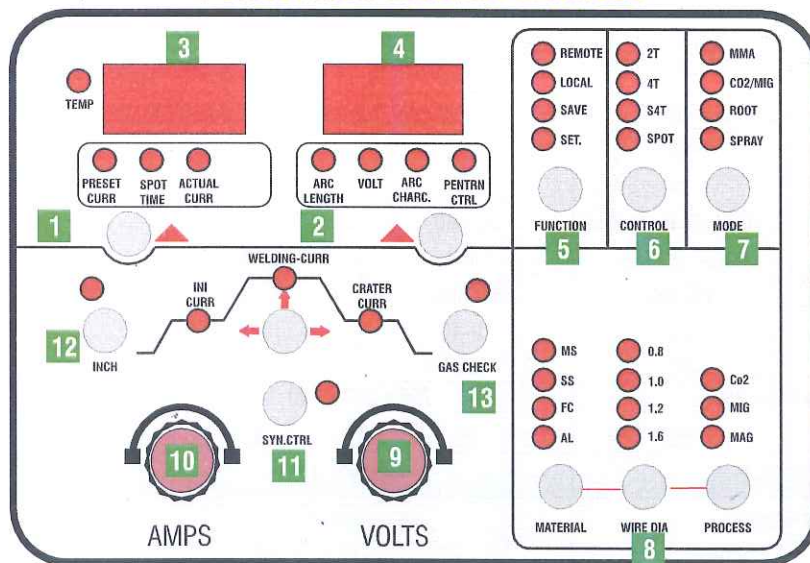


**DIGIMIG** Digital series products are semi-automatic gas shielded metal arc- welding machines with IGBT full bridge inverter technology. The machine has the characteristics of stable welding process low spatter and good weld. The digital control enables the easy control of molten pool. Easy to operate. Suitable for all position welding of mild steel, stainless steel, carbon steel, aluminum & its alloys etc, for both solid wire and flux-cored welding wire with the diameter of  $\Phi 0.8 / \Phi 1.2 / \Phi 1.6$  &  $\Phi 2.0$ .

### Perfect Man-Machine Interface



1. Preset Current/ Actual Current / Spot Time
2. Arc Length / Voltage/ Arc Characteristic/ Penetration Control
3. Display of Current & Time
4. Display of Voltage & Arc Characteristic
5. Remote/ local / Save/ Recall
6. 2T/ 4T/ S4T/ SPOT
7. MMA/ MIG/ ROOT/ SPRAY

8. Selection of wire size, material & Gas
9. Adjustment of parameters as per Point 2.
10. Adjustment of parameters as per Point 1.
11. Synergic On / Off
12. Inch
13. Gas Check

### Features:

- Root Weld Mode: For low amperage welding, for root welding, thin sheet welding.
- Spray Arc Mode: For Welding of Thick plates with higher speed & better Deposition rate.
- Burn back adjustment with digital control.
- Parameter limiting feature to limit the max. parameter of current & voltage.
- Job Save & Recall Facility.
- Constant penetration feature allows the current to be stable during variation of arc length.

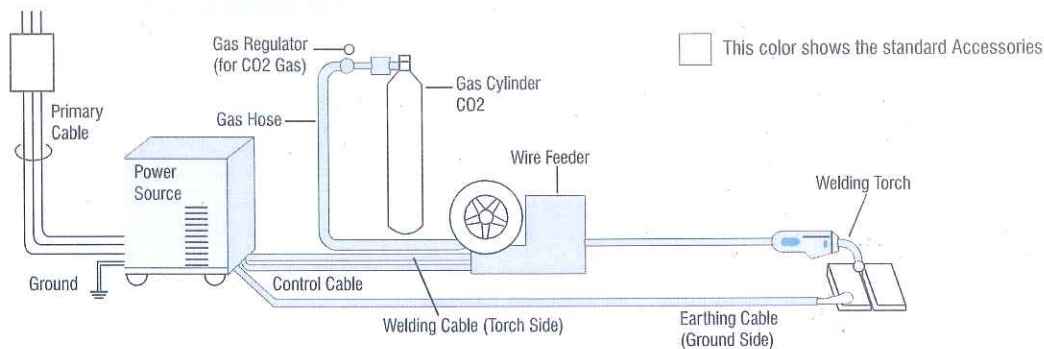
### Functions:

- Synergic operation makes it simple to operate.
- 2/4 step welding mode selection facility.
- Preflow & Postflow adjustment.
- Multi Process Selection: MIG/ MAG/ MMA / TIG\*/CAC.
- Digital Arc Characteristics control to set metal transfer characteristics for different metals.
- Protective functions : over-temperature, over current, under / over voltage, single phasing, Over Temperature, Short Circuit.

| INPUT |       | OUTPUT |      |
|-------|-------|--------|------|
| 3     | 50/60 | CV     | DC   |
| PHASE | Hz    | CC     | .... |

*Excellent Welding for Higher Performance...*

## CONNECTION DIAGRAM



### TECHNICAL SPECIFICATIONS of DIGI MIG DIGITAL Series

| PARAMETERS                                                             | DIGI MIG-300               | DIGI MIG -400                  | DIGI MIG-500            | DIGI MIG-600               |
|------------------------------------------------------------------------|----------------------------|--------------------------------|-------------------------|----------------------------|
| Rated input supply                                                     | 3Ph., 415VAC ±15%, 50/60Hz |                                |                         |                            |
| Power factor                                                           | 0.99                       |                                |                         |                            |
| Protection                                                             | IP 23                      |                                |                         |                            |
| Insulation class                                                       | H                          |                                |                         |                            |
| Rated input current (A)                                                | 14.5                       | 23.5                           | 34                      | 38                         |
| Rated MCB Capacity (A)                                                 | 32                         | 40                             | 63                      | 63                         |
| Rated input capacity (KVA)                                             | 10.5                       | 16                             | 23                      | 30                         |
| No load voltage (VDC)                                                  | 74                         | 74                             | 80                      | 80                         |
| Output current range (A)                                               | 30-300                     | 20-400 / 40-400 <sup>(1)</sup> | 20-500                  | 20-600                     |
| Output voltage range (V)                                               | 10-30                      | 10-34 /21-36 <sup>(1)</sup>    | 10-39                   | 10-44                      |
| Crater current range (V)                                               | 20-300                     | 20-400                         | 20-500                  | 20-600                     |
| Crater voltage range                                                   | 10-30                      | 10-34                          | 10-40                   | 10-44                      |
| Rated Duty cycle (%)                                                   | 60                         | 60                             | 60                      | 60                         |
| Dimension (LxWxH) (mm)                                                 | 750 x 350 x 800            |                                | 750 x 350 x 900         |                            |
| Weight (approx) (kg)                                                   | 34                         | 36                             | 85                      | 85                         |
| <b>Wire Feeder</b>                                                     | <b>SK-INV-2</b>            |                                | <b>SK-INV-4</b>         |                            |
| Dimension (approx.) (mm)                                               | 480x190x330                |                                | 480x190x330             |                            |
| Applicable spool size                                                  | 300mm dia 15 kg (max)      |                                | 300mm dia 15 kg (max)   |                            |
| Drive roll                                                             | 2 roll                     |                                | 4 roll                  |                            |
| Input supply (VDC)                                                     | 24                         |                                | 24                      |                            |
| Wire size (mm)                                                         | 0.8, 1.0, 1.2              |                                | 0.8, 1.0, 1.2, 1.6, 2.0 |                            |
| Feed Rate (mtr/min)                                                    | 0-25                       |                                | 0-25                    |                            |
| <b>Welding Torch</b>                                                   | <b>24KD</b>                | <b>WT 3510</b>                 | <b>60 KD</b>            |                            |
| Max. current capacity (A)                                              | 250                        | 350                            | 500                     |                            |
| Duty cycle (%)                                                         | 60%(Ar)/30% (MAG)          | 60%(Ar)/30% (MAG)              | 60%                     |                            |
| Weight (kg)                                                            | 2.2                        | 2.7                            | 3.54                    |                            |
| Cooling type                                                           | Gas Cooled                 | Gas Cooled                     | Gas Cooled              |                            |
| Length (mtr)                                                           | 3                          | 3                              | 3                       |                            |
| Wire size (mm)                                                         | (0.8, 1.0)                 | (0.8, 1.2)                     | (1.2, 1.6, 2.0)         |                            |
| <b>Standard scope of supply</b>                                        |                            |                                |                         | <b>OPTIONAL ACCESORIES</b> |
| Power Source                                                           | 1 No.                      |                                |                         | <b>Water Cooling Unit</b>  |
| Inter-Connection Cable ( Welding Cable - 3 Mtr, Earthing Cable- 3 Mtr) | 1 No.                      |                                |                         |                            |
| Wire Feeder                                                            | 1 No.                      |                                |                         |                            |
| Welding Torch                                                          | 1 No.                      |                                |                         |                            |
| Gas flow meter/regulator, Gas Pre heater                               | 1 No.                      |                                |                         |                            |

CAT: MO/CAT/DIGIMIG/01  
ISSUED ON : MAY19



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(In view of continuous development, we reserve the right to modify the design and / or dimensions without notice)



ISO 9001 : 2008