

Product Brochure For W197

MIG/TIG/STICK WELDER - MIG 250K

#KTRPM250KT

20-250 Amps Welding Current Range



ORDER CODE:	W197
MODEL:	PULSE 250K
Type:	MIG / TIG / STICK & Multifunction Welder
Part Number:	KTRPM250KT
Voltage (V):	240
Recommended Plug Amperage (amp):	32
Welding Current Range - MIG (amp):	20 - 250
Welding Current Range - STICK (amp):	20 - 220
Welding Current Range - TIG (amp):	10 - 250
Duty Cycle (% @ amp):	40 @ 250
Wire Spool Size (kg):	5 & 15
Ferrous Wire Size - Range (mm):	0.6 - 1.2
Stainless Steel Wire Size - Range (mm):	0.8 - 1.2
Aluminium Wire Size - Range (mm):	1.0 - 1.2
MMA Rod Size (mm):	~
Wire Feeding Speed (m/min):	~
Recommended Generator (KVA):	~
Dimensions (mm):	340 x 400 x 620
Nett Weight (kg):	24



Description

High Productivity Welding Solution
 MIG -TIG - MMA - 250 Amp DC Welder
 Synergic / Pulse / Double Pulse

The MULTI-250K is the most powerful multifunction Single Phase System that state of the art technology can offer. An industrial machine with multiple welding functions including Pulse Mig, Double Pulse Mig, High Speed Mig, DC Tig, and DC MMA (Stick). User friendly programs with synergic function are provided for all the welding processes making it suitable for even the inexperienced user. The Multi-250K encompasses all facets of the new PLUS CONCEPT technological development.

PLUS CONCEPT is an innovative solution that is revolutionising the welding industry. Now, high efficiency welding is possible with Gas Metal Arc Welding, Pulse Arc and standard applications. The forced dynamism of the PLUS CONCEPT achieves an ultra fast transfer droplet rate into the weld pool giving surprising results: it increase significantly the welding speed (up to 45%) and, at the same time, it increases the penetration of the weld. Higher speed, better penetration and less spatter means less energy used during the deposit and reduced deformation during the welding. Using the Double Pulse function provides the ability to produce welds with TIG like finish with excellent control over the weld pool. The Multi-250K is a professional industrial machine that is lightweight and has available an optional trolley with gas bottle support, being 230v single phase gives great portability, it can be run from any 15 Amp power socket providing more flexible use for site and home workshop locations. Ideal for general engineers, boat building, sheet metal workshops, stainless steel fabricators, panel beaters, transport engineering and home workshops, Designed and built to meet with European norms conformity.

The Ergonomic and Auto Learning System is used in the powerful front panel interface where welding mode selection, program selection, adjustments and special settings coexist in a rugged panel, whereby a simple touch the user can instantly see the results they have selected.

Plus Concept Benefits:

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Full Deeper Penetration:

Full penetration and greater depth of penetration in thicker materials can be obtained with the new PLUS CONCEPT programs. The increase in the arc transfer speed allows the welding of materials up to 15mm in one pass, with only a narrow gap, eliminating costly weld preps. This new process maintains the arc stability and allows long stick-out to enable the welding to be completed in a single pass. With this solution, due to the increased welding speed, a lot of time is saved and the energy required for the same weld is much less. Faster welding and energy reductions mean greater reduction of the distortion of the work-piece. Using PLUS CONCEPT in the application of heavy industry greatly improves the quality and notably reduces production costs.

High Speed Pulse Mig Application:

Product Brochure For W197

PLUS CONCEPT has available Pulse programs for most materials with better weld control and a smoother arc. Special waveforms and very fast dynamics increase the weld ability of all materials. A precision arc, smoother waveform and high frequency transfer allow a precise arc with lower pressure in the welding pool. As a result, the welding speed is increased up to 45% with the same arc energy as found in standard machines. The simplicity of the pulse control setting allows a fast approach to any welding, irrespective of the thickness and this results in a colder weld with exceptional appearance. Up to now, in certain applications where the pulse mig process would not be recommended, because of the higher heat in the join (compared to conventional welding), but now it is possible to improve quality and efficiency with the use of the new PLUS CONCEPT. Arc noise emissions are reduced with the smooth waveform in Pulse Mig too. It allows higher current applications without the typical loud noise of the arc.

Double Pulse Program:

The DOUBLE PULSE program can be easily selected. A simple click in the front panel will switch from a standard pulse application to the advanced and fast double pulse without any other settings required from the operator. The frequency of the DOUBLE PULSE is easily adjusted from 0.5 to 4.0 pulses per second. DOUBLE PULSE offers more control over the weld pool improving out of position welding, better controls distortion and gives excellent wash and even leg length on fillet welds, an added bonus is the improved cosmetic appearance of the weld likened to a TIG finished weld.

Mig Brazing:

Programs for brazing are easy to use and covers special applications for the car industry and any welding with zinc steel.

Multi Function:

PLUS CONCEPT is not only an innovative fast Pulse and fast MIG-MAG machine but MMA and TIG mode are also available. The MMA and TIG function are top level technology and offer professional results for expert users. MMA and TIG mode has both manual and synergic adjustment, when the Synergic mode is selected, the user selects the welding process, which enables self regulation of the welding parameters by simply selecting the work-piece thickness. Special Lift arc start is used for tig arc ignition which makes the use of high frequency negligible. Remote control receptacle is available for connection of remote amperage controls.

Features

- New "Plus Concept" Technology
- Latest European IGBT Inverter Technology
- High Speed Synergic Pulse Mig
- Synergic Mig Double Pulse
- High Speed Mig/Mag
- DC Tig with Manual and Synergic Programs
- MMA with Manual and Synergic Programs
- VRD Safety (Voltage Reduction Device)
- 2/4T Trigger Functions
- Up Slope - Down Slope
- Variable Start Current and Crater Current
- Simple selection of welding programs
- Simple interface for easy operation
- Accepts wide voltage supply variations (170-270V)

Includes

- SB36 3M Digital Ergo MIG torch with Euro connection
- 4M ARC Welding lead set with 35/50 Dinse style connections
- UNI-FLAME Twin Gauge Argon Regulator
- Gas Hose with Fittings
- Push Pull Torch Ready
- Includes trolley with gas bottle support

Optional Accessories

- Optional TIG Torch SR26-4MCP50 TIG Torch with 35/50 Dinse style connections
- Optional Push Pull Torch 8 Metre PPL36-8M

Product Brochure For W197



WELDING WIRE DIAMETER CHART

MATERIAL THICKNESS	RECOMMENDED WIRE DIAMETERS						
	MIG SOLID WIRE				GASLESS FLUX CORED WIRE		
	0.6mm	0.8mm	0.9mm	1.0mm	0.8mm	0.9mm	1.2mm
24 Gauge (.60mm)							
22 Gauge (.75mm)							
20 Gauge (.90mm)							
18 Gauge (1.0mm)							
16 Gauge (1.2mm)							
14 Gauge (1.6mm)							
3.0mm							
5.0mm							
6.0mm							
8.0mm							
10.mm							
12.0mm							

For material thickness of 5.0mm and greater, multi-pass runs or a beveled joint design may be required depending on the amperage capability of your machine.

Product Brochure For W197

Recommended Accessories

W10362

Magnetic MIG Torch Rest



W10361

Magnetic TIG Torch Rest



W571

MIG Torch - 4 Metre



W119

Anti-Spatter Spray



O0184

Ar/O₂ - Argon 98% & Oxygen 2% Disposable Cylinder



O0185

CO₂/Ar - 86% Argon & 14% Carbon Dioxide Disposable Cylinder



O300

Gas Refillable Cylinder



O304

Gas Refillable Cylinder



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O3045
Gas Refillable Cylinder



O302
Gas Refillable Cylinder



O306
Gas Refillable Cylinder



O3065
Gas Refillable Cylinder



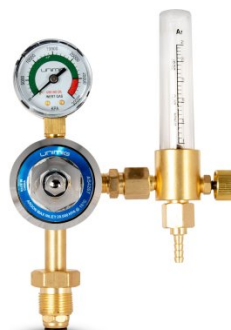
O0171
Argon Gas Regulator



W160A
Argon Gas Regulator-Twin Gauge



W161
Argon Gas Regulator-Bobbin Flowmeter



W001
Auto Darken Welding Helmet - 9~13 Shade



W002
Auto Darken Welding Helmet - 9~13 Shade



W1000A
Promax HV5 Welding Jacket



W1001A
Promax Blue FR Welding Jacket



W1002A
Professional Promax BL7 Welding Jacket



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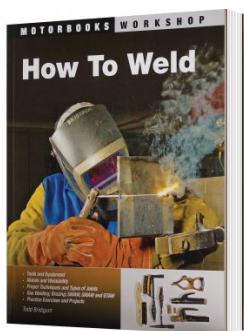
W100

ROGUE™ Heavy Duty Welding
Gloves - 400mm



L3456

How to Weld Book



W225

Welding Curtain



W135

Ø0.9mm Mild Steel MIG
Welding Wire



W136

Ø0.8mm Mild Steel MIG
Welding Wire



W138

Ø0.6mm Mild Steel MIG
Welding Wire



W138A

Ø0.6mm Mild Steel MIG
Welding Wire



W140

Ø0.8mm Mild Steel MIG
Welding Wire



W140A

Ø0.8mm Mild Steel MIG
Welding Wire



W142

Ø0.9mm Mild Steel MIG
Welding Wire



W143

Ø1.0mm Aluminium MIG
Welding Wire



W144

Ø1.2mm Aluminium MIG
Welding Wire



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W145

Ø0.9mm Gasless Mild Steel
 MIG Welding Wire



W145A

Ø0.9mm Gasless Mild Steel
 MIG Welding Wire



W125

Ø1.6mm TIG Filler Rod - Mild
 Steel



W126

Ø2.4mm TIG Filler Rod - Mild
 Steel



W127

Ø1.6mm TIG Filler Rod -
 Stainless Steel



W128

Ø2.4mm TIG Filler Rod -
 Stainless Steel



V099

90 degree Angle Vice Clamp



V100

90 degree Angle Vice Clamp



W546

10 x 0.6mm Contact Tips - Steel



W548

10 x 0.8mm Contact Tips - Steel



W549

10 x 0.9mm Contact Tips - Steel



W549A

10 x 0.9mm Contact Tips -
 Aluminium



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W550

10 x 1.0mm Contact Tips - Steel



W550A

10 x 1.0mm Contact Tips - Aluminium



W552

10 x 1.2mm Contact Tips - Steel



W552A

10 x 1.2mm Contact Tips - Aluminium



W539

0.6-0.8mm Blue Steel Liner



W538

1.0-1.2mm Red Steel Liner



W567

1.0-1.2mm Red Aluminium Liner



W564

2 x Conical Nozzles



W576

2 x Gas Diffusers



W568

Swan Neck Assembly

