2,60
	12.3	Ceramic nozzle 10.0 TH 452 W	10 pcs	26	142406	2,60
	12.4	Ceramic nozzle 12.5 TH 452 W	10 pcs	26	142408	2,60
	12.5	Ceramic nozzle 15.0 TH 452 W	10 pcs	26	142410	2,60
	13.1	Gas nozzle holder 1.0 mm TH 452 W complete with integrated gas lense		26	142388	17,50
	13.2	Gas nozzle holder 1.6 mm TH 452 W complete with integrated gas lense		26	142390	17,50
	13.3	Gas nozzle holder 2.4 mm TH 452 W complete with integrated gas lense		26	142392	17,50
	13.4	Gas nozzle holder 3.2 mm TH 452 W complete with integrated gas lense		26	142394	17,50
	13.5	Gas nozzle holder 4.0 mm TH 452 W complete with integrated gas lense		26	142396	17,50
	29	Adjustment wheel incl. potentiometer for TH torch		26	108354	44,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	31	Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	12,50
	33	Pc board for TIG double button switch (for torch with ball joint)		26	107992	16,80
	34	Switch button (red) for TIG torch with ball joint		26	107994	2,90
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	12,10
	37	Kinking protection for TIG handle		26	107998	11,70
	43	O-ring 8 x 1.6	10 pcs	53	103544	1,20
	44	Merkle TCG connector plug (water cooled) incl. rubber housing and 2 o-rings		26	109556	34,10
	45	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	46	Coupling nipple for water	10 pcs	22	02510400	1,80
	47	Torch plug for TIG-torch (standard)		26	02110380	24,00
	48	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	49	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	50.1	Power cable TH 452 W, 4 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104378	50,00
	50.2	Power cable TH 452 W, 8 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104379	75,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,21
	51.2	Control cable 5 x 0.5 LiYY no shield		26	107242	2,64
	54.1	Protection hose 4 m rubber / leather for TIG torch		26	114332	35,00
	54.2	Protection hose 8 m rubber / leather for TIG torch		26	114334	49,00
	58.1	Cable assembly TH 452 W, 4 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107652	180,00
	58.2	Cable assembly TH 452 W, 8 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107660	220,00
	58.3	Cable assembly TH 452 W, 4 m 10 qmm, Merkle TCG connector (control cable 5 x 0.5)		26	155618	185,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	58.4	Cable assembly TH 452 W, 8 m 10 qmm, Merkle TCG connector (control cable 3 x 0.5)		26	107664	225,00

Hose assembly with Euro connector:

	70	Euro-connector for TIG torches, water cooled		26	01340061	23,00
	71	Sleeve nut black		22	02510300	9,80
	72	Kinking protection, intake water cooled		22	02510100	14,20
	73	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	75	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	76	Coupling nipple for water	10 pcs	22	02510400	1,80
	77	Torch plug for TIG-torch (standard)		26	02110380	24,00
	79.1	Cable assembly TH/TM 452 W, 4 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108362	190,00
	79.2	Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108364	235,00
	79.3	Cable assembly TH 452 W, 4 m 10 qmm, Euro connector, for torches with potentiometer (control cable 5 x 1.5)		26	155596	198,00
	79.4	Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, for torches with potentiometer (control cable 5 x 0.5)		26	108366	240,00
	79.5	Cable assembly TH 452 W, 8 m MAG 10 qmm, MIG/MAG Euro connector, (control cable 3 x 1.5)		26	117928	220,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

6.3. TH 600 W

TIG hand welding torch TH 600 W

water cooled

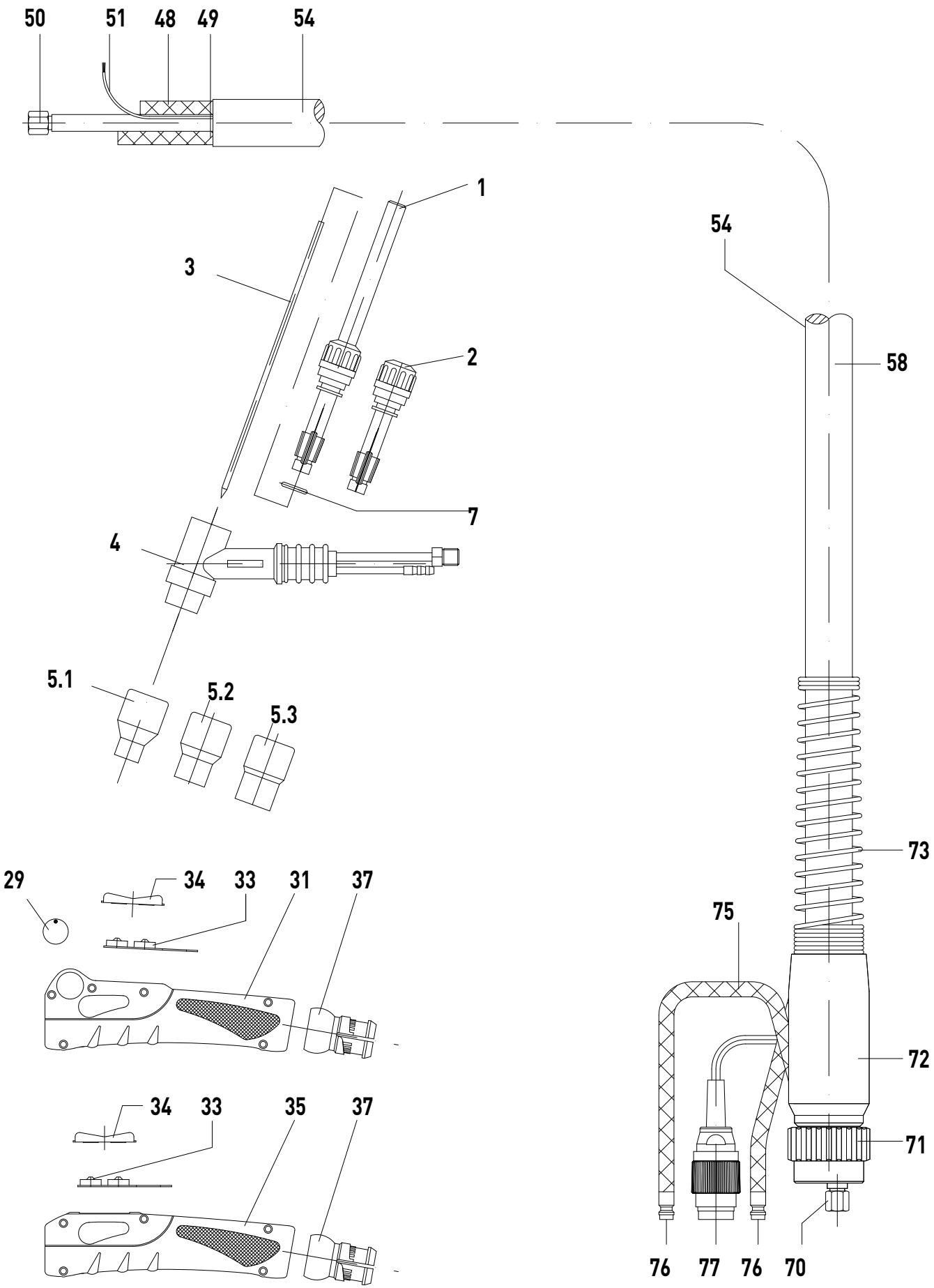
VERSIONS:

Standard

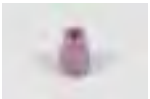
Potentiometer

Optional: 4 button

TECHNICAL DATA:	
Cooling:	water cooled
DC range:	600 A 60% duty cycle
AC range:	600 A 60% duty cycle
Tungsten electrodes:	2.4 - 4.8 mm ∅
Weight:	360 g without hose assembly



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
TIG hand welding torch TH 600 W						
		TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector leather/fabric		**10**	**104410**	**575,00**
		TIG hand welding torch model TH 600 W-EURO, 8 m with Euro connector and potentiometer leather/fabric		**10**	**104416**	**615,00**
Option 4 buttons:						
		Option 4 buttons for Merkle TH TIG torches functions: torch trigger1 and 2 / up, down		10	156930	135,00
Standard equipment: 4.0 mm, ceramic 13.0						
Spare parts and consumables:						
	1.1	Back cap "quick TIG" 2.4 mm, long TH 600 W		26	107722	40,95
	1.2	Back cap "quick TIG" 3.2 mm, long TH 600 W		26	107724	40,95
	1.3	Back cap "quick TIG" 4.0 mm, long TH 600 W		26	107726	40,95
	1.4	Back cap "quick TIG" 4.8 mm, long TH 600 W		26	107728	40,95
	2.1	Back cap "quick TIG" 2.4 mm, short TH 600 W		26	107734	39,90
	2.2	Back cap "quick TIG" 3.2 mm, short TH 600 W		26	107736	39,90
	2.3	Back cap "quick TIG" 4.0 mm, short TH 600 W		26	107738	39,90
	2.4	Back cap "quick TIG" 4.8 mm, short TH 600 W		26	107740	39,90
	3.1	Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	3,70
	3.2	Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	6,00
	3.3	Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	9,90
	3.4	Tungsten-electrode, grey 4.8 x 175 mm	10 pcs	26	01300116	10,90
	4	Torch neck TH 600 W		26	104270	195,00
	5.1	Ceramic nozzle 10.0, TH 600 W	10 pcs	26	104300	2,60
	5.2	Ceramic nozzle 13.0, TH 600 W	10 pcs	26	104302	2,60
	5.3	Ceramic nozzle 16.0, TH 600 W	10 pcs	26	104304	2,60
	7	O ring 11 x 2.5	10 pcs	26	05011829	3,15
	29	Adjustment wheel incl. potentiometer for TH torch		26	108354	44,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	31	Handle TIG torch, right and left side for torch with potentiometer (delivered without ball joint)		26	108368	12,50
	33	Pc board for TIG double button switch (for torch with ball joint)		26	107992	16,80
	34	Switch button (red) for TIG torch with ball joint		26	107994	2,90
	35	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	12,10
	37	Kinking protection for TIG handle		26	107998	11,70
	48	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	49	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	50	Power cable TH 600 W, 8m, 16 qmm		26	107752	75,00
	51.1	Control cable 3 x 0.5 LIYY no shield		07	107646	2,21
	54	Protection hose 8 m rubber / leather for TIG torch		26	114334	49,00
	58.1	Cable assembly TH 600 W, 8 m 16 qmm, Euro connector		26	107744	240,00
	58.2	Cable assembly TH 600 W, 8 m 16 qmm, Euro connector for torch with potentiometer		26	107746	243,00
	70	Euro-connector for TIG torches, water cooled		26	01340061	23,00
	71	Sleeve nut black		22	02510300	9,80
	72	Kinking protection, intake water cooled		22	02510100	14,20
	73	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	75	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	76	Coupling nipple for water	10 pcs	22	02510400	1,80
	77	Torch plug for TIG-torch (standard)		26	02110380	24,00

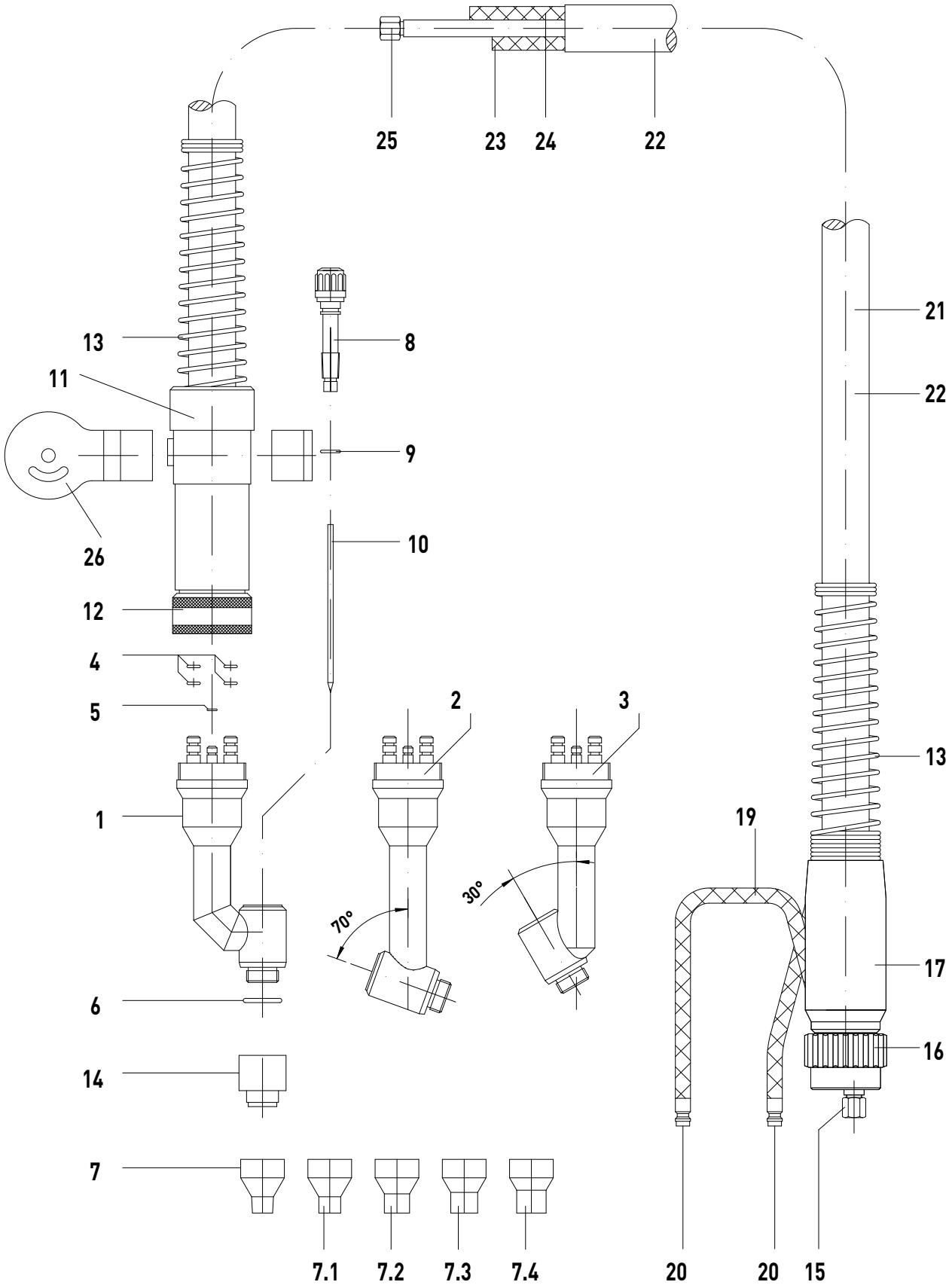
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

6.4. TM 450 W

TIG machine welding torch TM 450 W

water cooled / Euro connector
removable torch head
Versions of the torch head: straight, 30° bent, 70° bent

TECHNICAL DATA:	
Cooling:	water cooled
DC range:	450 A 60% duty cycle
AC range:	450 A 60% duty cycle
Tungsten electrodes:	1.0 - 4.0 mm ∅
Weight:	470 g torch head



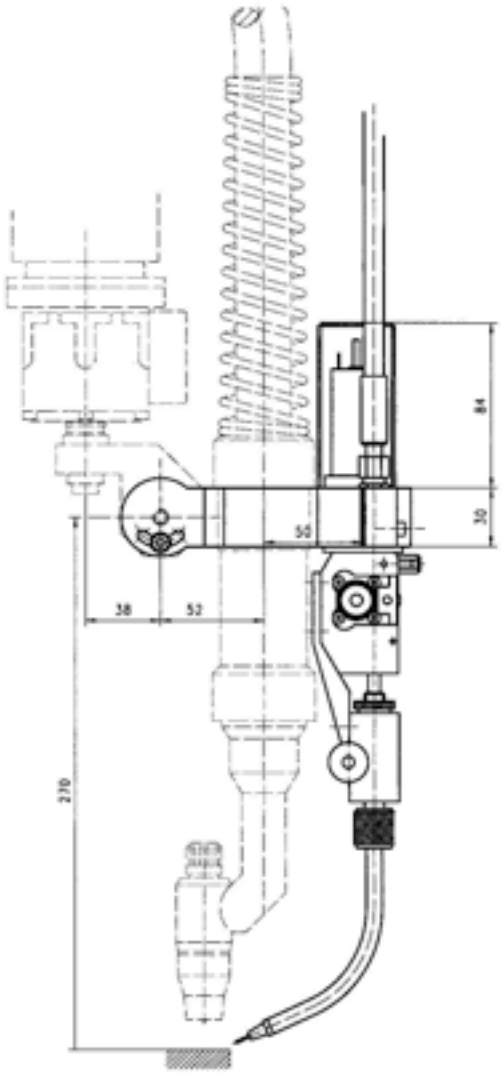
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Hose assemblies:						
		Cable assembly TM 450 W, 4 m incl. upper torch head connector		**10**	**109406**	**715,00**
		Cable assembly TM 450 W, 8 m incl. upper torch head connector		**10**	**109408**	**775,00**
Torch heads:						
	1	**Torch head TM 450 W, straight**		**10**	**109392**	**525,00**
	2	**Torch head TM 450 W, 70° bent**		**10**	**109404**	**525,00**
	3	**Torch head TM 450 W, 30° bent**		**10**	**109400**	**525,00**
Spare parts and consumables:						
	4	O-ring 5 x 1.5 (PM 400/150)	10 pcs	26	103137	3,15
	5	O-ring 4 x 1 liner for steel 70 shore model PA431	10 pcs	22	02210333	3,15
	6	O ring 18 x 2.5	10 pcs	26	05011830	3,15
	7.1	Ceramic gas-nozzle size 4	10 pcs	26	01300066	3,89
	7.2	Ceramic gas-nozzle size 5	10 pcs	26	01300067	3,89
	7.3	Ceramic gas-nozzle size 6	10 pcs	26	01300068	3,89
	7.4	Ceramic gas-nozzle size 7	10 pcs	26	01300069	3,89
	7.5	Ceramic gas-nozzle size 8	10 pcs	26	01300070	4,41
	7.6	Ceramic gas-nozzle size 10	10 pcs	26	109870	4,41
	7.7	Ceramic gas-nozzle size 12	10 pcs	26	109872	4,41
	8	Back cap "quick TIG" 1.0 mm, short TH/TM 450 W		26	107685	20,79
	8.1	Back cap "quick TIG" 1.6 mm, short TH/TM 450 W		26	107687	20,79
	8.2	Back cap "quick TIG" 2.4 mm, short TH/TM 450 W		26	107689	20,79
	8.3	Back cap "quick TIG" 3.2 mm, short TH/TM 450 W		26	107693	20,79
	8.4	Back cap "quick TIG" 4.0 mm, short TH/TM 450 W		26	107695	20,79
	9	O ring 9 x 1.5	10 pcs	26	02210704	1,89
	10	Tungsten-electrode, grey 1.0 x 175 mm	10 pcs	26	01300111	1,20
	10.1	Tungsten-electrode, grey 1.6 x 175 mm	10 pcs	26	01300112	1,90
	10.2	Tungsten-electrode, grey 2.4 x 175 mm	10 pcs	26	01300113	3,70
	10.3	Tungsten-electrode, grey 3.2 x 175 mm	10 pcs	26	01300114	6,00
	10.4	Tungsten-electrode, grey 4.0 x 175 mm	10 pcs	26	01300115	9,90

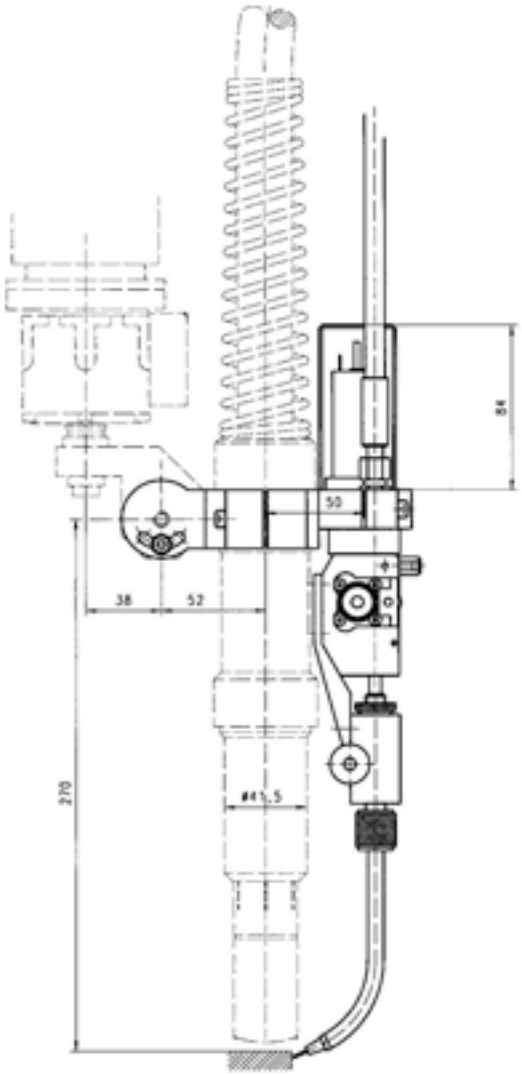
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	11	Upper part TM 450 W cmpl. with fastening nut		26	109390	240,00
	12	Fastening nut TM 450 W		26	109388	115,00
	13	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	14.1	Gas lense TM 450 W, 1.0 mm		26	125956	46,00
	14.2	Gas lense TM 450 W, 1.6 mm		26	125958	46,00
	14.3	Gas lense TM 450 W, 2.4 mm		26	125462	46,00
	14.4	Gas lense TM 450 W, 3.2 mm		26	125960	46,00
	14.5	Gas lense TM 450 W, 4.0 mm		26	125962	46,00
	15	Euro-connector for TIG torches, water cooled		26	01340061	23,00
	16	Sleeve nut black		22	02510300	9,80
	17	Kinking protection, intake water cooled		22	02510100	14,20
	19.1	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	19.2	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	20	Coupling nipple for water	10 pcs	22	02510400	1,80
	21	Cable assembly TH/TM 452 W, 4 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108362	190,00
	21.1	Cable assembly TH 452 W, 8 m 10 qmm, Euro connector, (control cable 3 x 0.5)		26	108364	235,00
	22	Protective hose 28 x 1,5 black		22	00600405	6,90
	23.1	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
	23.2	PVC hose 5 x 1.5, red per m		22	00600206	1,20
	24	PVC hose 5 x 1.5, black per m		22	00600207	1,20
	25	Power cable TH 452 W, 4 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104378	50,00
	25.1	Power cable TH 452 W, 8 m, 10 qmm, for torches with Merkle TCG and Euro connector		26	104379	75,00
	26	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00

6.5. KDZF

Cold Wire Feed System
Model KDZF



(with TM 450 W)



(with PM 400 W)

Technical Data:

Wire diameter:	0.8 - 1.2 mm
Wire feed speed:	0.5 - 5.0 m/min
Motor supply voltage:	42 V DC
Connection:	Euro connector and 10-pol plug

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Cold wire feed system WITH Push-Pull-operation:**					
	1a	Controller for cold wire feed KDZF with push-pull operation, installed in a machine Fa. Merkle		31	134570	2.750,00
	1b	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	138921	680,00
	1c	Controller for cold wire feed KDZF with push-pull operation, model E052-PP installed in external cabinet supply voltage: 230 V incl. sequence controller		05	142074	3.370,00
	1d	Controller for cold wire feed KDZF with push-pull operation, model E052-ROB installed in an external cabinet supply voltage: 230 V control through: 1 x control voltage 0-10 V		05	145808	1.790,00
	1e	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	138,00
	2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00
	3a	Cold Wire Feed KDZF with Feed Tube for PM 400 W (Mechanic with Motor) for Push-Pull use		05	141612	2.250,00
	3b	Cold Wire Feed KDZF with Feed Tube for TM 450 W (Mechanic with Motor) for Push-Pull use		05	141614	2.250,00
	4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00
B	**Cold wire feed system WITHOUT Push-Pull-operation:**					
	1a	Controller for cold wire feed KDZF WITHOUT push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	146018	480,00
	1b	Controller for cold wire feed KDZF without (!) push-pull operation, model E052 installed in an external cabinet supply voltage: 230 V incl. sequence controller		05	142072	2.850,00
	1c	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	138,00
	2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00
	3a	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for PM 400 W		05	141608	905,00
	3b	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for TM 450 W		05	141610	905,00
	4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

7. Plasma welding units and welding torches

7.1 Plasma welding units

7.2 Plasma welding torches Cold Wire Feed System KDZF

7.1. Plasma welding units

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

7.1.1. HighPLAS 352 DC RS

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98
Plasma DC-operation:	
Open circuit voltage:	57 V
Welding voltage:	25 - 39 V
Welding current:	5 - 350 A
Duty cycle 40 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	240 A (40 °C)
Prim. cont. power:	14.1 kVA
Prim. cont. current:	21 A
Prim. max. current:	30 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	Plasma, TIG DC, MMA/stick electrode
Digital displays:	LED displays with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation spot welding time
Ignition:	high frequency, liftTIG
Energy control:	at the machine, at the remote controls, at the torch
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	5 - 350 A
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection failure, hold function
Power source:	inverter
Torch connection:	Plasma connector
Sockets:	2 x 95 mm²
Torch cooling:	separate water cooling system (option)
Connection for water cooling unit:	6-pole
Mains supply cable:	4 x 4.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % mains power fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	53 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	Bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, Ethernet 10 Mbit with RJ45 connector (option)

MMA/stick electrode operation:	
Stick electrodes:	1.5 - 6 mm
Open circuit voltage:	57 V
Welding voltage:	20 - 34 V
Welding current:	20 - 350 A
Duty cycle 40 % (10 min.):	350 A (40 °C)
Duty cycle 100 %:	250 A (40 °C)
Prim. cont. power:	13.1 kVA
Prim. cont. current:	19 A
Prim. max. current:	27 A

7.1.2. HighPLAS 452 DC RS

Primary:	
Power supply:	3 x 400 V
Frequency:	50 / 60 Hz
cos phi:	0.98
Plasma DC-operation:	
Open circuit voltage:	72 V
Welding voltage:	25 - 43 V
Welding current:	5 - 450 A
Duty cycle 70 %:	450 A
Duty cycle 100 %:	400 A
Prim. cont. power:	26.3 kVA
Prim. cont. current:	38 A
Prim. max. current:	43 A

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Main switch:	3-phase
Welding modes:	Plasma, TIG DC
Digital display:	LED displays with pre-indication and hold function for current, voltage
Timer functions:	OFF, quick and slow pulsation, spot welding time
Ignition:	high frequency
Energy control:	at the machine
Operation modes:	2-stroke, 4-stroke, 4-stroke with 2 currents, gas check
Job-Operation:	999 jobs programmable
Gas pre-flow time:	0 - 3 s
Gas post-flow time:	1 - 60 s
Up slope time:	0 - 2 s
Down slope time:	0 - 20 s
Spot welding time:	0.01 - 25 s
Pulsation slow:	10 ms - 2.5 s
Pulsation fast:	50 Hz - 12 kHz
Hotstart time:	0.1 - 2.0 s
Hotstart current:	5 - 450 A
Arc force:	0 - 100 %
LEDs:	mains ON, temperature protection, failure, hold function
Power source:	inverter
Torch connection:	Plasma connector
Sockets:	2 x 95 mm²
Torch cooling:	separate water cooling system (option)

Connector for water cooling unit: Socket 6-pol.

Mains supply cable:	4 x 6.0 mm², 5 m long with plug 3 x 400 V, 32 A
Gas hose:	2 m
Stabilization:	± 10 % mains power fluctuation
Norm:	EN 60974-1 "S" / CE
Air filter:	as a standard
Weight:	67 kg
Dimensions l x w x h:	740 x 350 x 690 mm

Roboter interface:	Bus interface (Profibus, DeviceNet, CANopen, interbus, analogue interface, etc.)
Communication:	RS 232, Ethernet 10 Mbit with RJ45 connector (option)

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

7.1.3. HighPLAS 352/452 DC RS

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Plasma welding units**					
	A1	**Plasma DC Robot and Automation Welding Unit Model HighPLAS 352 DC RS (without interface and front panel)**		**55**	**144031**	**6.430,00**
	A2	**Plasma DC Robot and Automation Welding Unit Model HighPLAS 452 DC RS (without interface and front panel)**		**55**	**144032**	**7.820,00**
	Welding torches:					
		Plasma hand welding torch model PH 150 W, 8 m		**54**	**108612**	**2.245,00**
		Plasma machine welding torch model PM 400 W, 5 m		**54**	**103523**	**3.150,00**
		Plasma machine welding torch model PM 350 W, 5 m		**54**	**153898**	**3.200,00**
		Plasma machine welding torch model PM 350 W, 10 m		**54**	**153346**	**3.350,00**
B	**Operation panel/front (please select one):**					
	B1	Front panel for series HighPLAS with display and controls		46	144038	1.480,00
	B2	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	750,00
B3	**External operation panel:**					
	B3.1	Front panel without displays without selectors for series HighTIG/HighPLAS incl. process controller		46	139042	750,00
	B3.2	External operation panel in housing for manual process control incl. displays for series HighPLAS with 5 m cable (only with 139.042 and job panel)		46	144062	1.340,00
	B3.3	External operation panel mounted in ext. controller incl. displays for series HighPLAS with 5 m cable (only with 139.042)		46	144064	1.340,00
	B3.4	Kit for connection of MTC TRC PRC installed in HighPULSE, HighTIG, HighPLAS		46	113804	150,00
	B3.5	Special cable for external user panel, Remote, ProJOB-PPC, suitable for trailing (per 1m), 5 x 2 x 0,34		17	117540	34,50
C	**Interface connection (please select one):**					
	C1	Interface CANopen for RS series		17	117428	1.980,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	C2	Bus interface Profibus-DP for RS series		17	117430	1.980,00
	C3	Bus interface DeviceNet for RS series		17	117432	1.980,00
	C4	Bus interface Interbus for RS series		17	117436	1.980,00
	C5	Bus interface ProfiNET-IO for RS series		17	117438	1.980,00
	C6	Bus interface RS485 for RS series		17	139818	597,00
010110 64 jobs	C7a	Digital interface for job operation (6 bit - 64 jobs) or HighPULSE with socket 24 pol. signals: welding on, arc is started, emergency stop, torch blow out and 6 bits for jobs		17	159202	785,00
	C7b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C8a	Analogue interface for RS series incl. socket 24 pol.		17	113788	1.300,00
	C8b	Connection cable 24-pin., 5 m welding unit - robot		46	01903557	125,00
	C9a	Connection for automated welding or RS series incl. socket 6-pol. and signals: welding ON, arc OK, emergency stop		17	143998	450,00
	C9b	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	C10	Internal wiring for HighPLAS 352/452 DC for hand welding application without interface		46	144060	350,00
D	**Trolley:**					
		Trolley model TW 114-2, black for RS series (incl. water cooling unit) incl. gas bottle holder for 2 cylinders		46	144001	995,00
E	**Water cooling:**					
	E1	Re-cooling unit model ME-IK-V 4/T		31	113040	5.950,00
	E2	Water cooling unit model WK 350		46	144008	1.200,00
	E3	Water flow control device mounted in the water cooler		46	02610156	265,00
	E4	Coolant for plasma welding units ME-KM Plasma (30 l), no anti freeze protection		07	129660	99,00
F	**Gas controllers:**					
	F1	Gas controller for HighPLAS for shielding gas		46	144034	735,00
	F2	Gas controller for HighPLAS for pilot arc gas		46	144036	735,00

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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
G	**Option cold wire:**					
	G1	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	138921	680,00
	G2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00
	G3	Cold Wire Feed KDZF with Feed Tube for PM 400 W (Mechanic with Motor) for Push-Pull use		05	141612	2.250,00
	G4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00
H	**Accessories:**					
	H1	Gas regulator Argon-CO2 0-30 l/min with flow meter		46	114554	168,00
	H2	Gas regulator Argon-CO2 0-5 l/min with flow meter		46	144214	228,00
	H3a	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00
	H3b	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	H4a	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	H4b	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	H5	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	H6	Filter 205 x 314 mm for HighTIG / HighPULSE x52 RS		46	156804	3,50
	H7	Coolant for plasma welding units ME-KM Plasma (30 l), no anti freeze protection		07	129660	99,00
	H8	Cover for operation panel RS series 352/452/552		46	145206	132,00

I **WeldFACTORY:**
control, documentation and evaluation of welding parameters, job management
(see section 10.5 of the general catalogue)

7.2. Plasma welding torches

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

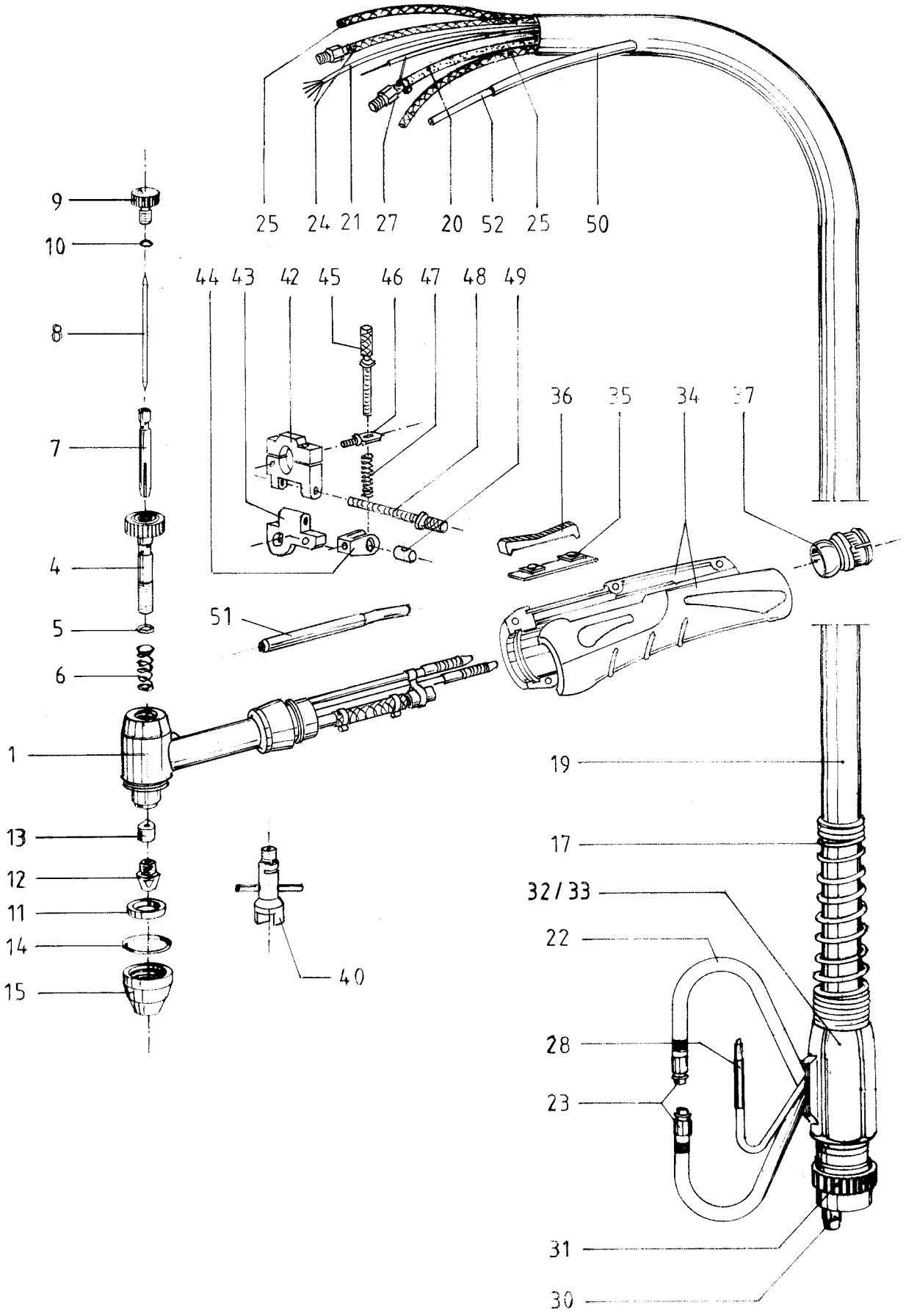
7.2.1. PH 150 W

Model PH 150 W

Technical data:

DC range:	150 A, 60% duty cycle (100% at 20°C water temp.)
AC range:	100 A, 60% duty cycle (100% at 20°C water temp.) (at 35% positive current)
Pilot gas:	Argon 0.5 – 2.0 l/min.
Shield gas:	Argon, ArH_2, ArHe
Tests:	according to EN 60974-07, room temp. 40°C

nozzle	DC
1.0 mm	30 A
1.2 mm	50 A
1.6 mm	80 A
2.0 mm	120 A
2.4 mm	150 A



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Plasma hand welding torch PH 150 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Plasma hand welding torch model PH 150 W, 8 m		**54**	**108612**	**2.245,00**

Spare parts and consumables:

	Cable assembly PH 150 W, 8 m		53	108616	537,00
1	Torch head PH 150 W		53	108522	982,00
4	Housing for fastening sleeve PM150W	10 pcs	53	103543	92,40
5	O-ring 8 x 1.6	10 pcs	53	103544	1,20
6	Spring PM 150 W	10 pcs	07	103545	13,00
7	Clamping nut 1.5 (PM 150 W)		53	103547	18,90
7.1	Clamping nut 2.4 (PM 150 W)		53	103546	18,90
8	Electrode 1.6 (PM 150 W)	10 pcs	53	103549	15,60
8.1	Electrode 2.4 (PM 150 W)	10 pcs	53	103548	15,90
9	Torch cap (PM 150 W)	10 pcs	53	103550	49,00
10	O-ring 4 x 1.2		07	103551	3,10
11	Gas-lens (PM 150 W)		53	103552	92,30
12	Welding nozzle 1.0 (PM 150 W)		53	103553	13,20
12.1	Welding nozzle 1.2 (PM 150 W)		53	103554	13,20
12.2	Welding nozzle 1.6 (PM 150 W)		53	103555	13,20
12.3	Welding nozzle 2.4 (PM 150 W)		53	103558	13,20
13	Centering ceramics 1.6 (PM 150 W)		53	103560	11,55
13.1	Centering ceramics 2.4 (PM 150 W)		53	103559	11,55
14	O-ring 22 x 2		07	103561	2,00
15	Gas nozzle 14 (PM 150 W)		53	103562	17,50
15.1	Gas nozzle 16 (PM 150 W)		53	103563	17,50
17	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
18	Spring 6x6x18 A (PM 150 W)		07	103566	7,35
19	Protective hose 28 x 1,5 black		22	00600405	6,90
20	Water power cable (PM 150 W) 5 m		53	108618	71,00
20.1	Water power cable (PM 150 W) 8 m		53	108534	90,00
22	PVC hose 5 x 1.5, blue per m		22	00600205	1,20
22.1	PVC hose 5 x 1.5, red per m		22	00600206	1,20
23	Coupling nipple for water	10 pcs	22	02510400	1,80
24	Water hose flow (blue) 5 m		53	108620	51,50
24.1	Water hose flow (blue) 8 m		53	108528	62,00
25	PVC hose 5 x 1.5, black per m		22	00600207	1,20
27	Pilot power cable 2.5 mm² PH 150 W, 5 m		53	108622	94,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	27.1	Pilot power cable 2.5 mm² PH 150 W, 8 m		53	108532	112,00
	28	Plug 1-pole		53	05011082	2,00
	30	Brass body for EURO connector, torch side, PM 150/400		53	103532	140,00
	31	Sleeve nut black		22	02510300	9,80
	32	Kinking protection, intake water cooled		22	02510100	14,20
	33	Euro connector complete		53	103530	136,50
	34	Handle TIG torch, right and left side (delivered without ball joint)		26	107988	12,10
	35	Pc board for TIG double button switch (for torch with ball joint)		26	107992	16,80
	36	Switch button (red) for TIG torch with ball joint		26	107994	2,90
	37	Kinking protection for TIG handle		26	107998	11,70
	40	Adjustment tool PM 150 W		53	104774	41,00

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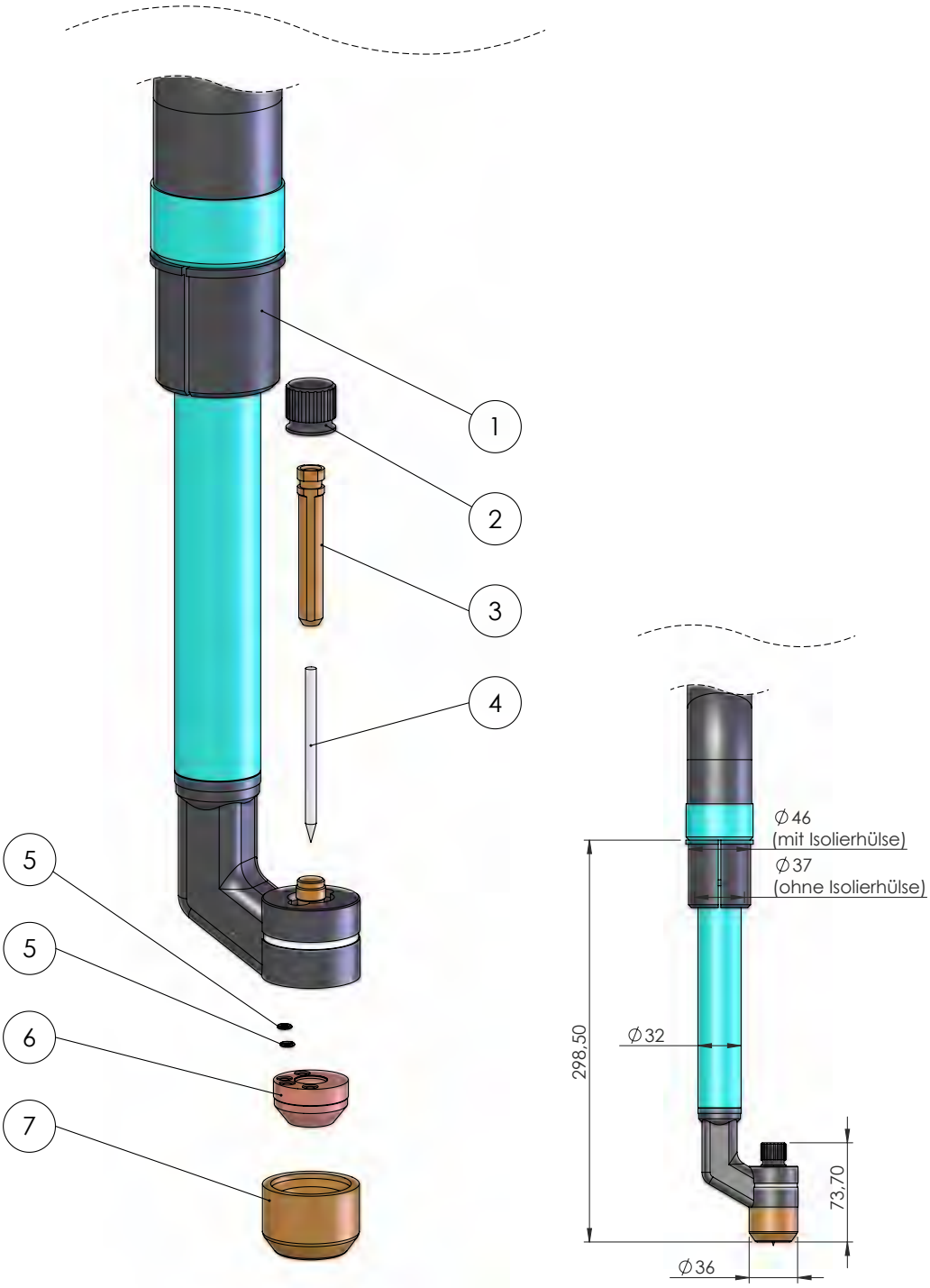
Subject to change. Valid from 18.05.2020

7.2.2. PM 350 W

Model PM 350 W

Technical data:

DC operation:	15-40 V
Welding current:	max. 350 A, 100 % duty cycle
Pilot current:	5-10 A, 100 % duty cycle
Tungsten electrode:	Ø 4.0 mm



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Pos.	Description	Pu	PrGrp	Part No.	Price/€
Plasma machine welding torch PM 350 W					
	Plasma machine welding torch model PM 350 W, 5 m		**54**	**153898**	**3.200,00**
	Plasma machine welding torch model PM 350 W, 10 m		**54**	**153346**	**3.350,00**
Spare parts and consumables:					
			54	160438	2.400,00
1	Insulating sleeve for plasma welding torch PM 350 W		62	153328	67,50
2	Tightening cap short for PM 350 W		53	153516	127,95
3	Clamping sleeve Ø 4 mm for PM 350 W		53	153510	21,00
4	Tungsten electrode 4 mm x 67 mm red, for PM 350 W		53	153514	77,50
5	O-ring for plasma nozzle PM 350 W		53	153506	0,75
7.1	Gas nozzle for PM 350 W, brass, Ø 21 mm		53	153492	53,50
7.2	Gas nozzle for PM 350 W, ceramic, Ø 20.5 mm		53	153493	14,50
Welding nozzles:					
6.1	Plasma nozzle NW 2.0 mm - 2x1.0 for PM 350 W		53	153494	148,00
6.2	Plasma nozzle NW 2.5 mm - 2x1.0 for PM 350 W		53	153496	148,00
6.3	Plasma nozzle NW 3.0 mm - 2x1.0 for PM 350 W		53	153498	148,00
6.4	Plasma nozzle NW 3.2 mm - 2x1.0 for PM 350 W		53	153500	148,00
6.5	Plasma nozzle NW 3.5 mm - 2x1.0 for PM 350 W		53	153502	148,00
6.6	Plasma nozzle NW 3.8 mm - 2x1.0 for PM 350 W		53	153504	148,00
Accessories:					
	Adjustment tool 1.0-1.5 mm for PM 350 W		62	156336	42,50

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Subject to change. Valid from 18.05.2020

7.2.3. PM 400 W

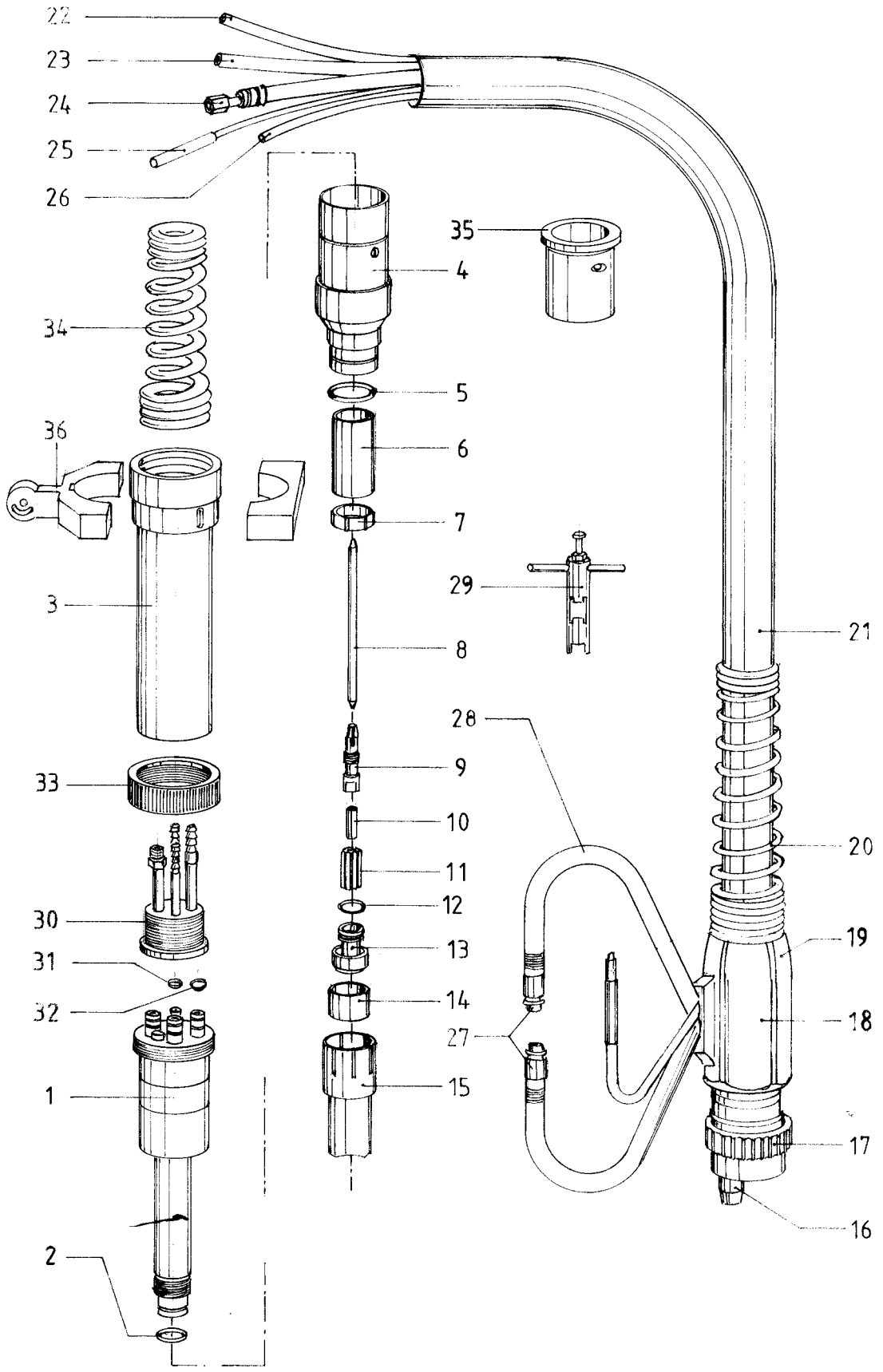
Model PM 400 W

Technical data:

DC operation:	max. 400 A*, 100 % duty cycle
AC operation:	max. 350 A* ,100 % duty cycle
Pilot gas:	Argon 1.0 – 4.0 l/min.
Shield gas:	Ar, $ArHe_2$, ArHe
Tests:	according EN 60974-07, room temp. 40°C

nozzle	DC standard	DC conical	AC (35 % positive) standard
2.0 mm	100 A	70 A	70 A
2.8 mm	180 A	120 A	120 A
3.2 mm	240 A	170 A	170 A
3.5 mm	280 A	240 A	200 A
4.0 mm	300 A	280 A	250 A
4.0 mm	400 A*	350 A*	
4.5 mm	400 A*	350 A*	300 A*
5.0 mm	400 A*	350 A*	350 A*

*: water temperature 20°C



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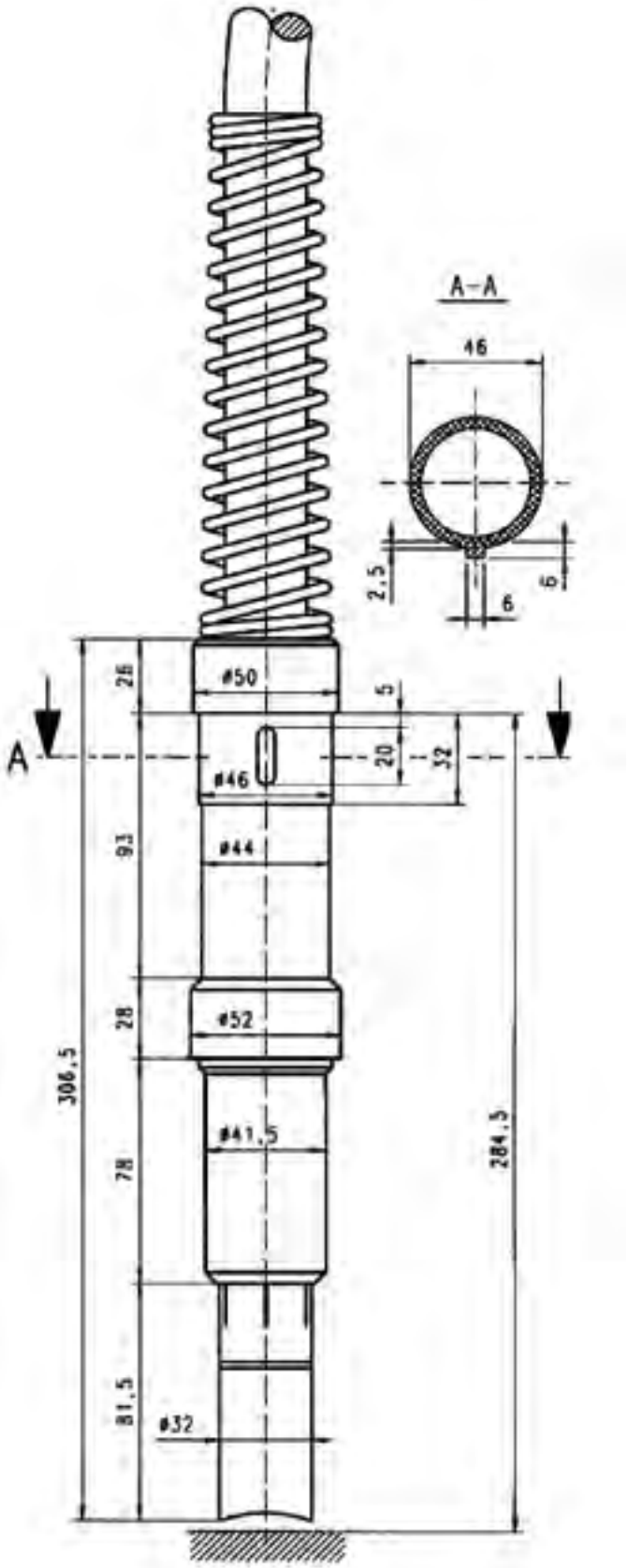
Subject to change. Valid from 18.05.2020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Plasma machine welding torch PM 400 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
AB	**Plasma machine welding torch model PM 400 W, 5 m**		**54**	**103523**	**3.150,00**
A	Torch head PM 400 W, compl.		53	105082	1.960,00
B	Hose assembly PM 400 W, 5 m		53	108102	1.450,00

Extensions for hose assembly:

	Extension for PM 400 W - 1.5 m		53	114030	620,00
	Extension for PM 400 W - 2 m		53	114032	630,00
	Extension for PM 400 W - 3 m		53	114034	640,00
	Extension for PM 400 W - 5 m		53	114036	680,00
	Extension for PM 400 W - 10 m		53	114038	720,00
	Extension for PM 400 W - 15 m		53	114040	870,00

Spare parts and consumables:

	Torch head PM 400 W, compl.		53	105082	1.960,00
1	O-ring 15 x 1.5 heat-resistant, PM 400 W		53	103525	9,80
2	Outer tube PM 400 W		53	103526	99,50
3	Gas nozzle holder PM 400 W		53	103527	210,00
4	O-ring 24 x 2.5	10 pcs	53	103528	3,30
5	Insulation PM 400 W		53	103056	32,00
6	Distance sleeve PM 400 W		53	103055	52,40
7	Electrode PM 400 W		53	103054	22,00
8	Clap PM 400 W		53	103053	56,80
9	Ceramic sleeve PM 400 W		53	103057	32,00
10	Centering ceramic		53	103058	35,50
11	O-ring 10.82 x 1.78 (PM 400 W)	10 pcs	53	103060	9,80

Nozzles for DC operation:

13.1	Welding nozzle 2.0 (PM 400 W) 100 A	10 pcs	53	103048	38,00
13.2	Welding nozzle 2.8 (PM 400 W) 180 A	10 pcs	53	103049	38,00
13.3	Welding nozzle 3.2 (PM 400 W) 200 A	10 pcs	53	103050	38,00
13.4	Welding nozzle 3.5 (PM 400 W) 250 A	10 pcs	53	103051	38,00
13.5	Welding nozzle 4.0 (PM 400 W) 300 A	10 pcs	53	103052	38,00
13.6	Welding nozzle 4.5 (PM 400 W) 350 A	10 pcs	53	105086	38,00
13.7	Welding nozzle 5.0 (PM 400 W) 400 A	10 pcs	53	105088	38,00
13.8	Welding nozzle 2.0 (PM 400 W) 70 A conical version	10 pcs	53	106988	38,00
13.9	Welding nozzle 2.8 (PM 400 W) 120 A conical version	10 pcs	53	106990	38,00
13.10	Welding nozzle 3.2 (PM 400 W) 170 A conical version	10 pcs	53	106992	38,00
13.11	Welding nozzle 3.5 (PM 400 W) 240 A conical version	10 pcs	53	106994	38,00
13.12	Welding nozzle 4.0 (PM 400 W) 280 A conical version	10 pcs	53	106996	38,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Pos.	Description	Pu	PrGrp	Part No.	Price/€
13.13	Welding nozzle 4.5 (PM 400 W) 350 A conical version	10 pcs	53	106998	38,00
13.14	Welding nozzle 5.0 (PM 400 W) 350 A conical version	10 pcs	53	107000	38,00

Nozzles for AC operation:

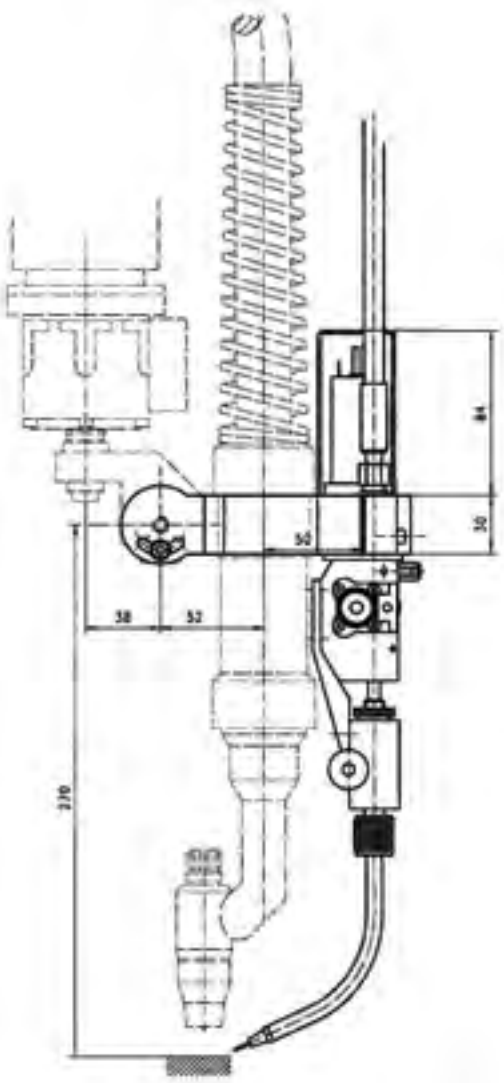
	13.15	Welding nozzle 2.0 AC (PM 400) 100 A AC	10 pcs	53	105212	38,00
	13.16	Welding nozzle 2.8 AC (PM 400) 180 A AC	10 pcs	53	105213	38,00
	13.17	Welding nozzle 3.2 AC (PM 400) 200 A AC	10 pcs	53	105214	38,00
	13.18	Welding nozzle 3.5 AC (PM 400) 250 A AC	10 pcs	53	105215	38,00
	13.19	Welding nozzle 4.0 AC (PM 400) 300 A AC	10 pcs	53	105216	34,65
	13.20	Welding nozzle 4.5 AC (PM 400) 350 A AC	10 pcs	53	105217	34,65
	13.21	Welding nozzle 5.0 AC (PM 400) 400 A AC	10 pcs	53	105218	34,65
	14	Cap for gas nozzle PM 400 W		53	103047	28,00
	15	Gas nozzle 24 (PM 400 W)		53	103045	48,00
	15.1	Gas nozzle 30 (PM 400 W)		53	103046	48,00
	16	Brass body for EURO connector, torch side, PM 150/400		53	103532	140,00
	17	Sleeve nut black		22	02510300	9,80
	18	Kinking protection, intake water cooled		22	02510100	14,20
	19	Euro connector complete		53	103530	136,50
	20	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	21	Protective hose 28 x 1,5 black		22	00600405	6,90
	22	Gas hose PM 400 W		53	103535	32,50
	23	Water hose flow PM 400 W		53	103536	35,00
	24	Water power cable PM 400 W		53	103537	82,00
	25	HF cable compl. for PM 400 W		53	103538	38,00
	26	Gas hose PM 400 W		53	103535	32,50
	27	Coupling nipple for water	10 pcs	22	02510400	1,80
	28	Gas hose 4.5 x 1.3 high flexible		35	108098	3,60
	29	Adjustment tool for PM 400 W		53	103059	54,60
	30	Coupling for hose assembly PM 400 W		53	104594	485,00
	31	O-ring 4 x 1 liner for steel 70 shore model PA431	10 pcs	22	02210333	3,15
	32	O-ring 5 x 1.5 (PM 400/150)	10 pcs	26	103137	3,15
	33	Euro adapter nut PM 400 W		53	104596	159,00
	34	Spring for kinking protection Euro connector, water cooled		22	02211579	9,80
	35	Distance sleeve PM 400 W		53	103055	52,40

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	36	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00
	37	Coolant for plasma welding units ME-KM Plasma (30 l), no anti freeze protection		07	129660	99,00

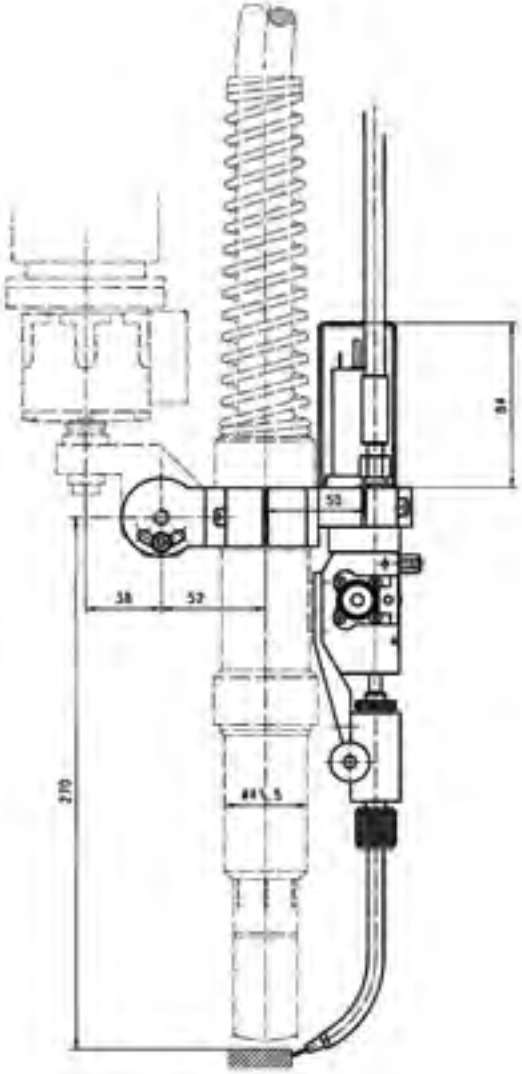
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

7.2.4. KDZF

Cold Wire Feed System
Model KDZF



(with TM 450 W)



(with PM 400 W)

Technical Data:

Wire diameter:	0.8 - 1.2 mm
Wire feed speed:	0.5 - 5.0 m/min
Motor supply voltage:	42 V DC
Connection:	Euro connector and 10-pol plug

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Cold wire feed system WITH Push-Pull-operation:**					
	1a	Controller for cold wire feed KDZF with push-pull operation, installed in a machine Fa. Merkle		31	134570	2.750,00
	1b	Controller for cold wire feed KDZF with push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	138921	680,00
	1c	Controller for cold wire feed KDZF with push-pull operation, model E052-PP installed in external cabinet supply voltage: 230 V incl. sequence controller		05	142074	3.370,00
	1d	Controller for cold wire feed KDZF with push-pull operation, model E052-ROB installed in an external cabinet supply voltage: 230 V control through: 1 x control voltage 0-10 V		05	145808	1.790,00
	1e	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	138,00
	2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00
	3a	Cold Wire Feed KDZF with Feed Tube for PM 400 W (Mechanic with Motor) for Push-Pull use		05	141612	2.250,00
	3b	Cold Wire Feed KDZF with Feed Tube for TM 450 W (Mechanic with Motor) for Push-Pull use		05	141614	2.250,00
	4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00
B	**Cold wire feed system WITHOUT Push-Pull-operation:**					
	1a	Controller for cold wire feed KDZF WITHOUT push-pull operation, installed inside HighTIG/HighPLAS incl. software		31	146018	480,00
	1b	Controller for cold wire feed KDZF without (!) push-pull operation, model E052 installed in an external cabinet supply voltage: 230 V incl. sequence controller		05	142072	2.850,00
	1c	Connection cable 24-pol/10-pol. Power source to external KDZF controller housing, 4 m long		05	107410	138,00
	2	Wire feed unit DV-31 KDZF / HDZF for cold / hot wire feed / including 5 m control cable		38	104634	2.470,00
	3a	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for PM 400 W		05	141608	905,00
	3b	Cold Wire Feed KDZF without (!) Push-Pull with Feed Tube for TM 450 W		05	141610	905,00
	4	Torch holder TIG / Plasma for machine welding torch TM 450 W, PM 400 W		05	103567	279,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

8. MMA/stick electrode welding units

8. MMA/stick electrode welding units

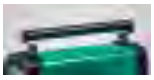
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

8.1. LiteARC 160

Primary:		
Voltage:	1 x 230 V	
Frequency:	50 / 60 Hz	
Cont. power (MMA/TIG):	3.7 kVA / 2.8 kVA	
Cont. current (MMA/TIG):	16 A / 12 A	
Max. current (E/TIG):	26 A / 20 A	
cos phi:	0.98	
MMA/stick electrode operation:		
Stick electrode:	1.5 - 3.25 mm	
Open circuit voltage:	64 V	
Welding voltage:	20.6 - 26.4 V	
Welding current:	15 - 160 A	
Duty cycle 25 % (10 min.):		150 A (40 °C)
Duty cycle 30 % (10 min.):	150 A (20 °C)	
Duty cycle 60 % (10 min.):	100 A (20 °C)	90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C)	80 A (40 °C)

Protection class:	IP 23
Isolation class:	F
Cooling:	AF
Main switch:	2-phase
Operation modes:	MMA/stick welding, TIG (DC) welding with hotstart (fixed) LiftTIG ignition
Potentiometer:	welding current
LED:	mains ON
LED:	temperature protection
Functions:	anti stick, hotstart and arc force (fixed)
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm², 2.5 m long with plug schuko
Transport:	adjustable carry/shoulder strap
Protection cover:	in front of operation panel
Weight:	6.0 kg
Dimensions l x w x h:	360 x 150 x 240 mm

TIG operation:		
Open circuit voltage:	64 V	
Welding voltage:	10 - 16.4 V	
Welding current:	5 - 160 A	
Duty cycle 20 % (10 min.):		160 A (40 °C)
Duty cycle 25 % (10 min.):	160 A (20 °C)	
Duty cycle 60 % (10 min.):	100 A (20 °C)	90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C)	80 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MMA/stick electrode and TIG welding unit LiteARC 160**					
	A	**MMA/Stick electrode and TIG welding unit model LiteARC 160**		**47**	**SET153772**	**585,00**
	AB	**MMA/Stick electrode and TIG welding unit model LiteARC 160 incl. accessories**		**47**	**SET153774**	**655,00**
	Packages:					
		Package with 10 pieces MMA/Stick electrode and TIG welding unit model LiteARC 160		**47**	**SET153776**	**4.935,00**
		Package with 10 pieces MMA/Stick electrode and TIG welding unit model LiteARC 160 incl. accessories		**47**	**SET153778**	**5.520,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
C	**Accessories:**					
	C1	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	C2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00
	C3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	C4	Handle set for LiteARC 160/180		46	158340	31,00
D	**Accessories for TIG welding:**					
	D1	TIG hand welding torch WHL 17-H with manual gas valve, 8 m and single connetor 50 mm2		10	101036	199,50
	D2	Regulator argon/CO2 standard version		46	107018	58,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

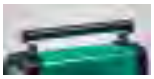
8.2. LiteARC 180

Primary:	
Voltage:	1 x 230 V
Frequency:	50 / 60 Hz
Cont. current:	16 A
Max. current (MMA/TIG):	35 A / 28 A
cos phi:	0.98

MMA/stick electrode operation:	
Stick electrode:	1.5 - 4 mm
Open circuit voltage:	68 V
Welding voltage:	20.8 - 26.8 V
Welding current:	20 - 170 A
Duty cycle 25 % (10 min.):	170 A (40 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)

Protection class:	IP 23
Isolation class:	H
Cooling:	AF
Main switch:	2-phase
Operation modes:	MMA/stick welding, with anti stick, arc force and hotstart TIG (DC) welding with LiftTIG ignition
Rotary switch:	welding current
Digital display:	welding current
LEDs:	mains ON temperature protection operation mode MMA/TIG hotstart arc force
Functions:	hotstart (adjustable) arc force (adjustable) anti stick
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm², 5 m long with plug schuko
Transport:	adjustable carry/shoulder strap
Weight:	5.2 kg
Dimensions l x w x h:	360 x 150 x 240 mm

TIG operation:	
Open circuit voltage:	68 V
Welding voltage:	10.4 - 17.2 V
Welding current:	10 - 180 A
Duty cycle 25 % (10 min.):	180 A (40 °C)
Duty cycle 60 % (10 min.):	130 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MMA/stick electrode and TIG welding unit LiteARC 180**					
	A	**MMA/Stick electrode and TIG welding unit model LiteARC 180**		**47**	**SET146370**	**685,00**
	AB	**MMA/Stick electrode and TIG welding unit model LiteARC 180 incl. accessories**		**47**	**SET146372**	**755,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
C	**Accessories:**					
	C1	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	C2	Filter frame inkl. filter mat for LiteARC and LiteTIG 160, 180, 210 (assembly only at Merkle with special tool)		46	158294	55,00
	C3	Filter mat 120 x 125 mm for LiteARC and LiteTIG 160, 190		46	158292	2,80
	C4	Handle set for LiteARC 160/180		46	158340	31,00
	C5	Remote control socket (5 pol) for LiteARC 180/200		46	157166	80,00
	C6	Hand remote control MFR-11 for LiteARC 180/200 with magnet, 5 m cable, 5 pol plug		46	157168	175,00
D	**Accessories for TIG welding:**					
	D1	TIG hand welding torch WHL 17-H with manual gas valve, 8 m and single connetor 50 mm2		10	101036	199,50
	D2	Regulator argon/CO2 standard version		46	107018	58,00

8.3. MobiARC 164 mobil

Primary:		
Voltage:	1 x 230 V	
Frequency:	50 / 60 Hz	
Cont. power (MMA/TIG):	3.7 kVA / 2.8 kVA	
Cont. current (MMA/TIG):	16 A / 12 A	
Max. current (MMA/TIG):	26 A / 20 A	
cos phi:	0.98	
MMA/stick electrode operation:		
Stick electrode:	1.5 - 3.25 mm	
Open circuit voltage:	64 V	
Welding voltage:	20.6 - 26.4 V	
Welding current:	15 - 160 A	
Duty cycle 25 % (10 min.):		150 A (40 °C)
Duty cycle 30 % (10 min.):	150 A (20 °C)	
Duty cycle 60 % (10 min.):	100 A (20 °C)	90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C)	80 A (40 °C)

Protection class:	IP 23
Isolation class:	H
Cooling:	AF
Main switch:	2-phase
Operation modes:	MMA/stick welding, TIG (DC) welding with hotstart (fixed), LiftTIG ignition
Potentiometer:	welding current
LED:	mains ON
LED:	temperature protection
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm², 2.5 m long with plug schuko
Transport:	handle
Storage department:	for welding accessories
Weight:	12 kg
Dimensions l x w x h:	436 x 222 x 385 mm

TIG operation:		
Open circuit voltage:	64 V	
Welding voltage:	10 - 16.4 V	
Welding current:	5 - 160 A	
Duty cycle 20 % (10 min.):		160 A (40 °C)
Duty cycle 25 % (10 min.):	160 A (20 °C)	
Duty cycle 60 % (10 min.):	100 A (20 °C)	90 A (40 °C)
Duty cycle 100 %:	90 A (20 °C)	80 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MMA/stick electrode and TIG welding unit MobiARC 164 mobil**					
	A	**MMA/Stick electrode and TIG welding unit MobiARC 164 mobil**		**47**	**SET145816**	**900,00**
	AB	**MMA/Stick electrode and TIG welding unit MobiARC 164 mobil incl. accessories**		**47**	**SET145818**	**970,00**
B	**Standard accessories:**					
	B1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	B2	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
C	**Welding accessories:**					
	C1	Accessory kit: hand shield, hammer, gloves, brush, 25 electrodes 2.5 and 3.25 mm		46	122348	98,00
D	**Accessories for TIG operation:**					
	D1	TIG hand welding torch WHL 17-H with manual gas valve, 8 m and single connetor 50 mm2		10	101036	199,50
	D2	Regulator argon/CO2 standard version		46	107018	58,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

8.4. MobiARC 284 cel

Primary:		
Voltage:	3 x 400 V	
Frequency:	50 / 60 Hz	
Data at mains input:	**3 x 400 V**	**1 x 230 V***
Cont. power (TIG/MMA):	8.3 / 9.7 kVA	3.2 / 3.7 kVA
Cont. current (TIG/MMA):	12 / 14 A	14 / 16 A
Max. current (TIG/MMA):	16 / 21 A	26 / 26 A
cos phi:	0.95	0.95
MMA/stick electrode operation:		
Stick electrode:	1.5 - 6.0 mm (Cel-suitable)	1.5 - 3.25 mm
Open circuit voltage:	90 V	103 V
Welding voltage:	20.8 - 31.2 V	20.8 - 26.4 V
Welding current:	20 - 280 A	20 -160 A
Duty cycle 35 %:	280 A (40 °C)	150 A (20 °C)
Duty cycle 50 %:	250 A (40 °C)	
Duty cycle 60 %:	240 A (40 °C)	90 A (40 °C)
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)

Protection class:	IP 23
Isolation class:	H
Cooling:	AF
Main switch:	3-phasig
Operation modes:	MMA/stick welding, TIG (DC) welding with LiftTIG ignition
Settings:	welding current, hotstart current, hotstart time, TIG down slope time, electrode type
LEDs:	mains ON, welding ON, failure, temperature protection
Display:	LED indication for current, time, voltage
Electrode type:	selectable rutile, basic, cellulose
Remote control:	power socket 10-pole
VRD:	optional
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 2.5 mm² 5 m long with plug 400 V, 16 A
Weight:	17 kg
Dimensions l x w x h:	495 x 210 x 450 mm

Data at mains input:	**3 x 400 V**	**1 x 230 V***
TIG operation:		
Open circuit voltage:	90 V	103 V
Welding voltage:	10 - 21.2 V	10 - 16.4 V
Welding current:	3 - 280 A	3 - 160 A
Duty cycle 35 %:	280 A (40 °C)	150 A (20 °C)
Duty cycle 50 %:	250 A (40 °C)	
Duty cycle 60 %:	240 A (40 °C)	90 A (40 °C)
Duty cycle 100 %:	210 A (40 °C)	80 A (40 °C)

*: BiPowerPLUS: Multi voltage supply system:
automatic switiching between 1 and
3 phase in the range 220 – 400 V (option)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**MMA/stick electrode and TIG welding unit MobiARC 284 cel**					
	A	**MMA/Stick electrode welding unit model MobiARC 284 cel**		**45**	**SET143078**	**2.510,00**
	AB	**MMA/Stick electrode welding unit model MobiARC 284 cel incl. accessories**		**45**	**SET143110**	**2.610,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
C	**Accessories:**					
	C1	BiPowerPLUS for series MobiMIG 280 K, MobiARC 282/284 cel, MobiTIG 284/304 DC		46	131445	160,00
	C2	Adapter: Schuko plug 230 V to CEE connector 16 A/400 V for MobiARC 282/284 cel, MobiTIG 284/304 DC, MobiMIG 280/300/320 K		46	130766	39,00
	C3	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	C4	Special cable, shielded with copper coat, 7 x 0,75 110 (per 1m)		07	00701015	5,80
D	**Electrode and earth cable:**					
	Up to 10 m length:					
		Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
		Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
		Welding cable, 35 mm², black (per m)		07	00900200	11,40
	Up to 25 m length:					
		Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
		Electrode welding cable 50 mm², 5 m incl. plug and electrode holder		46	129354	99,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		Welding cable 50 mm², black (per m)		07	00900300	16,80

Up to 50 m length:

		Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
		Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
		Welding cable, 70 mm², black (per m)		07	00900400	21,00

8.5. MobiARC 284 cel ±

Primary:	
Voltage:	3 x 400 V
Frequency:	50 / 60 Hz
Cont. power (MMA/TIG):	9.7 kVA / 8.3 kVA
Cont. current (MMA/TIG):	14 A / 12 A
Max. current (MMA/TIG):	21 A / 16 A
cos phi:	0.98

MMA/stick electrode operation:

Stick electrode:	1.5 - 6.0 mm (Cel-suitable)	
Open circuit voltage:	90 V	
Welding voltage:	20.6 - 31.2 V	
Welding current:	15 - 280 A	
Duty cycle 35 %:		280 A (40 °C)
Duty cycle 50 %:	280 A (20 °C)	250 A (40 °C)
Duty cycle 60 %:	260 A (20 °C)	240 A (40 °C)
Duty cycle 100 %:	240 A (20 °C)	210 A (40° C)

Protection class:	IP 23
Isolation class:	H
Cooling:	AF
Main switch:	3-phase
Operation modes:	MMA/stick welding, TIG (DC) welding with LiftTIG ignition
Settings:	welding current, Hotstart current, Hotstart time, TIG down slope time, electrode type
LEDs:	mains ON, welding ON, failure, temperature protection
Display:	LED indication for current, time, voltage
Electrode type:	selectable rutile, basic, cellulose
Remote control:	socket 10-pole polarity switch
VRD:	optional
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Socket 50 mm²:	earth lead cable
Socket 50 mm²:	electrode welding cable
Mains supply cable:	4 x 2.5 mm² 5 m long with plug 400 V, 16 A
Weight:	19 kg
Dimensions l x w x h:	495 x 210 x 450 mm

TIG operation:

Open circuit voltage:	90 V	
Welding voltage:	10 - 21.2 V	
Welding current:	5 - 280 A	
Duty cyle 35 %:		280 A (40 °C)
Duty cycle 50 %:	280 A (20 °C)	250 A (40 °C)
Duty cycle 60 %:	270 A (20 °C)	240 A (40 °C)
Duty cycle 100 %:	240 A (20 °C)	210 A (40 °C)

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A		**MMA/stick electrode and TIG welding unit MobiARC 284 cel ±**				
	A	**MMA/Stick electrode welding unit Model MobiARC 284 cel ± with polarity switch**		**45**	**SET143112**	**3.590,00**
	AB	**MMA/Stick electrode welding unit Model MobiARC 284 cel ± with polarity switch incl. accessories**		**45**	**SET143114**	**3.690,00**
B		**Standard accessories:**				
		Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
		Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
		Accessories:				
		Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
		Special cable, shielded with copper coat, 7 x 0,75 110 (per 1m)		07	00701015	5,80
		Electrode and earth cable:				
		Up to 10 m length:				
		Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
		Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
		Welding cable, 35 mm², black (per m)		07	00900200	11,40
		Up to 25 m length:				
		Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
		Electrode welding cable 50 mm², 5 m incl. plug and electrode holder		46	129354	99,00
		Welding cable 50 mm², black (per m)		07	00900300	16,80
		Up to 50 m length:				
		Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00
		Welding cable, 70 mm², black (per m)		07	00900400	21,00

9. Plasma cutting units and cutting torches

9.1 Plasma cutting units

9.2 Plasma cutting torches

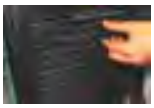
9.1. Plasma cutting units

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

9.1.1. C 82

Primary:	
Supply:	3 x 380 - 440 V (200 - 240 V)
Frequency:	50 / 60 Hz
Continuous power:	6.9 kVA
Continuous current:	10 A
Max. current:	20 A
cos phi:	0.99
Secondary:	
Open circuit voltage:	320 V
Cutting voltage:	80 - 112 V
Cutting current:	20 - 80 A
Duty cycle 35% (10 min.):	80 A
Duty cycle 60% (10 min.):	60 A
Duty cycle 100%:	40 A

Protection class:	IP 23
Insulation class:	H
Cooling	AF
Main switch:	3-phase
Energy control:	continuous adjustable
LEDs:	mains ON, failure, temperature protection
Digital display:	cutting current (option)
Switch:	standard cutting/cutting of perforated sheets
Cutting gas:	compressed air
Pressure indicator:	regulator at the rear
Pilot arc:	safety cut-off, timer controlled
Air pre-flow time:	fixed
Air post-flow time:	automatic controlled depending on cutting time
Valve:	continuous adjustable gas pressure
Fan:	automatic control
Power source:	inverter
Norm:	EN 60974-1 "S" / CE
Torch cooling:	compressed air
Torch connection:	plasma Euro connector
Power supply cable:	4 x 2.5 mm², 5 m with plug 400 V, 16 A
Air supply connector:	quick locking
Socket:	50 mm² for earth lead cable
Weight:	26 kg
Dimensions l x w x h:	535 x 230 x 465 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Plasma cutting unit C 82**					
	A	**Plasma cutting unit model C 82**		**23**	**SET109734**	**4.270,00**
	AB	**Plasma cutting unit model C 82 incl. accessories**		**23**	**SET109736**	**4.305,00**
	ABC	**Plasma cutting unit model C 82 incl. accessories and plasma cutting torch PR 81, 8 m**		**23**	**SET109738**	**4.690,00**
B	**Standard accessories:**					
	B1	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	40,50
C	**Cutting torches**					
	C1	**Plasma hand cutting torch Model PR 81, 8 m, plasma connector**		**03**	**05011315**	**518,00**
D	**Accessories:**					
	D1	Digital display for C 82, AirCUT 80 display of cutting current		46	109808	189,00
	D2	Filter frame incl. filter for TIG 300 DC, LT 240 AC/DC, C 82		46	112548	105,00
	D3	Filter for TIG/E 300 DC, C 82 LT 240 AC/DC (min. 10 pieces)	10 pcs	46	112550	3,25
	D4	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00
E	**Robot and automation accessories:**					
	E1	Connection for machine operation		46	02010915	253,00
	E2	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	E3	Connection for automated welding - 1 control channel (0-10 V) - emerg. STOP, welding ON, arc OK - socket 10 pol.		46	01301123	1.099,00
	E4	Connection cable 10-pol. 5m welding unit - automated system		46	01903556	102,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

9.1.2. AirCUT 120 W

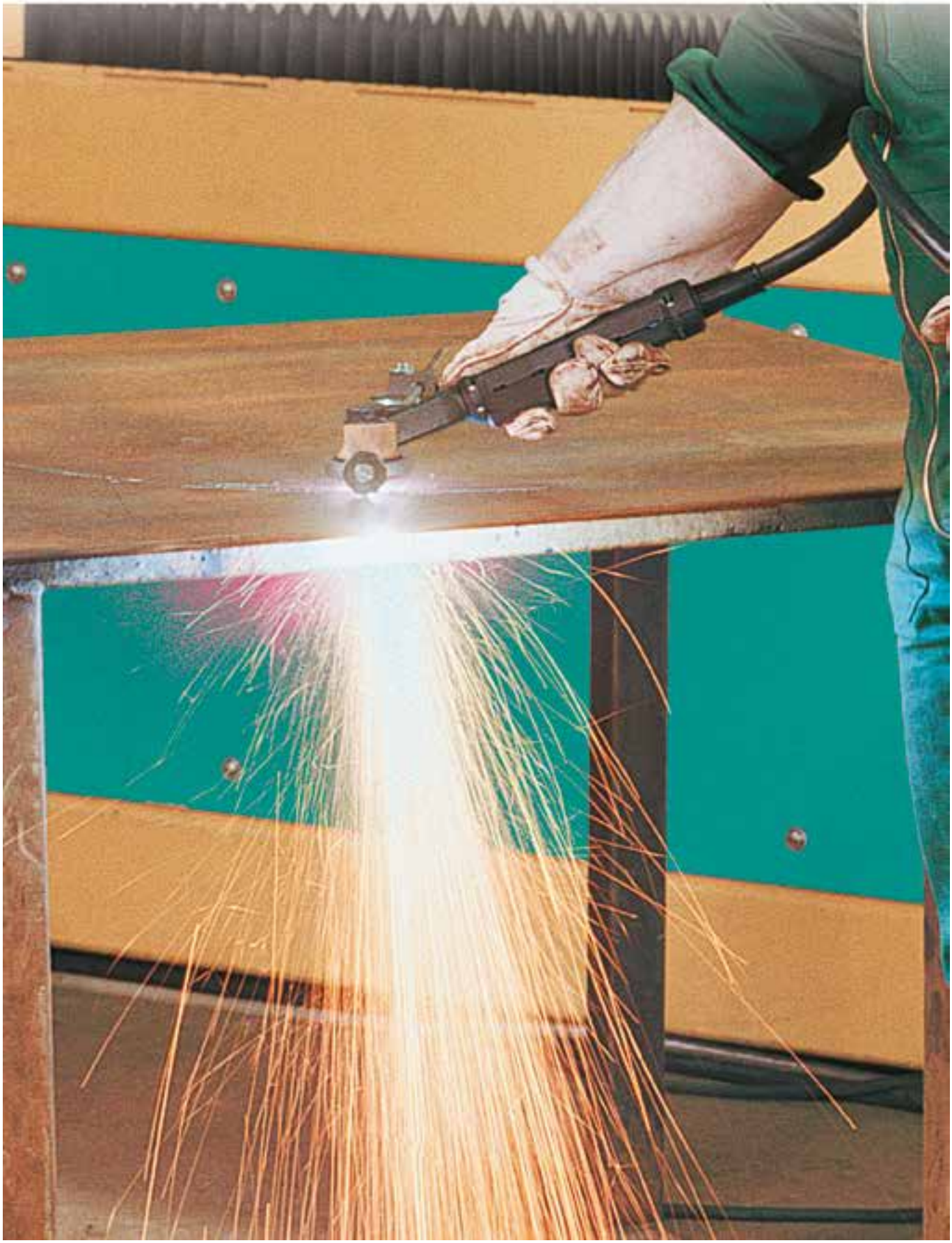
Power supply:		3 x 400 V	
Frequency:		50 Hz	
Primary:	120 A	80 A	40 A
max. current:	48 A	34 A	20 A
cos phi:	0.5	0.7	0.8
Fuse (slow):	50 A	35 A	20 A
Secondary:			
No-load voltage:	280 V	280 V	280 V
Working voltage:	100 V	100 V	100 V
Working current:	120 A	80 A	40 A
Duty cycle 60%:	120 A		
Duty cycle 80%:		80 A	
Duty cycle 100%:			40 A

Protection:	IP 23
Insulation class:	F
Cooling:	AF
Main switch:	0 - 40 A - 80 A - 120 A
SHE-key:	safety device
Control lamp:	mains ON
Control lamp:	pilot arc ON
Control lamp:	failure
Pressure indicator:	compressed air
Pressure switch:	compressed air
Service unit:	compressed air
Safety switch:	inside the torch fitting section
Pilot arc:	safety cut-off switching
Generator:	3-phase
Norm:	EN 60974-1 "S" / CE
Torch cooling:	integrated water cooler
Power supply cable:	4 x 10 mm², 5 m
Air supply:	2 m
Socket 50 mm²:	earth lead
Lifting eyes	4 pieces (option)
Weight:	240 kg
Dimensions l x w x h:	730 x 520 x 905 mm

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
A	**Plasma cutting unit AirCUT 120 W**					
	A	**Plasma cutting unit model AirCUT 120 W**		**23**	**SET114466**	**7.120,00**
	AB	**Plasma cutting unit AirCUT 120 W with accessories**		**23**	**SET114468**	**7.200,00**
	ABC1	**Plasma cutting unit AirCUT 120 W with accessories and plasma hand cutting torch PR 122 W, 8 m**		**23**	**SET114470**	**8.150,00**
	ABC2	**Plasma cutting unit AirCUT 120 W with accessories and machine cutting torch PR 121 W-M, 8 m**		**23**	**SET114472**	**8.270,00**
B	**Standard accessories:**					
	B1	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	B2	SHE-key		46	00100138	39,50
C	**Cutting torches**					
	C1	**Plasma hand cutting torch Model PR 122 W, 8 m**		**03**	**110970**	**950,00**
	C2	**Plasma machine cutting torch model PR 121 W-M, 8 m**		**03**	**102933**	**1.070,00**
D	**Accessories:**					
	D1	Lifting eye screw, galvanized	4 pcs	46	09002001	3,60
	D2	Connection for machine operation		46	02010915	253,00
	D3	Connection cable 6-pol welding unit - automated system, 5 m		46	01903593	87,00
	D4	Mains plug 5-pol. CEE, 63 A, 400 V		07	01201702	96,00
	D5	Professional instruction in the operation of the welding unit, approx. 2 hours		85	129584	150,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

9.2. Plasma cutting torches



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

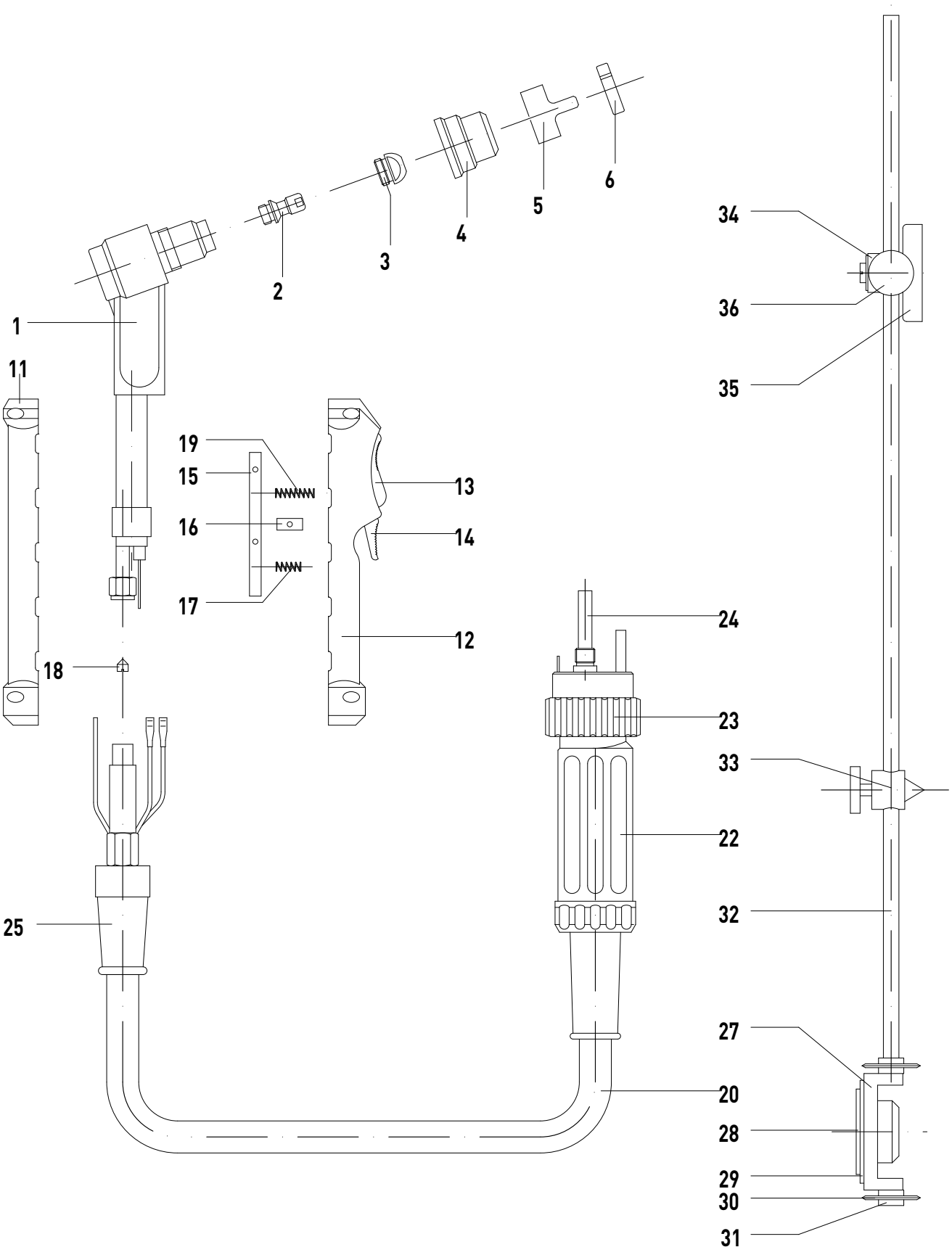
9.2.1. PR 81

Model PR 81

050.1.1315, 8 m long

Technical data:

Cutting current:	max. 80 A/100 V = 8 kW
Duty cycle:	60 % (except consumables)
Plasma carrier:	compressed air
Gas pressure:	4.5 bar
Air consumption:	approx. 40 to 50 l/min
Weight:	750 g/1 m H



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Plasma hand cutting torch PR 81

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		Plasma hand cutting torch Model PR 81, 8 m, plasma connector		**03**	**05011315**	**518,00**

Spare parts and consumables:

	1	Torch body PR 81		24	05010111	224,00
	2	Plasma electrode PR 80/81	10 pcs	52	05011077	4,70
	3.1	Cutting tip 1.0 mm (PR 81, 122)	10 pcs	52	05011078	5,30
	3.2	Cutting tip 1.2 mm (PR 81, 122)	10 pcs	52	05011068	5,30
	3.3	Cutting tip 1.4 mm (PR 81, 122)	10 pcs	52	05011069	5,30
	3.4	Cutting tip 1.6 mm (PR 81, 122)	10 pcs	52	05011067	5,30
	4	Outer nozzle PR 81	5 pcs	24	05010110	9,30
	5	Stand off guide PR 81		24	05010125	10,40
	11	Handle, upper part PR 81, PS 90 G		22	02210691	13,00
	12	Lower handle PR 81, PS 90 G incl. trigger, spring and contact metals		22	02210692	14,50
	13	Trigger PR 81		22	02210693	4,70
	14	Safty trigger		24	02210706	3,00
	15	Contact plate (PR 81)		24	02210696	0,70
	16	Contact blade		24	02210141	0,75
	17	Spring 4.8 x 13, short		24	02210695	0,20
	18	Pressure reducing nozzle PR 81		22	01201001	
	19	Spring for trigger		22	02210130	1,60
	20	Coax cable 8 m, PR 81, PS/PSM 90 G		24	02210504	244,00
	22	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	23	Sleeve nut black		22	02510300	9,80
	24	Plasma central connector, torch side, 7-pol. plug		24	02511691	55,00
	25	Kinking protection, at torch side		22	02210694	2,80

Circular cutting equipment for PR 81:

		Circular cutting equipment for PR 81 with compass tip and magnet holder		**24**	**05010131**	**169,00**
		Guide carriage PR 81		**24**	**05010132**	**52,00**

Spare parts for circular cutting equipment and guidance carrier:

	27	Ring PR 81, PS 90 G		24	05010985	18,90
	28	Turning ring PR 81		24	05010130	11,00
	29	Fastening ring		24	09011631	1,05
	30	Wheel for circular cutting equipment		24	05011045	8,70
	31	Fastening screw for wheels		24	05010988	2,70
	32	Radius bar		24	05011046	28,00
	33	Free centering pin		24	05011049	22,00
	34	Cross piece		24	05011048	22,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
35	Magnet FG 50 IG		24	05011047	9,00
36	Knurl screw		24	05011050	2,60
	SHE key for plasma cutting nozzles PR 81, PR 122 W, PS/PSM 90, PS/PSM 120		46	00100132	3,70

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

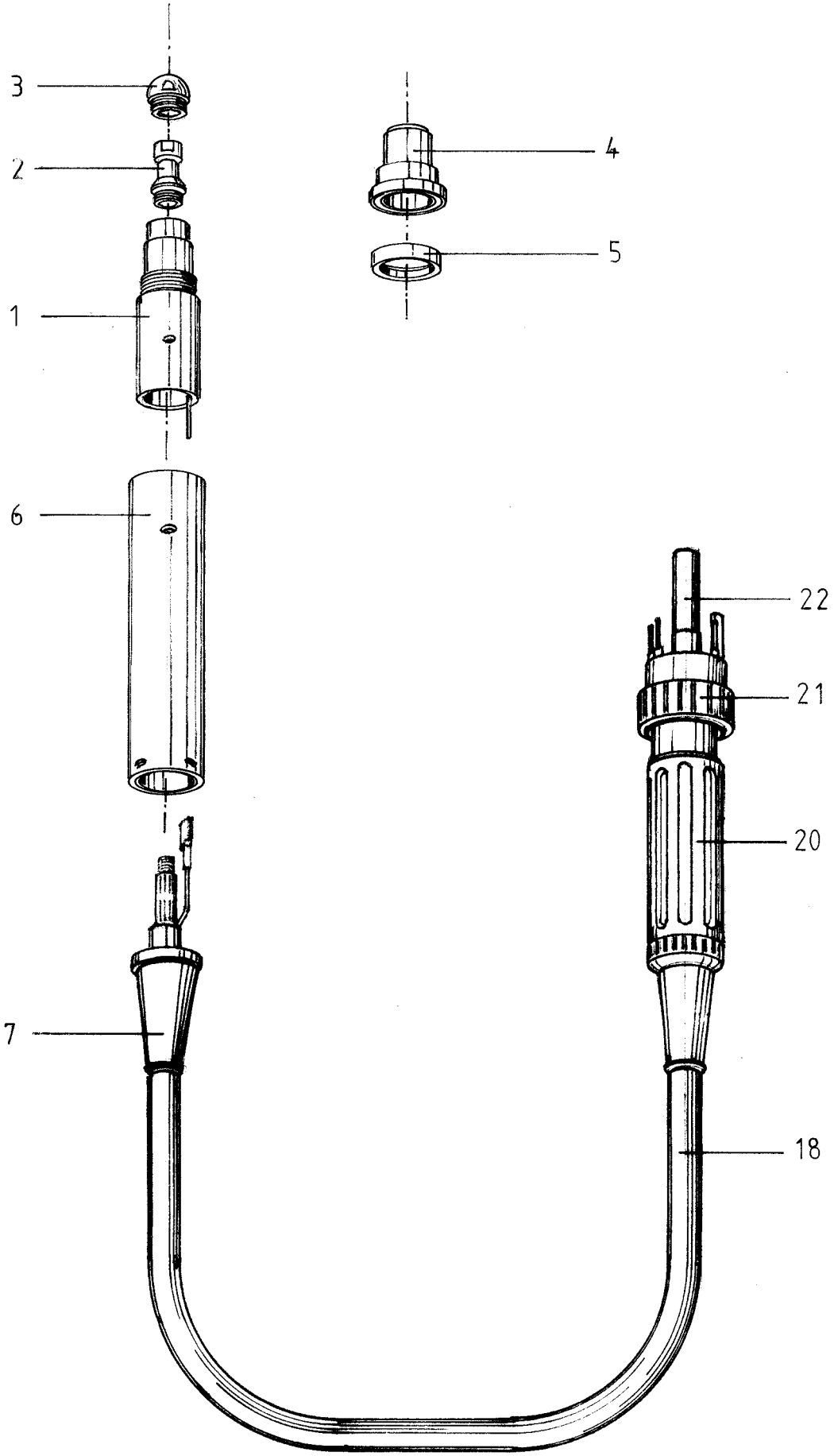
9.2.2. PR 81-M

Model PR 81-M

050.1.1766, 8 m long

Technical data:

Cutting current:	max. 80 A/100 V = 8 kW
Duty cycle:	60 % (except consumables)
Plasma carrier:	compressed air
Gas pressure:	4.5 - 5 bar
Air consumption:	approx. 40 to 50 l/min
Weight:	850 g/1 m H



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Plasma machine cutting torch PR 81-M

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
		Plasma machine cutting torch Model PR 81-M, 8 m		**03**	**05011766**	**560,00**

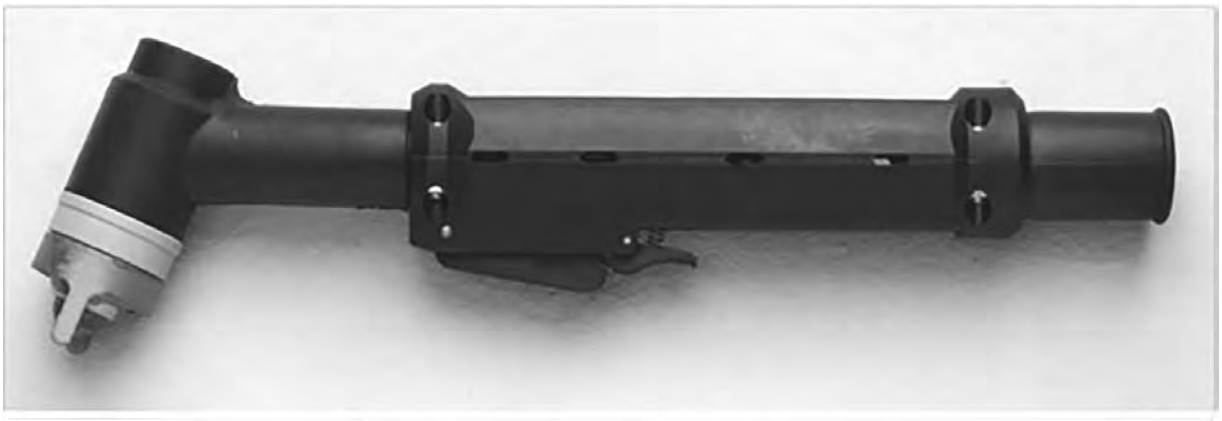
Spare parts and consumables:

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1	Torch body PR 81 M		24	100361	311,00
	2	Plasma electrode PR 80/81	10 pcs	52	05011077	4,70
	3.1	Cutting tip 1.0 mm (PR 81, 122)	10 pcs	52	05011078	5,30
	3.2	Cutting tip 1.2 mm (PR 81, 122)	10 pcs	52	05011068	5,30
	3.3	Cutting tip 1.4 mm (PR 81, 122)	10 pcs	52	05011069	5,30
	3.4	Cutting tip 1.6 mm (PR 81, 122)	10 pcs	52	05011067	5,30
	4	Outer nozzle PR 81	5 pcs	24	05010110	9,30
	5	Insulation WHW 12, WMW 13, PR 81 PSM 90 G		26	01320032	5,00
	6	Handle PR 81-M, PSM 90 G		24	100362	56,00
	7	Spout PR 81-M, PSM 90 G		24	100363	8,90
	18	Coax cable 8 m, PR 81, PS/PSM 90 G		24	02210504	244,00
	20	Kinking protection at machine side MIG Euro connector (set 3 pieces)		22	02511300	7,40
	21	Sleeve nut black		22	02510300	9,80
	22	Plasma central connector, torch side, 7-pol. plug		24	02511691	55,00

9.2.3. PR 122 W

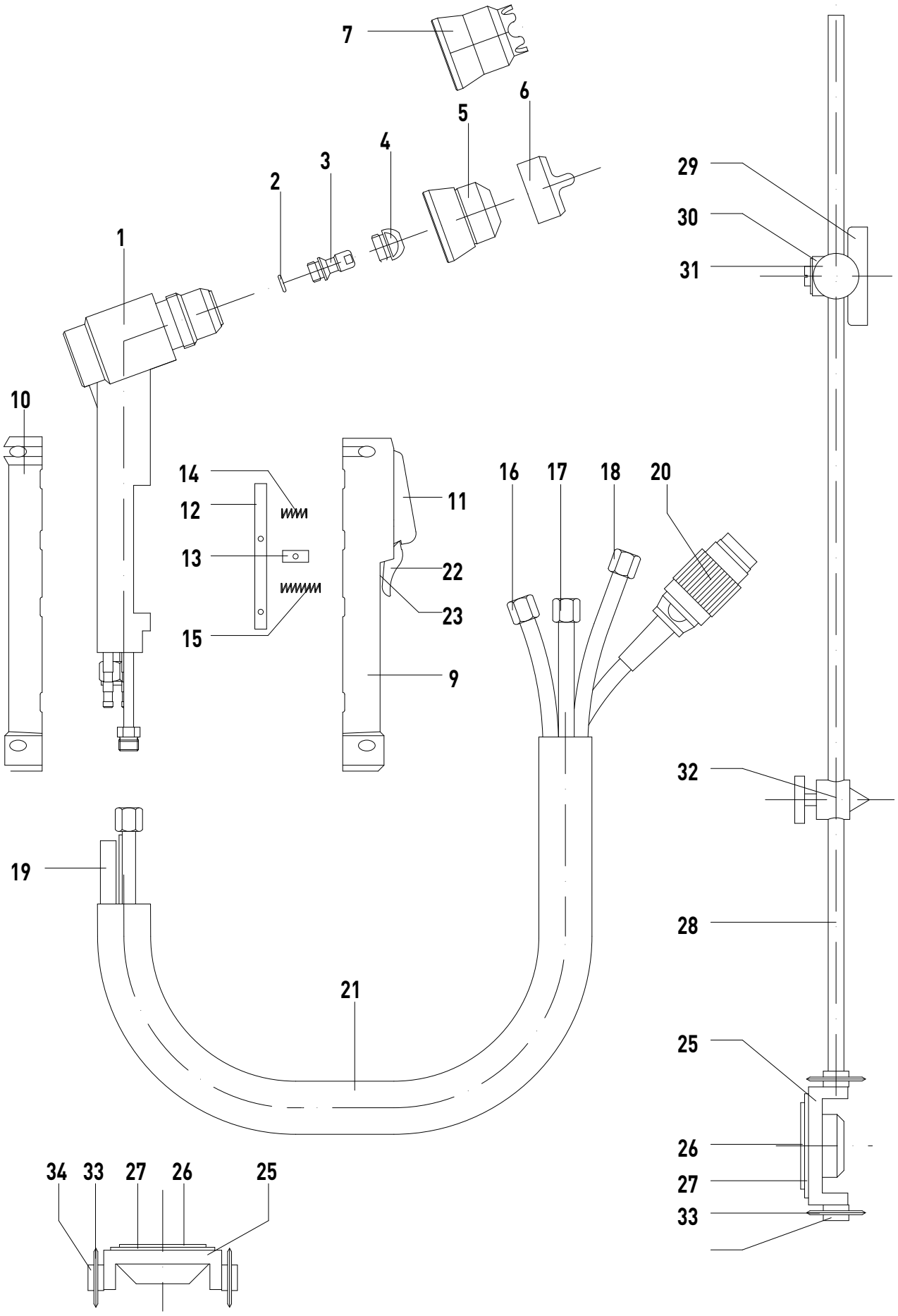
Model PR 122 W

110.970, 8 m long



Technical data:

Cutting current:	120 A/100 V = 12 kW
Duty cycle:	60 % (except consumables)
Plasma carrier:	compressed air
Gas pressure:	4.5 bar
Air consumption:	approx. 40 to 50 l/min
Weight:	1250 g/1 m H



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Plasma hand cutting torch PR 122 W

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Plasma hand cutting torch Model PR 122 W, 8 m		**03**	**110970**	**950,00**

Spare parts and consumables:

1	Torch body PR 122 W		24	110972	455,00
2	O-ring 6 x 1.5		24	05011497	0,60
3	Electrode with O-ring PR 120/121		52	05011205	6,30
4.1	Cutting tip 1.2 mm (PR 81, 122)	10 pcs	52	05011068	5,30
4.2	Cutting tip 1.4 mm (PR 81, 122)	10 pcs	52	05011069	5,30
4.3	Cutting tip 1.6 mm (PR 81, 122)	10 pcs	52	05011067	5,30
4.4	Cutting tip 1.8 mm (PR 81, 122)		52	05011134	5,30
5	Insulation ring PR 122 W, PS 120 W for distance holder incl. contact ring		24	110128	10,30
6	Distance holder PR 122 W		24	110982	15,30
7	Distance holder for operation with ruler PR 122 W, PS 120 W		24	110974	34,00
10	Handle, complete PR 122 W, PS 120 W		22	05011520	106,00
11	Trigger		22	02210122	2,50
12	Contact plate PR 122W, PS 120 W		24	02210140	0,60
13	Contact blade		24	02210141	0,75
14	Spring for trigger		22	02210130	1,60
15	Spring for switch	10 pcs	22	02210131	0,85
16	Water power cable cutting current M 12 x 1, 8 m		24	02211302	146,00
17	Water power cable pilot current 3/8", 8 m		24	02211304	117,00
18	Air hose cpl. 8 m		24	02211322	17,00
18.1	Glant nut for air hose 1/4"		22	01400203	1,80
18.2	Spout for air hose 3.5 mm for nut 1/4"		22	01400200	2,50
19	Water circulation hose 8 m		24	02211312	23,90
20	Switch cable cpl. 8 m		24	02211332	51,00
20.1	Round plug 3-pole		24	04510900	38,00
21	Protective hose 28 x 1,5 black		22	00600405	6,90
22	Safty trigger		24	02210706	3,00
23	Spring 4.8 x 13, short		24	02210695	0,20

Circular cutting equipment for PR 122 W:

	Circular cutting equipment PR 122 W with compass tip and magnet holder		**24**	**110978**	**169,00**
	Guide carriage PR 122 W		**24**	**110980**	**125,00**

Spare parts for circular cutting equipment and guidance carrier:

25	Ring PR 81, PS 90 G		24	05010992	36,00
26	Turning ring PR 122 W, PS 120 W		24	110976	12,70
26.1	Turning ring PR 121/122 W		24	102983	16,90

Pos.	Description	Pu	PrGrp	Part No.	Price/€
27	Safety ring A 45		24	09001633	2,40
28	Radius bar		24	05011046	28,00
29	Magnet FG 50 IG		24	05011047	9,00
30	Cross piece		24	05011048	22,00
31	Knurl screw		24	05011050	2,60
32	Free centering pin		24	05011049	22,00
33	Wheel for circular cutting equipment		24	05011045	8,70
34	Fastening screw for wheels		24	05010988	2,70

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

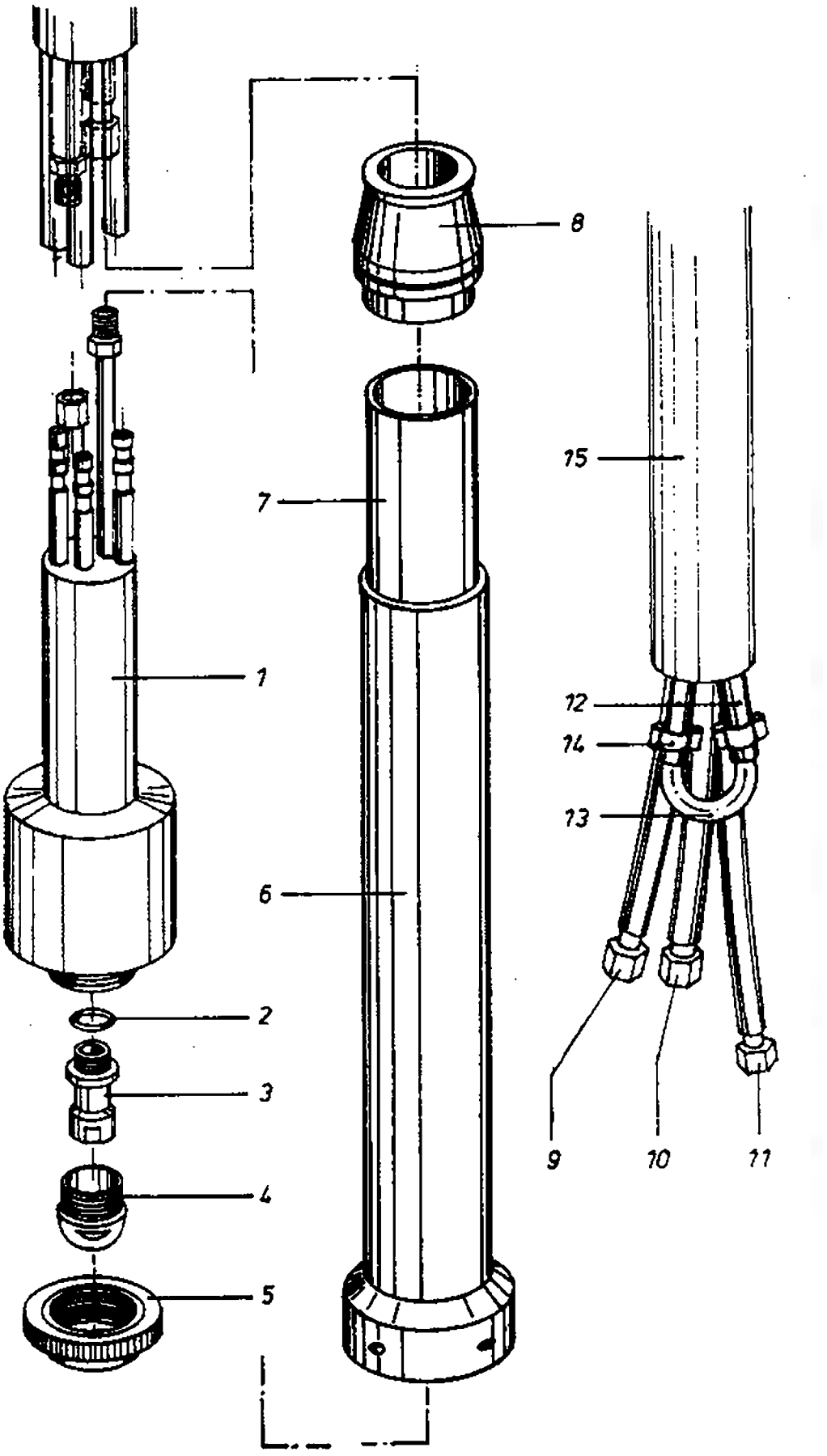
9.2.4. PR 121 W-M

Model PR 121 W-M

102.933, 8 m long

Technical data:

Cutting current:	120 A/100 V = 12 kW
Duty cycle:	60 % (except consumables)
Plasma carrier:	compressed air
Gas pressure:	4.5 bar
Air consumption:	approx. 40 to 50 l/min
Weight:	Torch head 980 g without cable assembly



All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Plasma machine cutting torch PR 121 W-M

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Plasma machine cutting torch model PR 121 W-M, 8 m		**03**	**102933**	**1.070,00**

Spare parts and consumables:

1	Torch body PR 121 W-M (without equipment)		24	102934	540,00
2	O-ring 6 x 1.5		24	05011497	0,60
3	Electrode with O-ring PR 120/121		52	05011205	6,30
4.1	Cutting tip 1.2 mm (PR 81, 122)	10 pcs	52	05011068	5,30
4.2	Cutting tip 1.4 mm (PR 81, 122)	10 pcs	52	05011069	5,30
4.3	Cutting tip 1.6 mm (PR 81, 122)	10 pcs	52	05011067	5,30
4.4	Cutting tip 1.8 mm (PR 81, 122)		52	05011134	5,30
5	Protection ring		24	102935	17,50
6	Handle PR 121 W-M, PSM 120 W		24	05011502	122,00
7	Insulation sleeve PR 121 W-M, PSM 120 W		24	05011503	25,00
8	Kinking protection PR 121 W-M, PSM 120 W		24	05011504	15,44
9	Water power cable cutting current M 12 x 1, 8 m		24	02211302	146,00
10	Water power cable pilot current 3/8", 8 m		24	02211304	117,00
11	Air hose cpl. 8 m		24	02211322	17,00
11.1	Glant nut for air hose 1/4"		22	01400203	1,80
11.2	Spout for air hose 3.5 mm for nut 1/4"		22	01400200	2,50
12	Water circulation hose 8 m		24	02211312	23,90
13	Water circulation tube		24	05011505	16,50
14	Hose clamp		07	02210190	0,50
15	Protective hose 28 x 1,5 black		22	00600405	6,90

Spare parts kit:

	Spare part-kit for PR 121 W-M		**24**	**05011342**	**260,00**

with following parts:

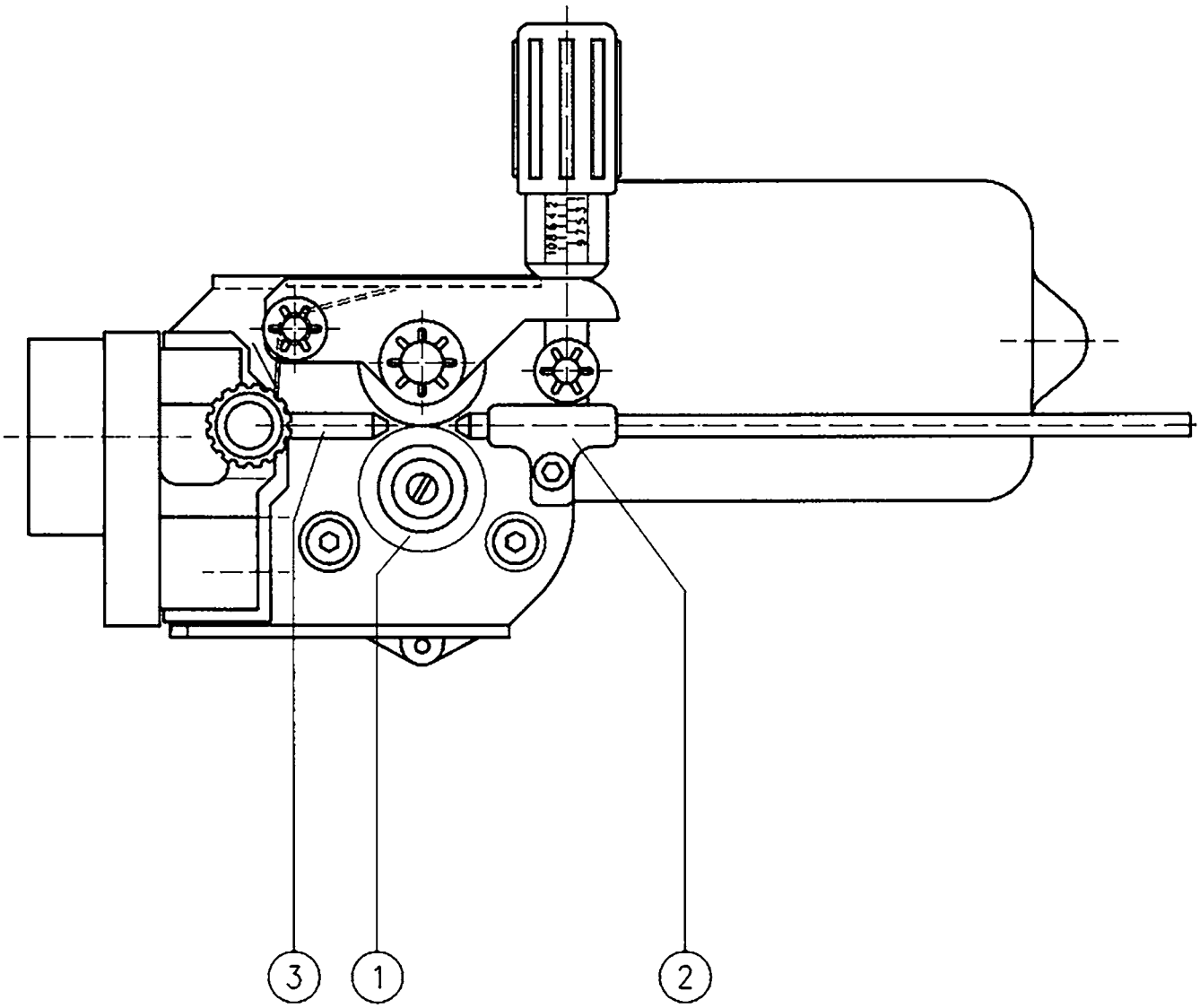
10 Stk	Electrode with O-ring PR 120/121		52	05011205	
5 Stk	Cutting tip 1.2 mm (PR 81, 122)		52	05011068	
5 Stk	Cutting tip 1.4 mm (PR 81, 122)		52	05011069	
5 Stk	Cutting tip 1.6 mm (PR 81, 122)		52	05011067	
5 Stk	Cutting tip 1.8 mm (PR 81, 122)		52	05011134	
5 Stk	Protection ring		24	102935	

10. Accessories

10. Accessories

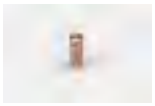
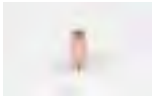
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

10.1. DV-21



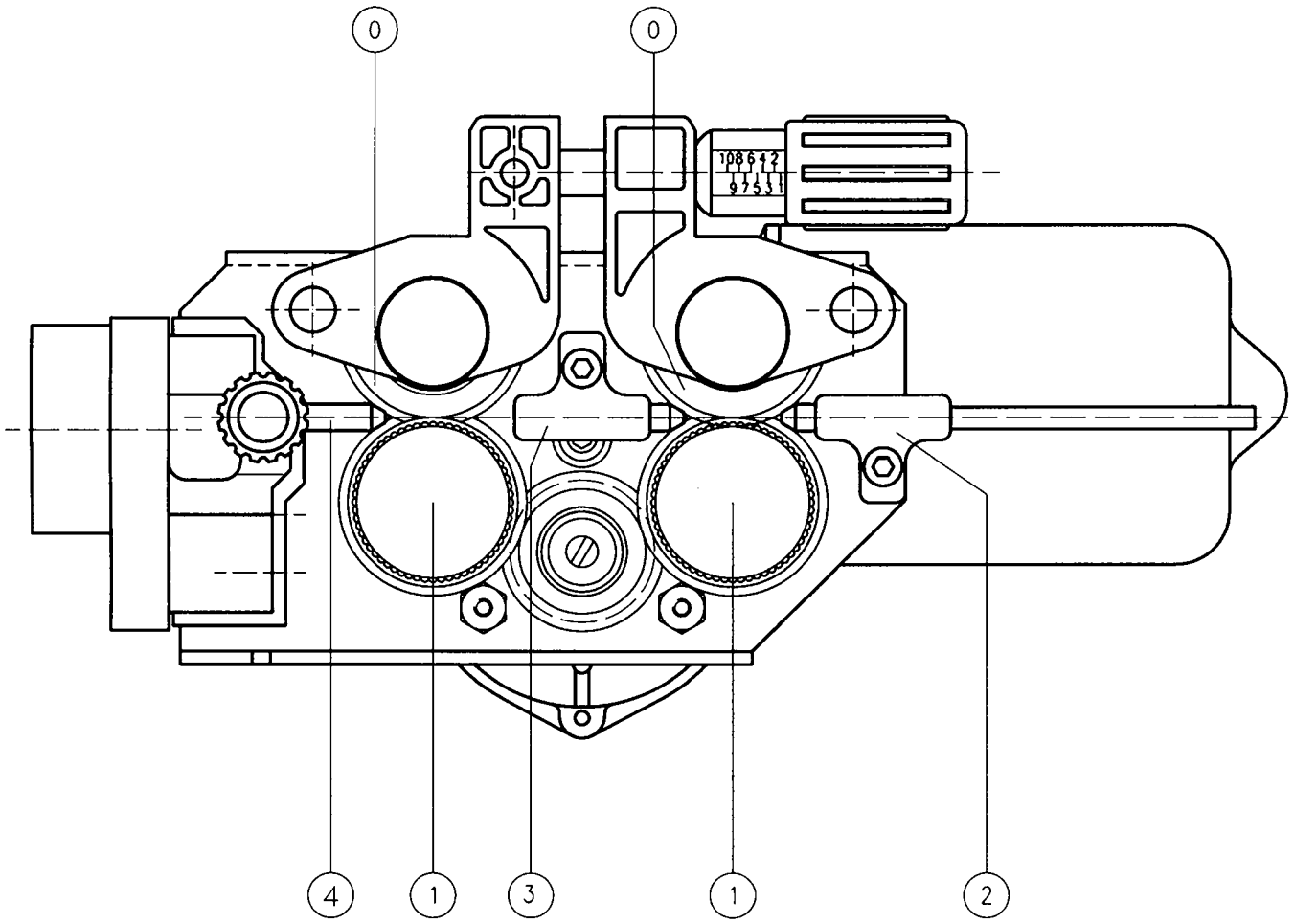
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
2-roller drive wire feeder DV-21						
		2-roller drive wire feeder DV-21, gear block with motor, euro connector and drive roller		**07**	**113756**	**295,00**
Additional wire equipment for DV-21:						
	A	**Kit for mild steel 0.6 mm (DV-21,20/2) (without contact tips)**		**46**	**01200387**	**41,00**
	B	**Kit for mild steel 0.8 mm (DV-21,20/2) (without contact tips)**		**46**	**01200388**	**43,00**
	C	**Kit for mild steel 1.0 mm (DV-21,20/2) (without contact tips)**		**46**	**01200389**	**43,00**
	D	**Kit for stainless steel 0.8 mm (DV-21,20/2) (without contact tips)**		**46**	**01200390**	**58,00**
	E	**Kit for stainless steel 1.0 mm (DV-21,20/2) (without contact tips)**		**46**	**01200391**	**58,00**
	F	**Kit for aluminium 1.0 mm (DV-21,20/2) (without contact tips)**		**46**	**01200392**	**58,00**
1 Drive rollers:						
	1.1	Drive roller steel 0.6/0.6 (DV-21,20/2)		38	01200215	31,00
	1.2	Drive roller steel 0.8/1.0 (DV-21,20/2)		38	01200209	33,00
	1.3	Drive roller steel 0.8/1.2 (DV-21,20/2)		38	01200216	33,00
	1.4	Drive roller alu 1.0/1.2 (DV-21,20/2)		38	01200212	35,00
2 Insertion piece:						
	2.1	Insertion piece DV-21, 26 complete with insertion liner		38	117938	12,75
3 Outgoing nozzle:						
	3.1	Outgoing and guidance nozzle pvc, DV-21, 20/2		38	01200384	6,30
4 Wire feed liners:						
	4.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	4.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	4.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	4.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	4.5	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
5	**Contact tips (for SB/SBT 157 G):**					
	5.1	Contact tip 0.6 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152181	1,73
	5.2	Contact tip 0.8 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152180	1,73
	5.3	Contact tip 1.0 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152182	1,73
6	**Contact tips (for SB/SBT 307 G):**					
	6.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	6.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	6.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95

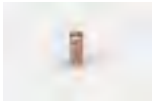
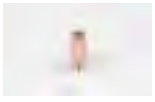
All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

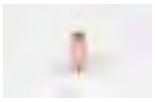
10.2. DV-26



Pos.	Description	Pu	PrGrp	Part No.	Price/€
4-roller drive wire feeder DV-26					
	4-roller drive wire feeder DV-26 incl. motor and Euro connector incl. pressure rollers, without drive rings, drive pinion and roller carrier from metal		**07**	**113564**	**416,00**
	4-roller drive wire feeder DV-26 incl. motor and Euro connector incl. pressure rollers, without drive rings, drive pinion and roller carrier from plastic		**07**	**160772**	**391,00**
Additional wire equipment for DV-26:					
A	**Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113846**	**63,00**
B	**Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113848**	**63,00**
C	**Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113852**	**79,00**
D	**Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113854**	**79,00**
E	**Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113858**	**83,00**
F	**Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113860**	**83,00**
Components for additional wire equipment:					
0.1	Pressure ring DV-26/31/32		38	124724	25,00
0.2a	Roller carrier metal DV-26/31/32 with ball bearing		07	110560	49,00
0.2b	Roller carrier plastic DV-26/31/32 with ball bearing		07	160768	44,00
0.3	Distance ring for core wire equipment DV-26, DV-31		38	126968	2,50
0.4a	Drive pinion DV-26, metal		07	113580	48,00
0.4b	Drive pinion DV-26, plastic		07	158330	43,00
1 Drive rollers:					
1.0	Drive ring steel 0.6 + 0.8 DV-26/31/32		38	113945	35,00
1.1	Drive ring steel 0.8 + 1.0 DV-26/31/32		38	113946	35,00
1.2	Drive ring steel 1.0 + 1.2 DV-26/31/32		38	01200272	35,00
1.3	Drive ring steel 0.9 + 0.9 DV-26/31/32		38	01200262	35,00
1.4	Drive ring alu 1.0 + 1.2 DV-26/31/32		38	01200281	35,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

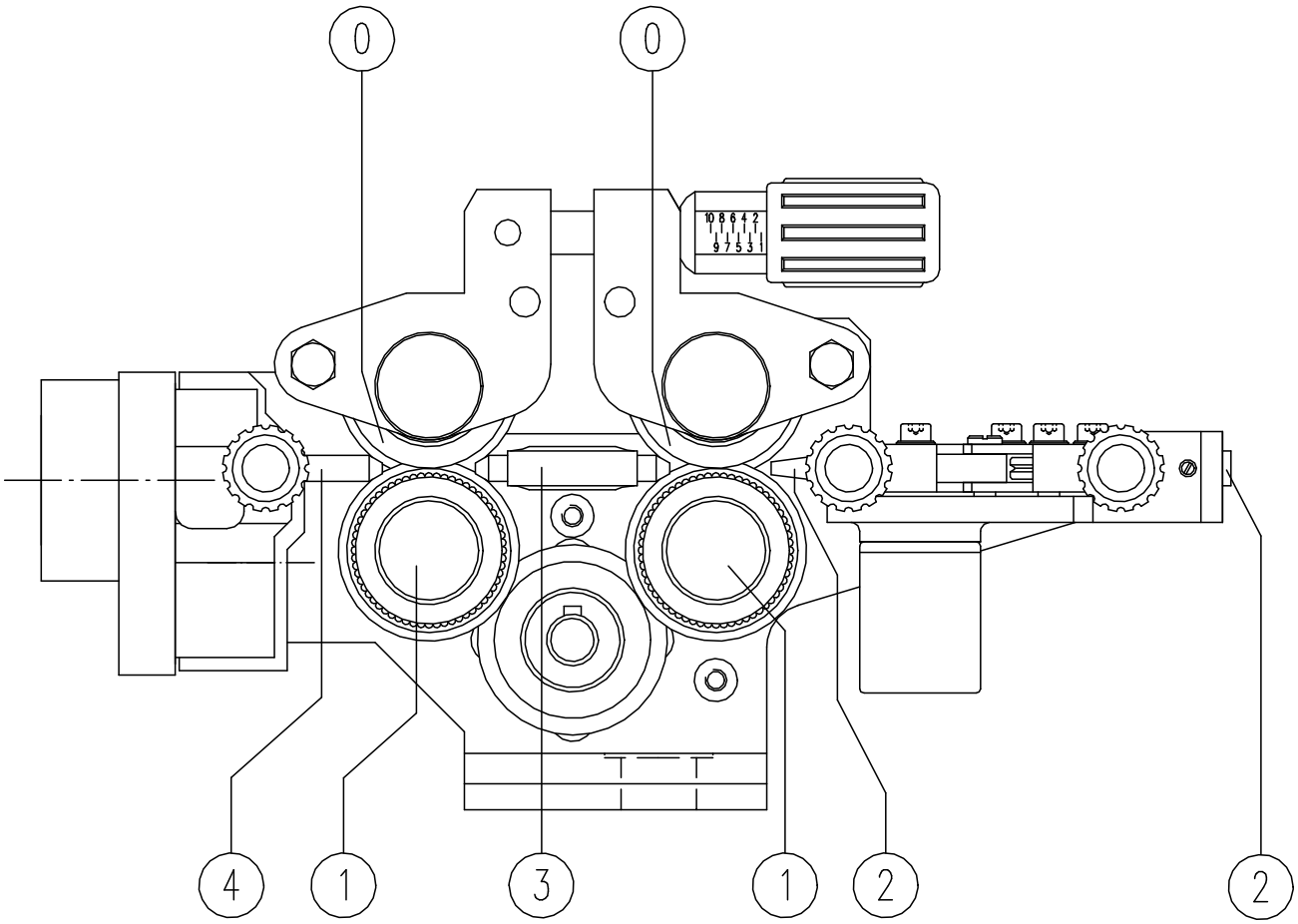
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	1.5	Drive ring alu 0.8 + 1.6 DV-26/31/32		38	01200282	35,00
2	**Insertion piece:**					
	2.1	Insertion piece DV-21, 26 complete with insertion liner		38	117938	12,75
3	**Insertion and guidance nozzle:**					
	3.1	Guidance piece with double guide DV-21/26		38	131508	7,50
4	**Outgoing nozzle:**					
	4.1	Outgoing nozzle DV-26, 31, 30/4 0.8 - 1.6 mm		38	110554	5,25
5	**Wire feed liners:**					
	5.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
	5.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
	5.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
	5.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
	5.6	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
	5.6	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
	5.7	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
	5.8	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner	1 pc	22	135574	37,00
	5.9	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	5.10	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00
6	**Contact tips (for SB/SBT 157 G):**					
	6.1	Contact tip 0.6 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152181	1,73
	6.2	Contact tip 0.8 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152180	1,73
	6.3	Contact tip 1.0 mm SB/SBT 157 G M6 x 0.75 ECU	20 pcs	52	152182	1,73
7	**Contact tips SB/SBT 307/351/352/504:**					
	7.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	7.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	7.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	7.4	Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	52	04511817	1,95



Pos.	Description	Pu	PrGrp	Part No.	Price/€
7.5	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
7.6	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
7.7	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
7.8	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

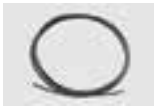
10.3. DV-31



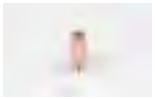
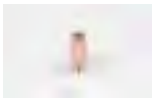
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
4-roller drive wire feeder DV-31						
		4-roller drive wire feeder DV-31, incl. motor and Euro connector incl. pressure rollers, without drive rings		**07**	**113836**	**1.420,00**
Additional wire equipment for DV-31:						
	A	**Kit for mild steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113846**	**63,00**
	B	**Kit for mild steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113848**	**63,00**
	C	**Kit for mild steel 1.6 mm (DV-31/32) (2 drive rings and wire core)**		**46**	**113850**	**63,00**
	D	**Kit for stainl. steel 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113852**	**79,00**
	E	**Kit for stainl. steel 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113854**	**79,00**
	F	**Kit for stainl. steel 1.6 mm (DV-31/32) (2 drive rings and wire core)**		**46**	**113856**	**79,00**
	G	**Kit for alu 0.8 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113858**	**83,00**
	H	**Kit for alu 1.0/1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113860**	**83,00**
	I	**Kit for alu 1.6 mm (DV-31/32) (2 drive rings and wire core)**		**46**	**113862**	**83,00**
	J	**Kit for core wire 1.2 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113864**	**78,00**
	K	**Kit for core wire 1.6 mm (DV-26/31/32) (2 drive rings and wire core)**		**46**	**113866**	**78,00**
	L	**Kit for core wire 2.0/2.4 mm (DV-31/32) (4 drive rings etc.)**		**46**	**113868**	**219,00**
	M	**Kit for core wire 2.8 mm (DV-31/32) (4 drive rings, etc.)**		**46**	**113870**	**219,00**
	N	**Kit for core wire 3.2 mm (DV-31/32) (4 drive rings etc.)**		**46**	**113872**	**219,00**
Components for additional wire equipment:						
	0.1	Pressure ring DV-26/31/32		38	124724	25,00
	0.2	Roller carrier metal DV-26/31/32 with ball bearing		07	110560	49,00
	0.3	Distance ring for core wire equipment DV-26, DV-31		38	126968	2,50

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	**Drive rollers:**				
1.0	Drive ring steel 0.6 + 0.8 DV-26/31/32		38	113945	35,00
1.1	Drive ring steel 0.8 + 1.0 DV-26/31/32		38	113946	35,00
1.2	Drive ring steel 1.0 + 1.2 DV-26/31/32		38	01200272	35,00
1.3	Drive ring steel 0.9 + 0.9 DV-26/31/32		38	01200262	35,00
1.4	Drive ring steel 1.6 + 1.6 DV-31/32		38	113948	35,00
1.5	Drive ring alu 1.0 + 1.2 DV-26/31/32		38	01200281	35,00
1.6	Drive ring alu 0.8 + 1.6 DV-26/31/32		38	01200282	35,00
1.7	Drive ring core wire 1.2 + 1.6 DV-31/32		38	01200291	38,00
1.8	Drive ring core wire 2.0 + 2.4 DV-31/32		38	01200292	38,00
1.9	Drive ring core wire 2.8 + 3.2 DV-31/32		38	01200293	38,00
2	**Insertion nozzle:**				
2.1	Insertion nozzle DV-31, 30/4 0.8 - 1.6 mm		38	110862	5,25
2.2	Insertion nozzle DV-31, 30/4 2.4 - 3.2 mm		38	110863	6,80
3	**Guidance nozzle:**				
3.1	Guidance nozzle DV-31, 30/4 0.8 - 1.6 mm		38	110552	5,25
3.2	Guidance nozzle DV-31, 30/4 2.4 - 3.2 mm		38	110553	6,80
4	**Outgoing nozzle:**				
4.1	Outgoing nozzle DV-26, 31, 30/4 0.8 - 1.6 mm		38	110554	5,25
4.2	Outgoing nozzle DV-31, 30/4 2.4 - 3.2 mm		38	110555	6,80
5	**Wire feed liners:**				
5.1	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 3 m long		22	02210246	5,40
5.2	Liner for steel (blue) 1.5x4.0 0.6 - 0.8 (1.0) mm, 4 m long		22	02210247	5,70
5.3	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 3 m long		22	02210244	5,60
5.4	Liner for steel (red) 2.0x4.0 1.0 - (1.2) mm, 4 m long		22	02210245	5,90
5.5	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 3 m		22	02210248	5,60
5.6	Liner for steel (uncoated) 2.5x4.5 1.2 - 1.6 mm, 4 m		22	02210249	5,90
5.7	Teflon liner for alu and stainl.st. 0.8 - 1.2 mm, 3 m (red, 2.0 x 4.0) with brass outgoing liner		22	02210586	25,00
5.8	Teflon liner for stainless steel 0.8 - 1.2 mm, 4 m (red, 2.0 x 4.0) with brass outgoing liner		22	108520	29,00
5.9	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 3 m (dark grey, 2.3 x 4.7) with brass outgoing liner		22	137778	31,00
5.10	Teflon liner for alu and stainl.st. 1.2 - 1.6 mm, 4 m (dark grey, 2.3 x 4.7) with brass outgoing liner	1 pc	22	135574	37,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	5.11	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 3 m (black, 2.7 x 4.7)		22	02210588	38,00
	5.12	Teflon liner for alu and stainl.st. (1.2) - 1.6 mm, 4 m (black, 2.7 x 4.7)		22	132788	46,00

6 Contact tips SB/SBT 307/351/352/504:

	6.1	Contact tip Cu-Cr-Zr 0.8 mm M8	20 pcs	52	04511814	1,95
	6.2	Contact tip Cu-Cr-Zr 1.0 mm M8	20 pcs	52	04511815	1,95
	6.3	Contact tip Cu-Cr-Zr 1.2 mm M8	20 pcs	52	04511816	1,95
	6.4	Contact tip Cu-Cr-Zr 1.6 mm M8	20 pcs	52	04511817	1,95
	6.5	Contact tip 0.8 mm alu CuCrZr M8	20 pcs	52	109754	2,60
	6.6	Contact tip 1.0 mm alu CuCrZr M8	20 pcs	52	109756	2,60
	6.7	Contact tip 1.2 mm alu CuCrZr M8	20 pcs	52	109758	2,60
	6.8	Contact tip 1.6 mm alu CuCrZr M8	20 pcs	52	04511818	2,60

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10.4. Water cooling units

Power supply:	1 x 230 V 1 x 400 V / 230 V (WK 230 / 300)
Frequency:	50 / 60 Hz
Mains current:	1 A / 1.6 A
Water pump:	high efficiency pump 230 V
Water pressure:	3.5 bar
Water capacity:	3 l
Water pressure switch:	integrated
Functions:	automatic switch of water pump and fan
electr. connection:	cable with 6-pole plug
Water connection:	2 quick couplings
Weight/Dimensions l x w x h:	15 kg, 590x210x210 mm (WK 210) 18 kg, 610x230x215 mm (WK 230) 20 kg, 600x300x260 mm (WK 300) 28 kg, 700x355x285 mm (WK 350)

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Water cooling units:				
	Water cooling unit model WK 210		**46**	**143136**	**990,00**
	Water cooling unit model WK 230		**46**	**02610142**	**990,00**
	Water cooling unit model WK 300		**46**	**02610143**	**990,00**
	Water cooling unit model WK 301		**46**	**158990**	**990,00**
	Water cooling unit model WK 350		**46**	**144008**	**1.200,00**
	Coolant ME-KM 20, ideal for all welding units and welding torches:				
	Coolant ME-KM 21, 10 l for welding units to -20°C		07	107822	29,00
	Coolant for welding units ME-KM 21(30 l), -20°C		07	118550	74,25
	Coolant for welding units ME-KM 21 (220 l), -20°C		07	118552	684,00
	Coolant for welding units ME-KM 21 (1000 l), -20°C		07	118554	1.550,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Coolant for plasma welding units:				
	Coolant for plasma welding units ME-KM Plasma (30 l), no anti freeze protection		07	129660	99,00

10.5. WeldFACTORY 4.0

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Options:						
	1.1	Software WeldFACTORY - Suitable for manual, automatic and robot controlled welding processes - Creation, execution and monitoring of automated production processes - Any quantity of welding units and machines in the network with any number of workstations - Networking of all welding units and peripheral devices via OPC UA - Cloud-based software architecture - Connection of other peripheral devices in the network possible (e.g., bar code reader, component counters, input terminals, etc.)		17	159326	5.900,00
2						
	2.1	WeldFACTORY welding machine equipment without software for one unit (159.191), monitoring of current, voltage, incl. ethernet interface and industrial ethernet plug allowing connection to an existing ethernet, incl. ethernet cable, 5 m		17	159190	765,00
	2.2	WeldFACTORY licence for one welding machine		17	159191	490,00
	2.3	Option Wifi equipment		17	144106	145,00
3 Options:						
	2.1	WeldFACTORY gas flow monitoring hardware installed in the welding machine (incl. connection cable 1.6 m)		17	159328	615,00
	2.2	WeldFACTORY option wire feed speed monitoring sensor for DV-31		17	159330	990,00
	2.3	WeldFACTORY Touch-Controller		17	159194	1.500,00
	2.4	Barcode-Scanner for WeldFACTORY		17	159198	475,00
	2.5	Tablet-PC, WeldFACTORY pre-installed icrosoft Surface Go - Tablet - Pentium Gold 4415Y / 1.6 GHz - Win 10 Pro - 4 GB RAM - 64 GB eMMC - 25.4 cm (10") Touchscreen 1800 x 1200 HD Graphics 615 Wi-Fi Bluetooth		46	157500	1.250,00
	2.6	Training and set-up for WeldFACTORY/Q.MACS software (price per day, extras not included)		85	139188	928,00

10.6. Software, Program updates, Calibration

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Software for EN 1090:						
	1.1	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and HighPULSE touch 350 - 550 A incl. calibration of the unit		17	135636	149,00
	1.2	EN 1090 WPS/WPQR package for series OptiMIG		17	138672	149,00
	1.3	EN 1090 WPS/WPQR package incl. jobs for series HighPULSE and OptiMIG for existing machines (calibration not included)		17	156806	99,00
2 Software:						
	2.1	Software ProDok32: generation and documentation of pulse and MIG/MAG programs for PC with RS 232 or USB port, for Windows, incl. dongle and 5 m cable, CD-ROM		17	113810	1.015,00
	2.2	Software ProJOB32: job generation and documentation, and software updates for PC with RS 232 or USB port, for Windows, incl. 5 m cable, converter, CD-ROM		17	118444	150,00
	2.3	Software ProJOB32pro: job generation and documentation, offline and online, and software updates for PC with RS 232, USB or ethernet port, for Windows, incl. 5 m cable, CD-ROM		17	125584	1.200,00
3 Program updates and welding software:						
	3.1	Programm update for all welding units incl. EPROM		17	100724	289,00
	3.2	Programm update for MAG-30 controller		17	117972	210,00
	3.3	Programm update for LogiTIG with pcb ME-TIG-4.7		17	137140	250,00
	3.4	Programming of new welding program according to customer's specifications for synergic pulse units		17	100725	940,00
	3.5	Programming of new welding program according to customer's specifications for MIG/MAG units		17	100726	495,00
ColdMIG	3.6	Software for ColdMIG process for series HighPULSE/SpeedMIG		17	118064	880,00
DeepARC	3.7	Software for DeepArc process for series HighPULSE		17	118162	880,00
HighUP	3.8	Software for HighUP process for series HighPULSE		17	134392	880,00
InterPULSE	3.9	Software for Interpulse process for series HighPULSE		17	120490	280,00
4 Calibration:						
	4.1	Calibration of welding machine incl. documentation		14	100619	95,00

All prices per piece plus VAT and material surcharge.
Subject to change. Valid from 18.05.2020

10.7. Calibration unit MCU 1000

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	**Complete system:**				
1.1	Calibration unit MCU 1000, complete system consistant of: calibration resistor 1000 A, sensor box for wire speed and gas flow, software (without computer and printer), all adapters and cables. For the calibration of welding units according to DIN EN 50504, suitable for MIG/MAG, TIG, MMA/stick electrode, Plasma - Measurement of welding current and voltage (+/- 1.0 %) - Measurement of temperatur and supply voltage (1ph/3ph) - External measurement of wire feed speed and gas flow - High duty cycle due to cooling with integrated fan - Automatic switching of the steps - HF proof design for calibration of TIG units - Grafic display for easy setting and recording of calibration and measurement parameters - Robust aluminium housing for mobile application at the customer - External software control - Automatic temperatur switch-off Dimensions appr. L 750 mm, W 310 mm, H 650 mm Weight approx. 45 kg		17	SET146510	9.200,00
1.2	Wheel set 160 mm 2 swivel wheels, 2 fix wheels		46	146132	68,00
1.3	Extension cable between sensor box (MCU 1000) and Euro connector at power source, approx. 1 m		17	146458	420,00
1.4	Calibration of the calibration unit MCU 1000 at Merkle Germany incl. BGUV3 check, incl. documentation, annually required		85	144204	330,00
1.5	Training and set-up for calibration system MCU 1000 incl. software installation (price per day, extras not included)		85	145956	1.144,00
1.6	Software installation via Teamviewer (3 h) Calibration unit MCU 1000 incl. telephone briefing		85	148478	429,00
2	**System components:**				
2.1	Calibration resistor 1000 A (MCU 1000) For the calibration of welding units according to DIN EN 50504, suitable for MIG/MAG, TIG, MMA/stick electrode, Plasma - Measurement of welding current and voltage (+/- 1.0 %) - Measurement of temperatur and supply voltage (1ph/3ph) - Connector for external measurement of wire feed speed and gas flow - High duty cycle due to cooling with integrated fan - Automatic switching of the steps - HF proof design for calibration of TIG units - Grafic display for easy setting and recording of calibration and measurement parameters - Robust aluminium housing for mobile application at the customer - External control with optional software - Automatic temperatur switch-off Dimensions appr. L 750 mm, W 310 mm, H 650 mm Weight approx. 45 kg		17	141500	6.450,00

Pos.	Description	Pu	PrGrp	Part No.	Price/€
2.2	Set of two connection cables for MCU 1000 each 95 mm² abd 1.5 mm² with plugs in protection hose		17	143976	255,00
2.3	Adapter Euro connector --> Dinse socket with wire feed hose for external sensor box for MCU 1000		17	143974	105,00
2.4	Adapter cable and adapter for MCU 1000 for monitoring of the power supply voltage: 3~ 16 A CEE --> 6-pol Harting		17	146102	160,00
2.5	External sensor box for wire feed speed and gas flow for MCU 1000 and Q.MACS extern, for connection to Euro-connector, range 0 - 30 m/min and 3 - 30 l/min		17	141502	1.230,00
2.6	Connection cable between external sensor box and calibration resistor MCU 1000		17	143972	170,00
2.7	Calibration software (without installation) software functions: measurement of welding current (0-1000 A), welding voltage (0-100 V), wire feed speed (0-30 m/min), gas flow (0-20 l/min), supply voltage, room temperature (0-100°C) => parameter montoring and control if the parameters are within the tolerance limits => report creation in pdf, excel or word format software in German and English (latest software version can be downloaded)		17	141504	890,00
2.8	USB cable 3 m, transparent, gold plug with ferrit ring, USB-A to USB-B		17	144942	9,20

10.8. Accessories

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
1 Trolley:						
	1.1	Trolley model TW 112, black for portable welding units (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	138938	325,00
	1.2	Drawer option for trolley TW 112 incl. one drawer		46	138940	298,00
	1.3	Trolley model TW 114, black for portable welding units and RS series (incl. water cooling unit) incl. gas bottle holder for 1 cylinder		46	144000	365,00
	1.4	Transportation cart TW 50 - with gas bottle holder for portable welding units, with additional wheel, 4 lifting eyes, quick-lock system for welding unit, with gas bottle holder for 10 l cylinder		46	155506	805,00
2 Regulators:						
	2.1	Regulator argon/CO2 standard version		46	107018	58,00
	2.2	Regulator argon/CO2, single stage		46	01200300	68,00
	2.3	Gas regulator Argon-CO2 0-30 l/min with flow meter		46	114554	168,00
	2.4	Gas regulator Argon-CO2 0-5 l/min with flow meter		46	144214	228,00
3 Earth leads:						
	3.1	Earth lead 16 mm², 4 m long with plug 50 mm² and earth clamp		46	02210385	39,00
	3.2	Earth lead 25 mm², 4 m long with plug and earth clamp		46	02210400	40,50
	3.3	Earth lead 35 mm², 4 m long with plug 50 mm² and earth clamp		46	02210401	66,00
	3.4	Earth lead 50 mm², 4 m long with plug and earth clamp		46	02210402	76,00
	3.5	Earth lead 70 mm², 4 m long with plug and earth clamp		46	02210408	98,00
	3.6	Earth lead 95 mm², 4 m long with plug and earth clamp		46	02210403	151,00

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	3.7	Earth lead 95 mm², 5 m long with plug 95 mm² and ring d=12 mm		46	139816	154,00
	3.8	Earth lead 120 mm², 4 m long with plug and earth clamp		46	02210396	243,00

4 Electrode welding cables:

	4.1	Electrode welding cable 16 mm², 4 m incl. plug 50 mm² electrode holder		46	115702	42,00
	4.2	Electrode welding cable 35 mm², 5 m incl. plug 50 mm² & electrode holder		46	02210451	70,80
	4.3	Electrode welding cable 70 mm², 5 m incl. plug and electrode holder		46	02210449	145,00

5 Remote controls:

	5.1	Foot remote control pedal with 5 m cable and 5-pol plug		46	116730	520,00
	5.2	Foot remote with 5 m cable and 10 pin plug		46	01903000	530,00
	5.3	Foot remote with 8 m cable and 10 pin plug		46	01902999	540,00
	5.4	Hand remote control MFR-10, 5 m with 10 pin plug, with magnetic foot incl. switch for polarity change (only MobiARC 284 cel +-)		46	123791	355,00
	5.5	Remote control box for energy and voltage trim incl. 5 m cable		46	01903542	420,00
	5.6	Hand remote 4m with 10 pin plug		46	01301059	257,00
	5.7	Hand remote 8m with 10 pin plug		46	01301060	280,00
	5.8	Foot switch single, 3 m cable		05	01902900	225,00
	5.9	Foot switch double, 3 m cable		05	01902901	396,00
	5.10	MAG Remote Control MRC-50 for HighPULSE und SpeedMIG in steel casing with handgrip and magnet, incl. 5 m supply cable		46	154578	885,00

6 Filters:

	6.1	Filter for TIG/E 300 DC, C 82 LT 240 AC/DC (min. 10 pieces)	10 pcs	46	112550	3,25
	6.2	Filter for RS units 450/550 (minimum 10 pieces)	10 pcs	46	114468	3,50
	6.3	Filter for HighPULSE and SpeedMIG Version KW and DW, 320x330x25 mm (minimum 10 pieces)	10 pcs	46	113844	3,50

All prices per piece plus VAT and material surcharge.
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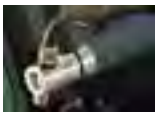
	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	6.4	Filter mat 245 x 290 mm for Insquare 300/420/600, HighPULSE 282, 284, 352, 354 K, HighPULSE touch 280/350 K, CompactMIG 400 (min. 10 pieces)	10 pcs	46	00501048	3,50
	6.5	Filter for OptiMIG	10 pcs	46	109528	3,50
	6.6	Metal filter for HighPULSE 284/354 K HighPULSE touch 280/350 K		46	157336	110,00
	6.7	Metal filter insert for HighPULSE, SpeedMIG, HighTIG 300 x 315 x 20 mm		46	156144	110,00

7 Accessories:

	7.1	Adapter for wire spool		46	02900104	19,50
	7.2	Torch holder D27 for mounting at the handle or handle tube		46	157598	39,00
	7.3	Transportation box "Merkle", black material: polypropylen, water proof, for LiteARC 160/180, LiteTIG 190 inner dimensions 50 x 35 x 19.4 cm		46	n01200371	149,00
	7.4	Transportation box black big material: polypropylen, water proof, for LiteARC 160/180, MobiTIG 180, LiteTIG 190 inner dimensions 59 x 47 x 21 cm		46	n01200372	218,00
	7.5	Adapter for connection of TIG torches with Euro connector to Merkle TCG connector		46	109234	110,00

10.9. Advertising articles

	Pos.	Description	Pu	PrGrp	Part No.	Price/€
Advertising articles						
	1	Ball pen "Klick", blue/silver with blue MERKLE print		67	102510	0,61
	2	MERKLE Base cap dark blue with embroidered Merkle logo, white		67	125262	4,80
	3	High quality paper bag with new MERKLE design 30x10x40 + 6 cm		67	119946	1,89
	4	Swiss pocket-knife, 8,5 cm with bottle opener, screwdriver, pincers blue with white MERKLE print		67	102514	7,00
	5	Foot-rule 1 m with MERKLE logo		67	102516	2,20
	6	Cup, white ceramics green with MERKLE logo		67	106784	3,50
	7	College block with 50 pages in MERKLE design		67	137980	1,75
	8	Mousepad in MERKLE design		67	118086	1,40
	9	Desk pad à 25 sheets with new MERKLE design and welding positions		67	118088	4,75
	10	Towel Merkle big 80 x 150 including bordure with company logo		67	126906	12,45
	11	USB stick, 16 GB check card size		67	160730	4,00
	12	Note dispenser for approx. 500 sheets coated metal, green		77	156940	7,00
	13	MERKLE flag, 3 m x 1.20 m white with blue MERKLE print		67	106786	68,35
	14	Overall blue with MERKLE logo, sizes 48-54		67	106788	52,00
	15	Fabric tuck "MERKLE" logo 6 x 6 cm		67	106794	2,10
	16	Fabric tuck "MERKLE" name 24 x 4,5 cm		67	106796	2,63
	17	Stand for MobiARC and MobiTIG		67	117482	125,00

All prices per piece plus VAT and material surcharge.
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	Pos.	Description	Pu	PrGrp	Part No.	Price/€
	18	Roll-up banner design 1 (1 x 2 m) "HighPULSE and TEDAC torch"		67	148646	47,00
	19	Roll-up banner design 2 (1 x 2 m) "Automation"		67	148648	47,00
	20	Roll-up banner design 3 (1 x 2 m) "Technology made in Germany"		67	148650	47,00
	21	3-months desk diary (to be ordered in advance)		67	102517	1,86
	22	3-months wall calender (to be ordered in advance)		67	102518	1,79
	23	Agenda without name Imitation leather (to be ordered in advance)		67	102519	4,80
	24	Agenda with name, print in gold, real leather (ordered in advance)		67	102520	7,50

10.10. Leaflets and Catalogues

Pos.	Description	Pu	PrGrp	Part No.	Price/€
1	**Leaflets:**				
	Prospekt -DE- Programmübersicht		77	109608	
	Leaflet - Product Range		77	109610	
	Prospekt -DE- RedMIG Bauserie		77	109616	
	Leaflet - RedMIG		77	109644	
	Prospekt -DE- CompactMIG Bauserie		77	109646	
	Leaflet - CompactMIG		77	109648	
	Prospekt -DE- OptiMIG Bauserie		77	109650	
	Leaflet - OptiMIG		77	109652	
	Prospekt -DE- MobiMIG Bauserie		77	109654	
	Leaflet - MobiMIG		77	109656	
	Prospekt -DE- SpeedMIG touch Bauserie		77	157914	
	Leaflet - SpeedMIG touch		77	160190	
	Prospekt -DE- HighPULSE touch Bauserie		77	109678	
	Leaflet - HighPULSE touch		77	160152	
	Prospekt -DE- HighPULSE Bauserie		77	109658	
	Leaflet - HighPULSE		77	109660	
	Prospekt -DE- LiteTIG/MobiTIG Bauserie		77	156130	
	Leaflet - LiteTIG/MobiTIG		77	156132	
	Prospekt -DE- LiteTIG 190 AC/DC		77	160666	
	Leaflet - LiteTIG 190 AC/DC		77	160668	
	Prospekt -DE- LogiTIG Bauserie		77	142142	
	Leaflet - LogiTIG		77	142144	
	Prospekt -DE- Baureihen HighTIG, Insquare		77	109670	
	Leaflet - HighTIG and Insquare		77	109672	
	Prospekt -DE- LiteARC Bauserie		77	156114	
	Leaflet - LiteARC		77	156118	
	Prospekt -DE- MobiARC 284 cel		77	109674	
	Leaflet - MobiARC 284 cel		77	109676	
	Prospekt -DE- Plasma-Schneidanlagen		77	109682	
	Leaflet - Plasma Cutting Units		77	109684	
	Prospekt -DE- DeepARC		77	129710	
	Leaflet - DeepARC		77	129712	
	Prospekt -DE- ColdMIG		77	129718	
	Leaflet - ColdMIG		77	129720	
	Prospekt -DE- HighUP		77	132822	
	Leaflet - HighUP		77	132930	
	Prospekt -DE- Rauchabsaugbrenner		77	133930	
	Leaflet - Fume extraction torches		77	133931	
	Prospekt -DE- Automatisierung und Robotics		77	129706	
	Leaflet - Automation and Robotics		77	129708	
	Prospekt -DE- WeldROB		77	149368	
	Leaflet -GB- WeldROB		77	160160	
	Prospekt -DE- Schweißfahrwerk		77	160150	

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Pos.	Description	Pu	PrGrp	Part No.	Price/€
	Leaflet - Welding carriage		77	160162	
	Prospekt -DE- WCM		77	133804	
	Leaflet - WCM		77	133805	
	Prospekt -DE- Q.MACS		77	134648	
	Leaflet - Q.MACS		77	134650	
	Prospekt -DE- Kalibriergerät MCU 1000		77	142134	
	Prospekt -DE- DIN EN 1090		77	142136	
	Leaflet - Company Profile		77	133806	
	Prospekt -DE- Drehtische		77	156120	
	Leaflet - Welding positioner		77	156122	
	Leaflet - Welding units for shipbuilding		77	156124	
	Prospekt -DE- TEDAC Digital		77	156126	
	Leaflet - TEDAC digital		77	156128	
	Prospekt -DE- Kalibrieren/Validieren		77	156134	

2 Catalogues:

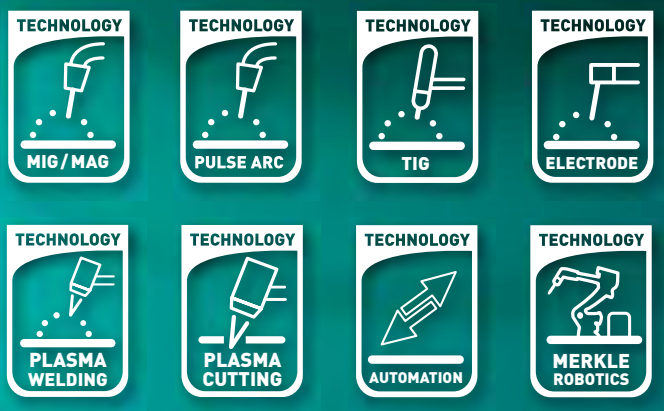
	General catalogue GERMAN		20	129728	
	General catalogue ENGLISH		20	129730	
	Automation catalogue GERMAN		20	129732	
	Automation catalogue ENGLISH		20	129734	

The current T/C for installation / customer service / sales and delivery can be found on our website

http://www.merkle.de/de/agb.html

MERKLE

- MIG/MAG Welding Units
- Synergic Pulse Welding Units
- TIG Welding Units
- MMA / Stick Electrode Welding Units
- Plasma Welding and Cutting Units
- Welding and Cutting Torches
- Turntables and Roller Drive Units
- Automation Components and Solutions
- Merkle Robotics



MADE IN GERMANY

www.merkle.de

Merkle Schweissanlagen-Technik GmbH | Industriestr. 3 | D-89359 Koetz | Germany
Tel.: +49 8221 915-0 | Fax: +49 8221 915-40 | E-mail: info@merkle.de | **www.merkle.de**