



MMA DC IGBT Inverter 3 Phase S series


S 250 i
S 350 i
S 500 i

Main Applications

- Shipyards
- Metal tanks
- Steel fabricator
- Construction
- Sheet metal
- Medium to heavy industries
- Chemical and process industry
- Mechanical and electrical

Advantageous

- MMA / SMAW DC Inverter welding machine, feature exceptional ignition and welding properties
- Compact and robust design, user friendly panel design
- IGBT Inverter Technology for more durability
- Can weld cellulose electrode
- Adjustable hot start for easily starting welding current
- Adjustable arc force for easily control the arc
- Anti stick function to cut down the welding current to minimum when the electrode is stuck to the work-piece for safety
- Digital display for accurate welding amperage adjustment
- Selector switch for Tig welding with Lift Arc ignition
- Remote control device for S 350 i and S 500 i

MMA	S 250 i	S 350 i	S 500 i
Electrode range	1.6 - 6.0 mm	1.6 - 8.0 mm	1.6 - 10.0 mm
Material thickness	1 - 10 mm	1 - 16 mm	1 - 20 mm

TIG	S 250 i	S 350 i	S 500 i
Tungsten range	1.6 - 4.0 mm	1.6 - 4.0 mm	1.6 - 4.0 mm
Material thickness	1 - 5 mm	1 - 8 mm	1 - 10 mm

Specifications	S 250 i	S 350 i	S 500 i
Welding range	10 - 250 A	20 - 350 A	20 - 500 A
Load voltage	20.8 - 30 V	20.8 - 34 V	20.8 - 40 V
Open circuit voltage	81 V	81 V	81 V
Duty cycle at 80 % (40°C)	250 A	-	-
Duty cycle at 100 % (40°C)	224 A	350 A	500 A
Input power at 80 %	9.5 KVA	15 KVA	25 KVA
Input current at 80 %	14.5 A	23 A	38 A
Input phase	3 Phase	3 Phase	3 Phase
Main voltage, Tolerance	380 V, ± 15 %	380 V, ± 20 %	380 V, ± 20 %
Power factor	0.93	0.93	0.93
Index protection	IP 23	IP 23	IP 23
Insulation class	F	F	F
Cooling	F	F	F
Dimensions (L x W x H)	490 x 220 x 395 mm	600 x 360 x 580 mm	600 x 360 x 580 mm
Weight	20 Kg	31 kg	35 kg

Item Code	Item Name	MoQ
101.02.003.1	S 250 i - MMA DC IGBT Inverter	1 Set
101.02.004.1	S 350 i - MMA Package	1 Set
101.02.005.1	S 500 i - MMA Package	1 Set
	• Remote control RC-02	


Remote Control RC-02

Item Code	Item Name	MoQ	101.02.003.1	101.02.004.1	101.02.005.1
Standard Accessories					
101.02.003	MMA DC IGBT Inverter - S 250i	1 Unit	•		
101.02.004	MMA DC IGBT Inverter - S 350i	1 Unit		•	
101.02.005	MMA DC IGBT Inverter - S 500i	1 Unit			•
201.11.015	Plug to Ground Clamp 300 A, 50 mm2 at 3 m - S Series IGBT Inverter	1 Set	•		
201.11.016	Plug to Electrode Holder 400 A, 50 mm2 at 3 m - S Series IGBT Inverter	1 Set	•		
208.04.007	Plug to Ground Clamp 600 A, 50 mm2 at 5 m	1 Set		•	•
208.03.005	Plug to Electrode Holder 400 A, 50 mm2 at 5 m	1 Set		•	•

Optional Accessories for SMAW / MMA

208.03.002	Plug to Electrode Holder 600 A, 70 mm2 at 10 m	1 Set			•
208.03.003	Plug to Electrode Holder 600 A, 70 mm2 at 20 m	1 Set			•
208.03.006	Plug to Electrode Holder 400 A, 50 mm2 at 10 m	1 Set		•	
208.03.007	Plug to Electrode Holder 400 A, 50 mm2 at 20 m	1 Set		•	
208.03.009	Plug to Electrode Holder 400 A, 35 mm2 at 5 m	1 Set	•		
208.03.010	Plug to Electrode Holder 400 A, 35 mm2 at 10 m	1 Set	•		
208.04.005	Plug to Ground Clamp 600 A, 70 mm2 at 10 m	1 Set			•
208.04.006	Plug to Ground Clamp 600 A, 70 mm2 at 15 m	1 Set			•
208.04.008	Plug to Ground Clamp 600 A, 50 mm2 at 10 m	1 Set		•	
208.04.009	Plug to Ground Clamp 200 A, 35 mm2 at 5 m	1 Set	•		

Optional Accessories for GTAW / TIG

208.17.006	Tig Torch - WP 17 V-25-2 at 8 m	1 Set	•	•	•
208.17.007	Tig Torch - WP 26 V-25-2 at 8 m	1 Set	•	•	•
201.23.001	Argon Gas Regulator	1 Pcs	•	•	•
203.01.005	Plug - Trak-SK 35 mm	2 Pcs	•	•	•

General Accessories

208.18.001	Torch Holder - TIG	1 Pcs	•	•	•
201.22.009	Welding Helmet - Solarmatic Blue	1 Pcs	•	•	•
201.22.010	Welding Helmet - Solarmatic Red	1 Pcs	•	•	•
201.22.011	Welding Helmet - Solarmatic Green	1 Pcs	•	•	•



Material	Thickness mm	Tungsten Ø mm	Welding Current A	Alumina Ceramic Nozzle
Steel / Stainless Steel	1.0	1.6	10 - 60	4
	1.5	1.6	40 - 80	5
	2.0	1.6	70 - 120	5
	3.0	1.6 - 2.4	90 - 150	6
	4.0	2.4	140 - 180	7
Copper	1.0	1.6	60 - 80	4
	1.5	1.6	100 - 150	5
	3.0	2.4	150 - 180	6