

KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Others



DeviceNet™

EtherNet/IP™

CANopen®



PROFI®
BUS

EtherCAT®



MX600 W Pulse



MX500 W Pulse



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 119 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
532 mm x 1040 mm x 1346 mm
CE

400 V
- 10 % / + 15 %
10 A
400 A
500 A %60, 400 A %100
500 A %60, 400 A %100
500 A %60, 400 A %100
63 V - 82 V
1.0 + 1.6 mm / Steel
Liquid Cooled 115 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
532 mm x 1040 mm x 1346 mm
CE

MX350 W

Pulse



400 V
- 10 % / + 15 %
10 A
320 A
350 A %60, 300 A %100
350 A %60, 300 A %100
350 A %60, 300 A %100
63 V - 82 V
1.0 + 1.2 mm / Steel
Liquid Cooled 77 kg
5 m Power Cable (4 x 4 mm²)
3 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
532 mm x 1040 mm x 1235 mm
CE

MX270 CW

Pulse



400 V
- 10 % / + 15 %
10 A
270 A
270 A %60, 210 A %100
270 A %60, 210 A %100
270 A %60, 210 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 67 kg
4 m Power Cable (4 x 2.5 mm²)
3 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
532 mm x 1040 mm x 964 mm
CE

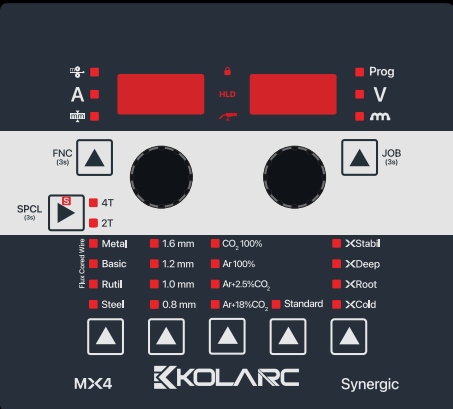
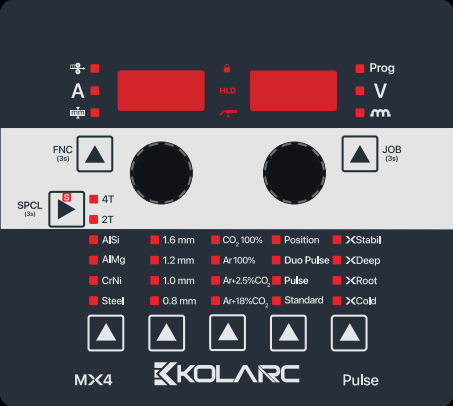
MX220 C

Pulse



230 V
- 10 % / + 15 %
10 A
150 A
150 A %25, 110 A %60, 90 A %100
220 A %25, 110 A %60, 90 A %100
170 A %25, 110 A %60, 90 A %100
58 V - 75 V
0.8 + 1.0 mm / Steel
Air Cooled 49.5 kg
4 m Power Cable (3 x 2.5 mm²)
3 m Earth Clamp (16 mm²)
Gas Hose (1.5 m)
267 mm x 664 mm x 443 mm
CE

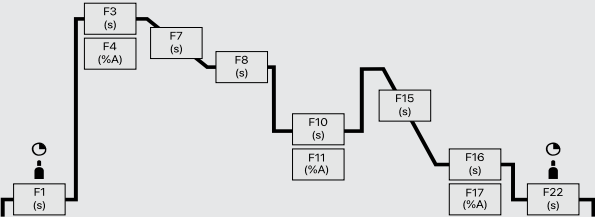
It's Manual Or Robotic.
Experience 406* welding programs



Intuitive User Interface

*Welding jobs for 1.6 Wires are just available for 500 and 600 models.

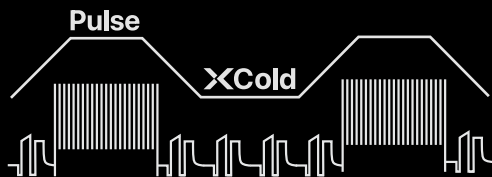
Synergic - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	8	10	12	16
	Ar+10%CO ₂	18	20	22	26
	CO ₂ 100%	28	30	32	36
CrNi - 316 / 1.4430	Ar+2.5%CO ₂	68	70	72	76
AlMg4,5 Mn	Ar100%	118	120	122	126
AlSi	Ar100%	138	140	142	146
Flux Cored Wire		0.8	1.0	1.2	1.6
Steel / FluxCore Metal	Ar+18%CO ₂	238	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 G3Si1 / G4Si1	Ar+18%CO ₂	298	300	302	306
	Ar+10%CO ₂	308	310	312	316
CrNi - 318 / 1.4576	Ar+2.5%CO ₂		620	622	626
XRoot - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO ₂		360	362	
XCold - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3	Ar+18%CO ₂	378	380	382	386
CrNi - 316 / 1.4430	Ar+2.5%CO ₂	698	700	702	
AlMg4,5 Mn	Ar100%		410	412	
AlSi	Ar100%		420	422	
Application					
MIG/MAG Manual			4		
TIG (Lift Arc)			5		
MMA			6		
Gouging			7		



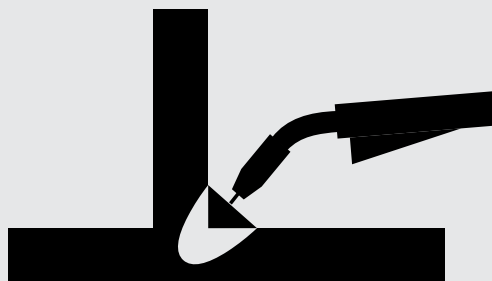
Function	Description	Min	Max
F1	Gas pre-flow (s)	0	10
F2	Start wire speed (m/min)	1	11
F3	Start time (s)	0	10
F4	Start current (%)	1	200
F5	Start arc correction(V)	-9.9	+9.9
F7	Start slope (s)	0	5
F8	Duo peak time (s)	0.05	10
F10	Duo base time (s)	0.05	10
F11	Duo base amper (s)	1	100
F12	Duo base arc 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/stich 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

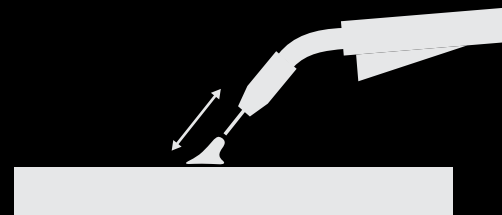
Function	Description	Min	Max
F31	TIG V stop limit (V)	10	30
F32	TIG comfort stop sensitivity (V)	-2	+2



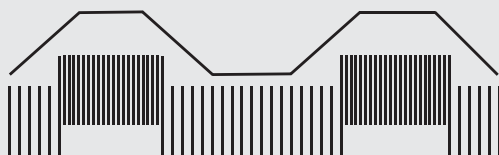
Position



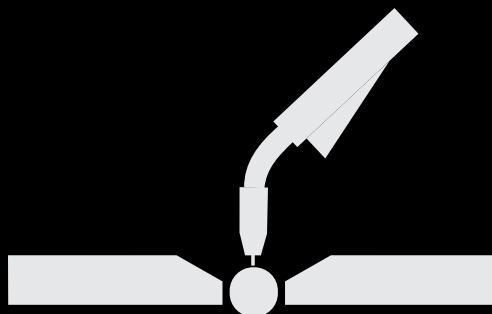
XCDeep



XCStabil



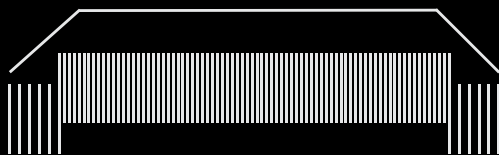
Duo Pulse



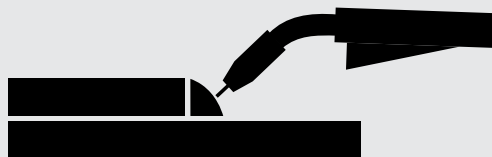
XCRoot



**4x4 Rollers
Wire Drive**



Pulse



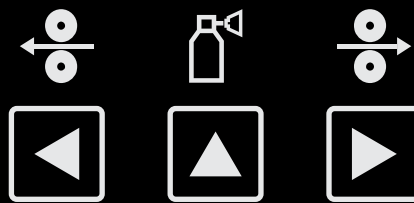
XC Cold



Torch



**25000
Times Per Second
Wire Speed Control**



**Wire Push
Pull-Back
Gas Testing**

RL

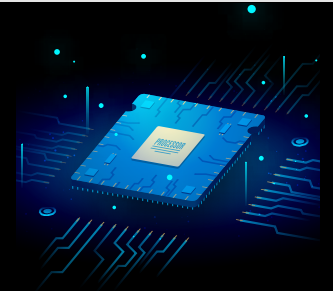
**Torch and Cable
Calibration**

99

**Program
Memory**



**Intelligent
Cooling**



**32 BIT
Microcontroller**



**Hose Pack
Support**



**Military
Connector**

**Ergonomic
Robust
Modular
Design**

Gun Holder

Compact Wire Feeder

Modular IP21 Design

Touch Sense Ignition

Perfect Start with Wire Cut Function

Wire Speed Correction

Wire Feeder Cabinet Lighting

Wire Feeder MMA Connection

Gas Saving System

Gas Filter

Liquid Filter

Extension Cable Rack

External Changable Couplings

Plug Double Setscrew

Socket Brass-Nut

Industrial Wheels

Optional Wire Feeder Wheels

