

# M SERIES



## Process table

MIG-MAG



standard for all models    standard for certain models    optionally available

## Operation concepts



### M-series Standard

- "3 steps to weld" operating concept
- with automatic setting control (synergic function)
- Switch 2-stroke/4-stroke/spot
- 2-roll wire feeder (M 222, M 242)
- 4-roll wire feeder (M304)
- 6-12 voltage levels (vary with each model)

# TECHNICAL DATA



M 222



M 242



M 304

	M 222	M 242	M 304
MIG-MAG			
- Welding range (in A)	25-210	30-230	30-290
- voltage setting	6 steps	7 steps	12 steps
Duty cycle			
- duty cycle 100% 40 °C (in Amps)	85	115	135
- duty cycle 60% 40 °C (in Amps)	135	155	175
- duty cycle at max. current 40 °C (in %)	15%	20%	20%
Feeder and wire			
- wire feed unit	2 rolls	2 rolls	4 rolls
- weldable wires steel (in mm)	0,6-1,0	0,6-1,0	0,6-1,2
- weldable wires aluminium (in mm)	1,0-1,2	1,0-1,2	1,0-1,2
Mains			
- mains voltage (in V)	230	400	400
- phases (50/60 Hz)	1~	3~	3~
- Mains voltage 2 (in V)	400	---	---
- phases (50/60 Hz)	2~	---	---
- positive mains tolerance (in %)	15%	15%	15%
- negative mains tolerance (in %)	15%	15%	15%
- mains fuse (in Amps)	16	16	16
- mains plug	Schuko/CEE 16	CEE 16	CEE 16
Dimensions and weights			
- dimensions (LxWxH) (in mm)	870x390x610	870x390x610	870x390x610
- weight (in kg)	55	57	67
Standards and approvals			
- standard	EN 60974-01	EN 60974-01	EN 60974-01
- protection class (EN 60529)	IP23S	IP23S	IP23S
- insulation class	F	F	F
- designation	CE, S	CE, S	CE, S

## Versions



### A-system with set

Drivable compact unit with integrated wire feed and all necessary accessories for MIG-MAG welding