

Product Brochure For W199

MIG/TIG/STICK WELDER - MIG 400K DUO SWF

#KTRPM400K

20-400 Amps Welding Current Range



ORDER CODE:	W199
MODEL:	PULSE 400K DUO (SWF)
Type:	MIG / TIG / STICK & Multifunction Welder
Part Number:	KTRPM400K
Voltage (V):	415
Recommended Plug Amperage (amp):	32
Welding Current Range - MIG (amp):	20 - 400
Welding Current Range - STICK (amp):	20 - 400
Welding Current Range - TIG (amp):	10 - 400
Duty Cycle (% @ amp):	60 @ 400
Wire Spool Size (kg):	5 & 15
Ferrous Wire Size - Range (mm):	0.8 - 1.6
Stainless Steel Wire Size - Range (mm):	0.8 - 1.6
Aluminium Wire Size - Range (mm):	1.0 - 1.6
MMA Rod Size (mm):	~
Wire Feeding Speed (m/min):	~
Recommended Generator (KVA):	~
Dimensions (mm):	340 x 400 x 620
Nett Weight (kg):	30



Description

High Productivity Welding Solution
 MIG -TIG - MMA - 400 Amp DC Welder - with SWF
 Synergic / Pulse / Double Pulse

The MULTI-400K is a complete and powerful multifunction DC inverter welding machine - 3 phase 400V. 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-400K 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 increases 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-400K is a professional industrial machine that is supplied complete with trolley with gas bottle support, also with Push Pull Torch interface connection. Ideal for boat building, heavy fabrication and general engineering, sheet metal workshops, stainless steel fabricators, transport engineering, panel beaters, repair and maintenance 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:

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.

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:

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

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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.

Separate Wire Feed Unit

A robust and industrial concept has been developed for outside use whilst maintaining complete flexibility and full operation. The machines can be developed according to the needs of the user. From a simple compact air cooled torch solution, to a machine complete with cooler unit, an external wire feeder can be connected for dual applications, the addition of a Push Pull Gun is simply done via our plug and play connection. Any extra accessory is auto recognised and then auto installed by the central process control and works in the correct mode without the input or knowledge of the operator. E.g. Water cooling unit starts and stops alone only when it is necessary. The central controls monitor any function of the equipment and accessories and alert the user, on the front panel, every time something needs checking. Connection of the optional separate wire feeder, provides dual independent wire feed operation from the machine. The digitally controlled wire feeder can feed any kind of wire with high efficiency. It is completely independent from the power source, a digital communication connects the wire feeder control to the power source and compensates the resistance of the interconnecting cable. An innovative communication system allows the use of interconnecting cables up to 50 meters without affecting the arc. All the welding parameters are easy to set via the front panel of the wire feeder eliminating the need to go to the power source.

The wire feeder is robust and developed also for on site welding and is constructed to be lightweight and portable. It can be used with undercarriage wheels for easy movement in the welding area or it can be located on a turning support fixed to the top of the machine. The dimensions are as small as possible, but for a special use where weight must be reduced an adaptor to accept smaller spools of wire is available. With this adaptor and a 5kg spool of wire installed the maximum weight is 13kg and this solution is the lightest for off shore, on site transportable requirement. The wire feeder is also ideal for stationary applications where the compact dimensions are important.

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

- Separate Wire Feed
- SB36-3M MIG Torch
- Argon Regulator
- 4M Earth Lead
- 4M Arc Lead
- Gas hose
- Gas Hose with Fittings

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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



W100
ROGUE™ Heavy Duty Welding Gloves - 400mm



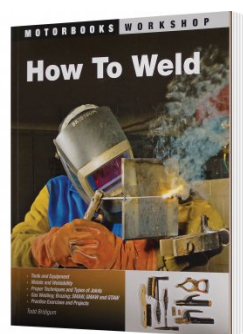
W001
Auto Darken Welding Helmet - 9-13 Shade



W002
Auto Darken Welding Helmet - 9-13 Shade



L3456
How to Weld Book



W225
Welding Curtain



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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



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



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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



W550

10 x 1.0mm Contact Tips - Steel



W550A

10 x 1.0mm Contact Tips - Aluminium



W552

10 x 1.2mm Contact Tips - Steel



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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

