

KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Others



DeviceNet

EtherNet/IP

CANopen



PROFIBUS

EtherCAT



KM600 W



KM500 W



TECHNICAL SPECIFICATIONS

Input Voltage
Mains Voltage Tolerance
Minimum Welding Current
Maximum Welding Current
MIG Duty Cycle, 40°C
TIG Duty Cycle, 40°C
MMA Duty Cycle, 40°C
Open – Circuit Voltage
Factory Delivered Roller
Weight
Standard Accessories

Dimensions (W, L, H)
Certification

400 V
- 10 % / + 15 %
10 A
600 A
600 A %40, 500 A 60%, 400 A %100
600 A %40, 500 A 60%, 400 A %100
600 A %40, 500 A 60%, 400 A %100
63 V - 82 V
1.2 + 1.6 mm / Steel
Liquid Cooled 100 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
532mm x 970mm x 1351mm
CE

400 V
- 10 % / + 15 %
10 A
500 A
500 A %40, 430 A %60, 360 A %100
500 A %40, 430 A %60, 360 A %100
500 A %40, 430 A %60, 360 A %100
63 V - 82 V
1.0 + 1.2 mm / Steel
Liquid Cooled 100 kg
3 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
532mm x 970mm x 1261mm
CE

KM350 CW



400 V
- 10 % / + 15 %
10 A
350 A
350 A %40, 300 A %60, 250 A %100
350 A %40, 300 A %60, 250 A %100
350 A %40, 300 A %60, 250 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 75 kg
4 m Power Cable (4 x 2.5 mm²)
3 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
532mm x 970mm x 949mm
CE

KM270 C

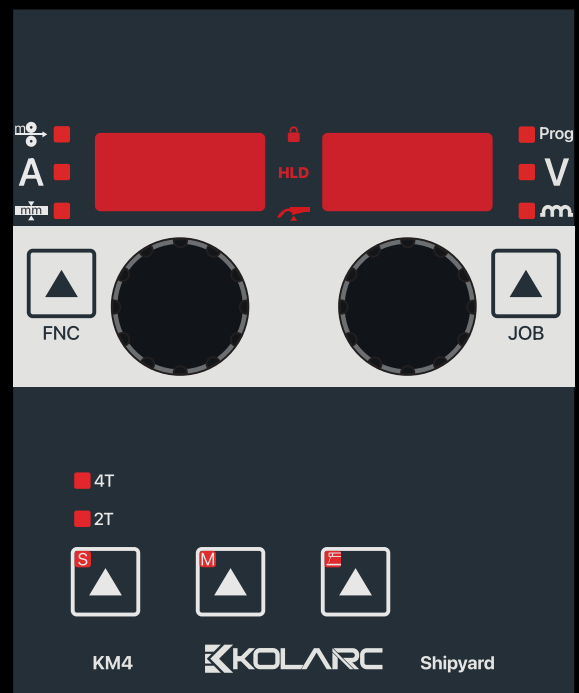
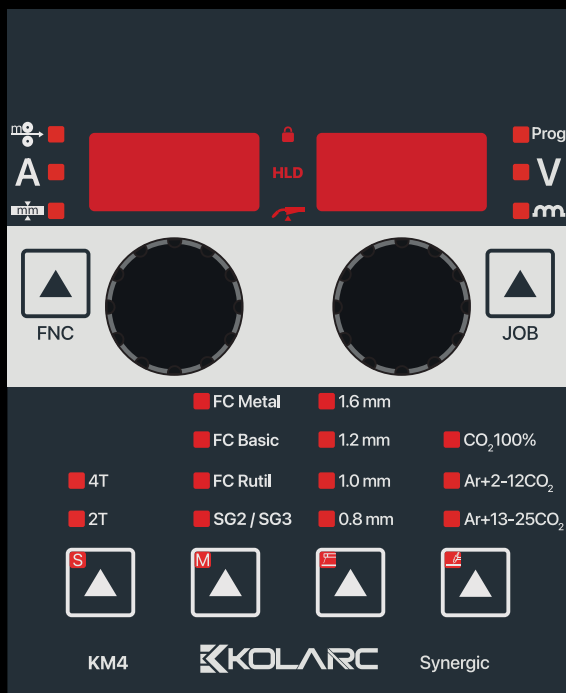
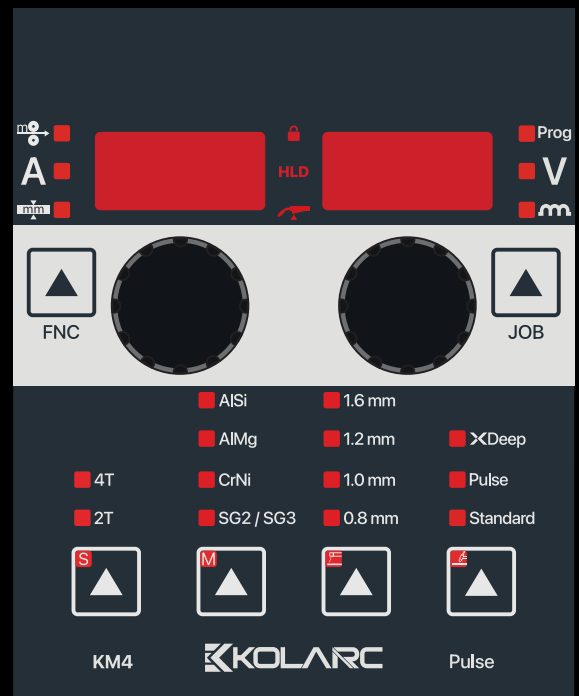
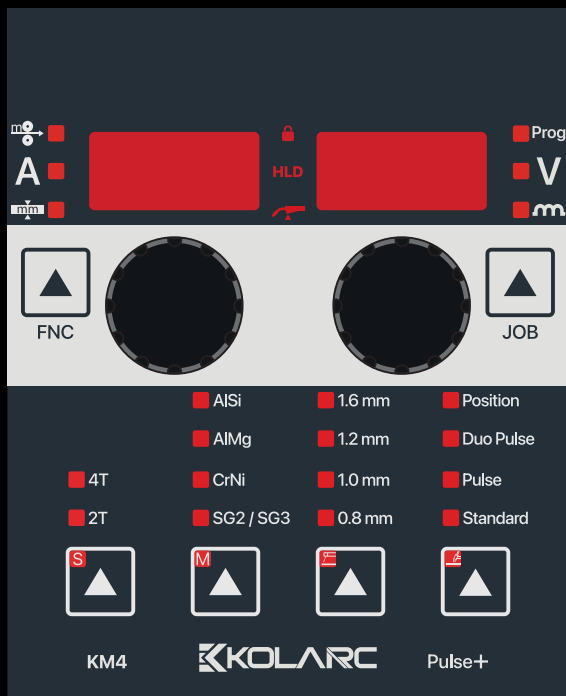


400 V
- 10 % / + 15 %
10 A
270 A
270 A %40, 230 A %60, 170 A %100
270 A %40, 230 A %60, 170 A %100
270 A %40, 230 A %60, 170 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled 25 kg
4 m Power Cable (4 x 2.5 mm²)
3 m Earth Clamp (35 mm²)
Gas Hose (1.5 m)
234mm x 483mm x 417mm
CE

KM220 C

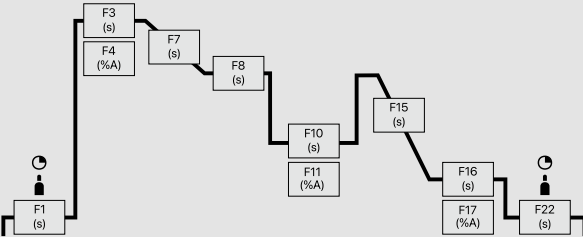


230 V
- 10 % / + 15 %
10 A
220 A
220 A %40, 180 A %60, 140 A %100
220 A %40, 180 A %60, 140 A %100
220 A %40, 180 A %60, 140 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled 25 kg
4 m Power Cable (4 x 1.5 mm²)
3 m Earth Clamp (25 mm²)
Gas Hose (1.5 m)
234mm x 483mm x 417mm
CE



Pulse+ / Pulse Job & Function List

Standard - Pulse			0.8	1.0	1.2	1.6	
SG2 / SG3		Ar+18%CO ₂	8	10	12	16	
		Ar+10%CO ₂	18	20	22	26	
		CO ₂ 100%	28	30	32	36	
CrNi	308 / 1.4316	Ar+2.5%CO ₂	58	60	62	66	
CuSi		Ar100%	178	180	182	186	
CuAl		Ar100%	188	190	192	196	
AlMg4,5 Mn		Ar100%	118	120	122	126	
AlSi		Ar100%	138	140	142	146	
Flux Cored Wire			0.8	1.0	1.2	1.6	
Steel / FluxCore Metal		Ar+18%CO ₂	238	240	242	246	
Steel / FluxCore Rutil		Ar+18%CO ₂	248	250	252	256	
		CO ₂ 100%			262	266	
Steel / FluxCore Basic		Ar+18%CO ₂			602		
Steel FluxCore High Str.		Ar+18%CO ₂			592		
Steel / FluxCore Rutil		Self Shielded		720	722		
XDeep - Pulse			0.8	1.0	1.2	1.6	
SG2 / SG3		Ar+18%CO ₂	298	300	302	306	
		Ar+10%CO ₂	308	310	312	316	
Application							
MIG/MAG Manual			4				
TIG (Lift Arc)			5				
MMA			6				
Gouging			7				

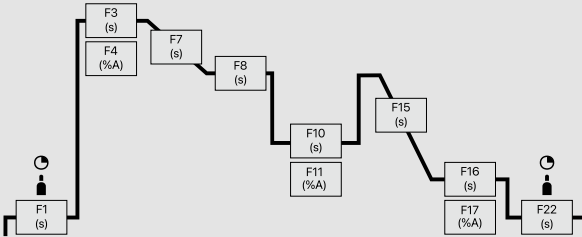


Function	Description	Min	Max
F1	Gas pre-flow (s)	0	10
F2	Start wire speed (m/min)	1	11
F3	Start time (s)	0	10
F4	Start current (%)	1	200
F5	Start arc correction(V)	-9.9	+9.9
F7	Start slope (s)	0	5
F8	Duo peak time (s)	0.05	10
F10	Duo base time (s)	0.05	10
F11	Duo base amper (%)	1	100
F12	Duo base arc correction (v)	-9.9	+9.9
F15	End down slope (s)	0.05	10
F16	End time (s)	0	10
F17	End current (%)	1	200
F18	End arc correction (V)	-9.9	+9.9
F20	End burn back (-)	10	200
F21	End wire cut mode (-)	0	2
F22	Gas post-flow (s)	0	10
F23	Smart trigger (-)	0	1
F24	Penetration stabilizer (m/min)	0	5

Function	Description	Min	Max
F25	Hot start time (s)	0	10
F26	Hot start current (%)	1	200
F27	Arc force (-)	-50	+50
F28	Antistick (s)	0	2
F29	VRD function (-)	0	1
F34	Tack/stitch mode (-)	0	2
F35	Cooling mode (-)	0	4
F36	Motor current (A)	0	-
F37	Motor current limit (A)	0.7	7
F38	Auto load default values (-)	0	1
F39	Motor control firmware (-)	-	-
F40	Power control firmware (-)	-	-
F41	Arc on time (h)	0	-
F42	Machine on time (h)	0	-
F45	Wire speed correction (m/min)	-2	+2
F49	Working mode	1	8
F50	RL cable calibration (mOhm)	0	30
F31	TIG V stop limit (V)	10	30
F32	TIG comfort stop sensitivity (V)	-2	+2

Synergic / Shipyard Job & Function List

Standard - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO ₂	8	10	12	16
	Ar+10%CO ₂	18	20	22	26
	CO ₂ 100%	28	30	32	36
Flux Cored Wire		0.8	1.0	1.2	1.6
Steel / FluxCore Metal	Ar+18%CO ₂	238	240	242	246
Steel / FluxCore Rutil	Ar+18%CO ₂	248	250	252	256
	CO ₂ 100%			262	266
Steel / FluxCore Basic	Ar+18%CO ₂			602	
Steel FluxCore High Str.	Ar+18%CO ₂			592	
Steel / FluxCore Rutil	Self Shielded		720	722	
XDeep - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO ₂	298	300	302	306
	Ar+10%CO ₂	308	310	312	316
Application					
MIG/MAG Manual		4			
TIG (Lift Arc)		5			
MMA		6			
Gouging		7			

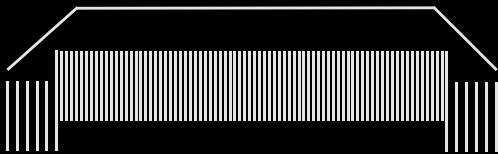


Function	Description	Min	Max
F1	Gas pre-flow (s)	0	10
F2	Start wire speed (m/min)	1	11
F3	Start time (s)	0	10
F4	Start current (%)	1	200
F5	Start arc correction(V)	-9.9	+9.9
F7	Start slope (s)	0	5
F8	Duo peak time (s)	0.05	10
F10	Duo base time (s)	0.05	10
F11	Duo base amper (%)	1	100
F12	Duo base arc correction (v)	-9.9	+9.9
F15	End down slope (s)	0.05	10
F16	End time (s)	0	10
F17	End current (%)	1	200
F18	End arc correction (V)	-9.9	+9.9
F20	End burn back (-)	10	200
F21	End wire cut mode (-)	0	2
F22	Gas post-flow (s)	0	10
F23	Smart trigger (-)	0	1
F24	Penetration stabilizer (m/min)	0	5

Function	Description	Min	Max
F25	Hot start time (s)	0	10
F26	Hot start current (%)	1	200
F27	Arc force (-)	-50	+50
F28	Antistick (s)	0	2
F29	VRD function (-)	0	1
F34	Tack/stitch mode (-)	0	2
F35	Cooling mode (-)	0	4
F36	Motor current (A)	0	-
F37	Motor current limit (A)	0.7	7
F38	Auto load default values (-)	0	1
F39	Motor control firmware (-)	-	-
F40	Power control firmware (-)	-	-
F41	Arc on time (h)	0	-
F42	Machine on time (h)	0	-
F45	Wire speed correction (m/min)	-2	+2
F49	Working mode	1	8
F50	RL cable calibration (mOhm)	0	30
F31	TIG V stop limit (V)	10	30
F32	TIG comfort stop sensitivity (V)	-2	+2

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Program Memory

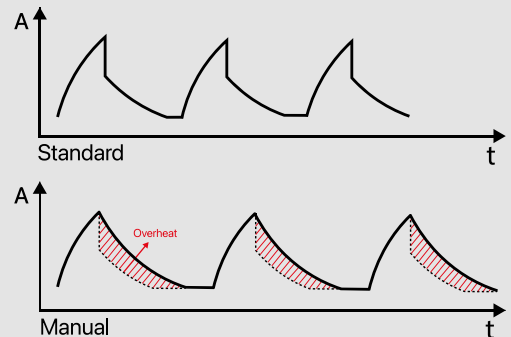


Pulse

Pulse eliminates post-weld cleaning and spatter in the welding of aluminum, stainless steel and all metal alloys, providing flawless welding performance.



XDeep operates in the spray arc area, using high-frequency, low-amplitude current pulses to provide high feed rate and low heat input for steel and stainless steel welding in the PA and PB positions, effectively reducing labor time and welding costs.



Synergic (Standard)

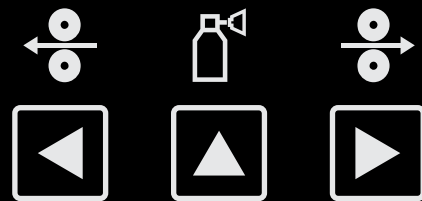
Synergic keeps the voltage constant after droplet transfer by rapidly reducing the welding current vertically to a certain reference level. This increases the welding speed, resulting in low heat input and an intensified arc.



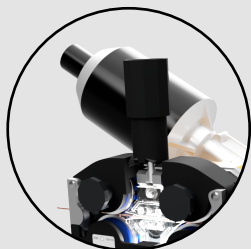
**Spool Cover
With Wire
View**



**4x4 Rollers
Wire Drive**



**Wire Push
Pull-Back
Gas Testing**



**25000
Times Per Second
Wire Speed Control**



**Hose Pack
Support**



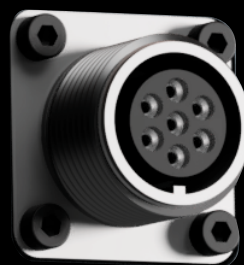
**Ergonomic
Robust
Modular
Design**



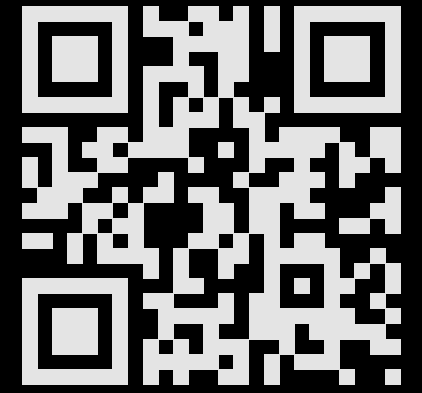
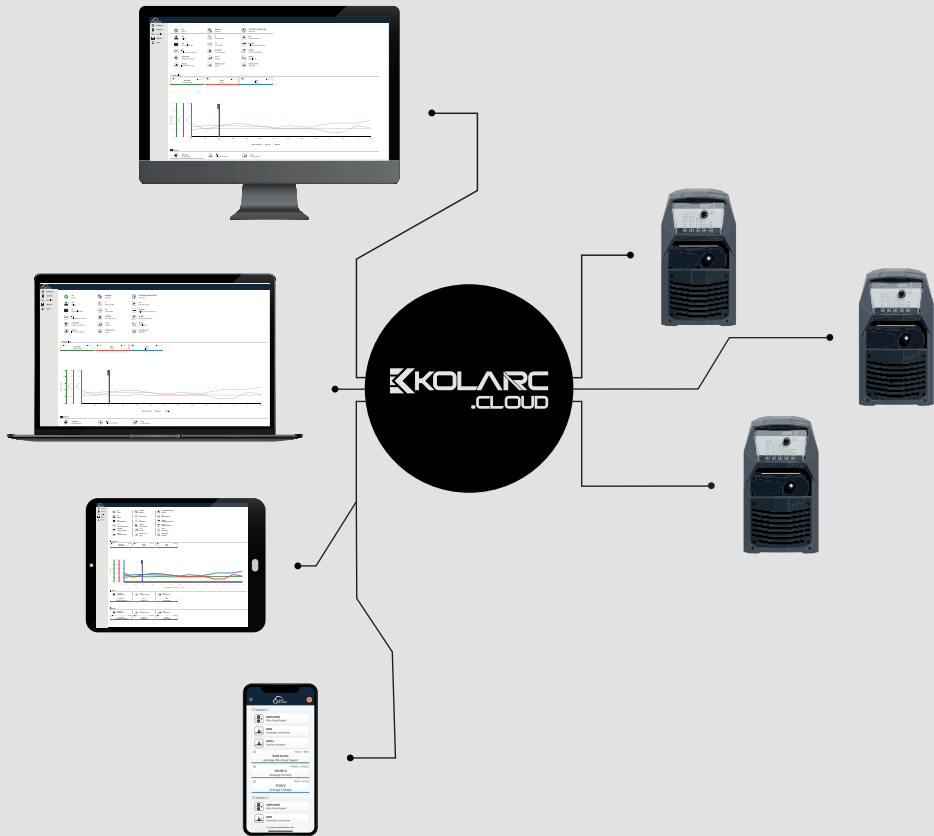
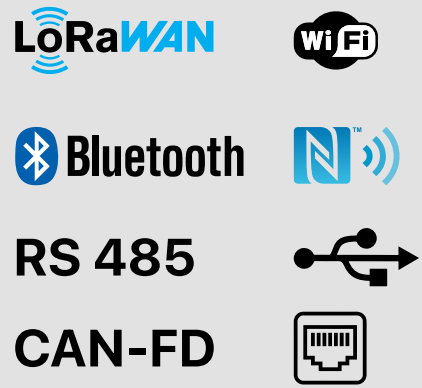
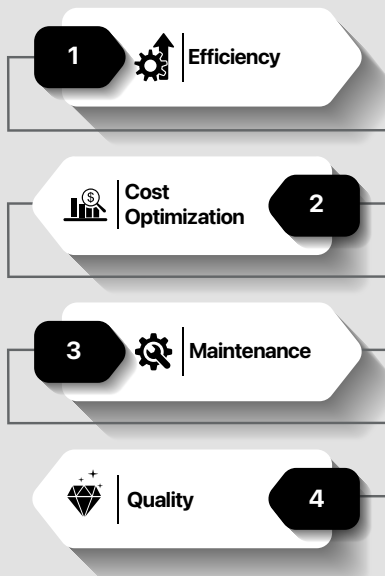
**Dual Liquid
Cooling System**



**Intelligent
Cooling**



**Military
Connector**



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