

KOLARC

BUILDING THE FUTURE



Robotic Interface
Digital and IO available
for all XM Series



XM600 W



TECHNICAL SPECIFICATIONS

Input Voltage	400 V
Mains Voltage Tolerance	- 10 % / + 15 %
Minimum Welding Current	5 A
Maximum Welding Current	600 A
MIG Duty Cycle, 40°C	600 A %60, 500 A %100
TIG Duty Cycle, 40°C	600 A %60, 500 A %100
MMA Duty Cycle, 40°C	600 A %60, 500 A %100
Open – Circuit Voltage	60 V
Factory Delivered Roller	1.0 + 1.2 mm / Steel
Weight	Water Cooled 111 kg
Standard Accessories	5 m Power Cable (4 x 6 mm ²) 3 m Earth Clamp (95 mm ²) Interconnection H.P (5 m) 4m 500 A Torch Remote Controlled
Dimensions (W, L, H)	532mm x 974mm x 1270mm
Certification	CE

XM500 W



Input Voltage	400 V
Mains Voltage Tolerance	- 10 % / + 15 %
Minimum Welding Current	5 A
Maximum Welding Current	500 A
MIG Duty Cycle, 40°C	500 A %60, 400 A %100
TIG Duty Cycle, 40°C	500 A %60, 400 A %100
MMA Duty Cycle, 40°C	500 A %60, 400 A %100
Open – Circuit Voltage	60 V
Factory Delivered Roller	1.0 + 1.2 mm / Steel
Weight	Water Cooled 107 kg
Standard Accessories	5 m Power Cable (4 x 6 mm ²) 3 m Earth Clamp (70 mm ²) Interconnection H.P (5 m) 4m 500 A Torch Remote Controlled
Dimensions (W, L, H)	532mm x 974mm x 1270mm
Certification	CE

XM350 W



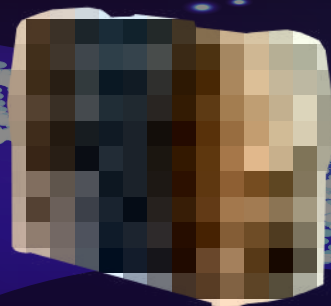
400 V
- 10 % / + 15 %
5 A
350 A
350 A %60, 300 A %100
350 A %60, 300 A %100
350 A %60, 300 A %100
60 V
1.0 + 1.2 mm / Steel
Water Cooled 77 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
4m 500 A Torch Remote Controlled
532mm x 974mm x 1178mm
CE

XM270 CW



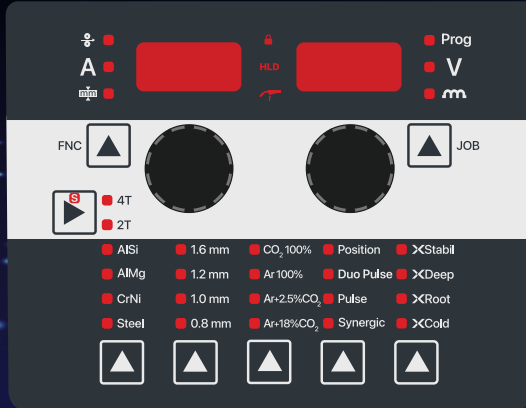
400 V
- 10 % / + 15 %
5 A
325 A
270 A %60, 210 A %100
270 A %60, 210 A %100
270 A %60, 210 A %100
60 V
0.8 + 1.0 mm / Steel
Water Cooled 71 kg
4 m Power Cable (4 x 2.5 mm²)
3 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
4m 320 A Torch Remote Controlled
532mm x 974mm x 624mm
CE

XM220 C

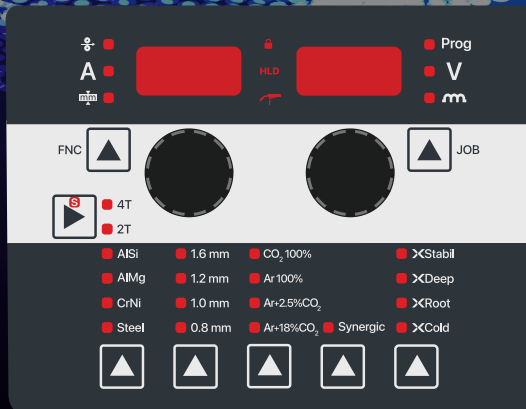


230 V
- 10 % / + 15 %
5 A
150 A
150 A %25, 110 A %60, 90 A %100
220 A %25, 110 A %60, 90 A %100
170 A %25, 110 A %60, 90 A %100
60 V
0.8 + 1.0 mm / Steel
Air Cooled 28 kg
3 m Power Cable (3 x 2.5 mm²)
3 m Earth Clamp (16 mm²)
Gas Hose (1.5 m)
4m 250 A Torch Remote Controlled
200mm x 658mm x 400mm
CE

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



Pulse



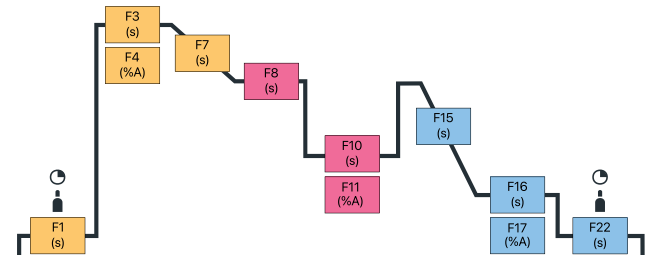
Synergic

Intuitive User Interface

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

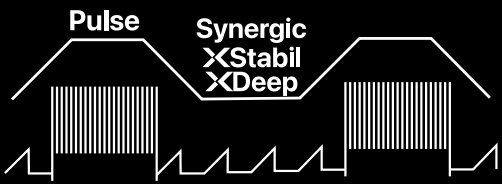
Synergic - Pulse		0.8	1.0	1.2	1.6	
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	8	10	12	16	
	Ar+10%CO ₂	18	20	22	26	
	CO ₂ 100%	28	30	32	36	
CrNi	318 / 1.4576	38	40	42	46	
	316 / 1.4430	68	70	72	76	
	310 / 1.4842				520 522	
	309 / 1.4332	Ar+2.5%CO ₂	538	540	542	546
	308 / 1.4316		58	60	62	66
	307 / 1.4370		48	50	52	56
	Duplex 2209 1.4462		78	80	82	86
		Ar+20%He+2%CO ₂	88	90	92	96
	CuSi	Ar100%	178	180	182	186
		Ar+2.5%CO ₂	558	560	562	566
CuAl	Ar100%	188	190	192	196	
CuSi Brazing	Ar100%	198	200	202	206	
	Ar+2.5%CO ₂	208	210	212	216	
CuAl Brazing	Ar100%	218	220	222	226	
	Ar+2.5%CO ₂	228	230	232	236	
AlMg4,5 Mn	Ar100%	118	120	122	126	
	Ar+30%He	128	130	132	136	
AlMg3	Ar100%	530	532	536		
AlSi	Ar100%	138	140	142	146	
	Ar+30%He	148	150	152	156	
	Ar100%	158	160	162	166	
Al99	Ar+30%He	168	170	172	176	
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		620	622	626	
	316 / 1.4430		640	642	646	
	310 / 1.4842				660 662	
	309 / 1.4332	Ar+2.5%CO ₂	670	672	676	
	308 / 1.4316		320	322	326	
	307 / 1.4370				632 636	
	Duplex 2209 1.4462		650	652	656	
	AlMg4,5 Mn	Ar100%		332	336	
	AlSi	Ar100%		342	346	
	Al99	Ar100%		352	356	
CrNi / FluxCore Metal	Ar+18%CO ₂	608	610	612	616	
XRoot - Pulse		0.8	1.0	1.2	1.6	
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂		360	362		
	CO ₂ 100%		370	372		
	Ar+10%CO ₂		500	502		

XCold - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	378	380	382	386
	CO ₂ 100%	388	390	392	
	Ar+10%CO ₂		510	512	
CrNi	318 / 1.4576		678	680	682
	316 / 1.4430		698	700	702
	308 / 1.4316	Ar+2.5%CO ₂	398	400	402
	307 / 1.4370		688	690	692
	Duplex 2209 1.4462		708	710	712
	AlMg4,5 Mn	Ar100%		410	412
	AlSi	Ar100%		420	422
	Al99	Ar100%		430	432
	CuSi Brazing	Ar100%	438	440	442
	CuAl Brazing	Ar100%	448	450	452
AlSi Brazing	Ar100%		460	462	
ZnAl Brazing	Ar100%		470	472	
ZnAl (St to Al Welding)	Ar100%		490	492	
Mg / Mg	Ar+30%He		572	576	
Cladding		0.8	1.0	1.2	1.6
NiCr-6625 / 2.4831	Ar+30%He	100	102	106	
	Ar+20%He+2%CO ₂	110	112	116	
NiCr-6617 / 2.4627	Ar+30%He		552	556	
CrNi / 309-2312 / 1.4332	Ar+2.5%CO ₂		542	546	
Co - Based	Ar100%		532	536	
XStabil		0.8	1.0	1.2	1.6
SG2 / SG3 - G3Si1 / G4Si1	Ar+18%CO ₂		730	732	
CrNi - 316 / 1.4430	Ar+2.5%CO ₂		750		
CrNi - 308 / 1.4316	Ar+2.5%CO ₂		740	742	
Flux Cored Wire		0.8	1.0	1.2	1.6
Steel / FluxCore Metal	Ar+18%CO ₂	238	240	242	246
	Ar+18%CO ₂	248	250	252	256
	CO ₂ 100%		262	266	
Steel / FluxCore Basic	Ar+18%CO ₂		602		
CrNi / FluxCore Metal	Ar+2.5%CO ₂		272	276	
CrNi / FluxCore Rutil	Ar+18%CO ₂		282	286	
CrNi / FluxCore Rutil	CO ₂ 100%		292	296	
Steel FluxCore High Str.	Ar+18%CO ₂		592		
Steel / FluxCore Rutil	Self Shielded	720	722		
Application					
	MIG/MAG Manual		4		
	TIG (Lift Arc)		5		
	MMA		6		
	Gouging		7		

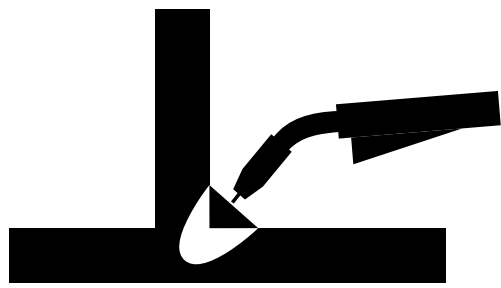


Function	Description	Min	Max
F01	Gas pre-flow (s)	0	10
F02	Start ignition mode (-)	0	2
F03	Start time (s)	0	10
F04	Start amper (%)	1	200
F05	Start arc correction (v)	-9.9	+9.9
F07	Start slope (s)	0	5
F08	Duo peak time (s)	0.05	10
F10	Duo base time (s)	0.05	10
F11	Duo base amper (%)	1	100
F12	Duo base arc correction (v)	-9.9	+9.9
F15	End down slope (s)	0.05	10
F16	End time (s)	0	10
F17	End amper (%)	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

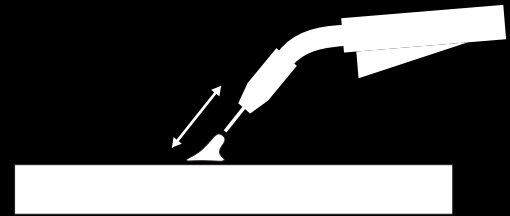
Function	Description	Min	Max
F25	Hot start time (s)	0	10
F26	Hot start amper (%)	1	200
F27	Arc force (-)	-50	+50
F28	Antistick (s)	0	2
F29	VRD function (-)	0	1
TIG			
F31	TIG V stop limit (v)	10	30
F32	TIG comfort stop sensitivity (v)	-2	+2
MIG/MAG			
F34	Tack/stich mode (-)	0	2
F35	Other cooling mode (-)	0	-
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
F50	RL cable calibration (mOhm)	0	30
OTHER			



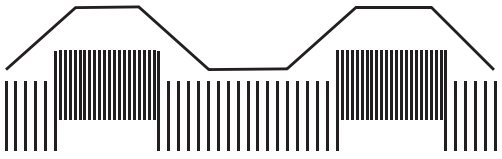
Position



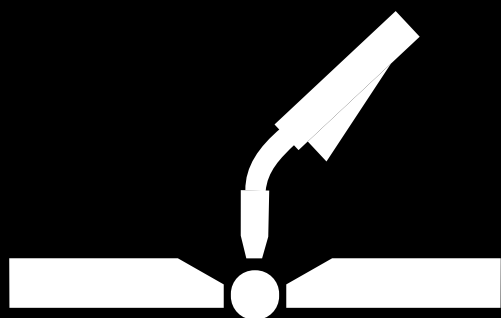
XDeep



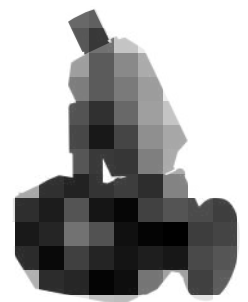
XStabil



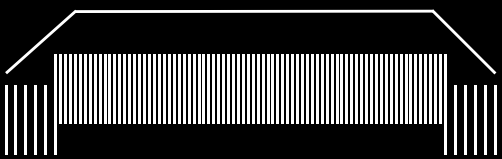
Duo Pulse



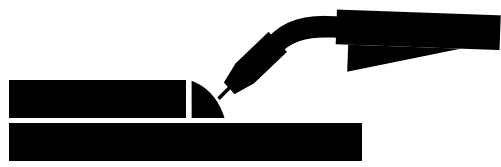
XRoot



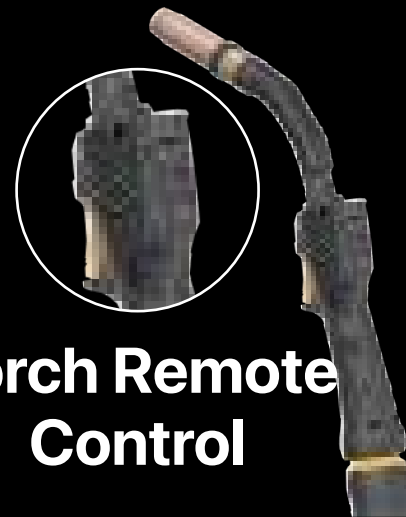
**4x4 4 Rollers
Wire Drive**



Pulse



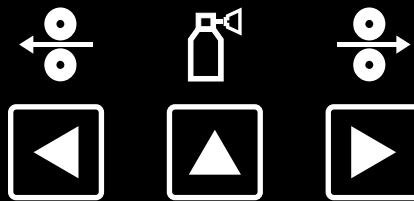
XCold



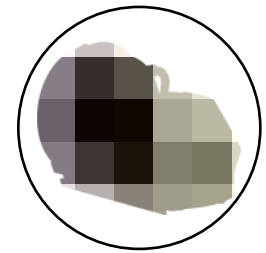
**Torch Remote
Control**



**256 PPR
(A-B-Index)
Optical Encoder**



**Wire Inching
Gas-Purge
Retract**



**Spool Cover
With Wire
View**

99

**Program
Memory**



**Intelligent
Cooling**

RL

**Torch and Cable
Calibration**



**HP
Support**



**Military
Connector**

CAN-FD

**High Speed
Communication**

Gun Holder

Aluminium Body

Lightweight Compact Wire Feeder

Modular IP23 Design

User Interface Cover

RGB Status Lighting

Touch Sense Ignition

Wire Cut, Sure Start

Wire Calibration

Wire Feeder Cabinet Lighting

Wire Feeder MMA connection

Gas Saving System

Gas Filter

Water Filter

Fan Ventilation Filter

Extension Cable Rack

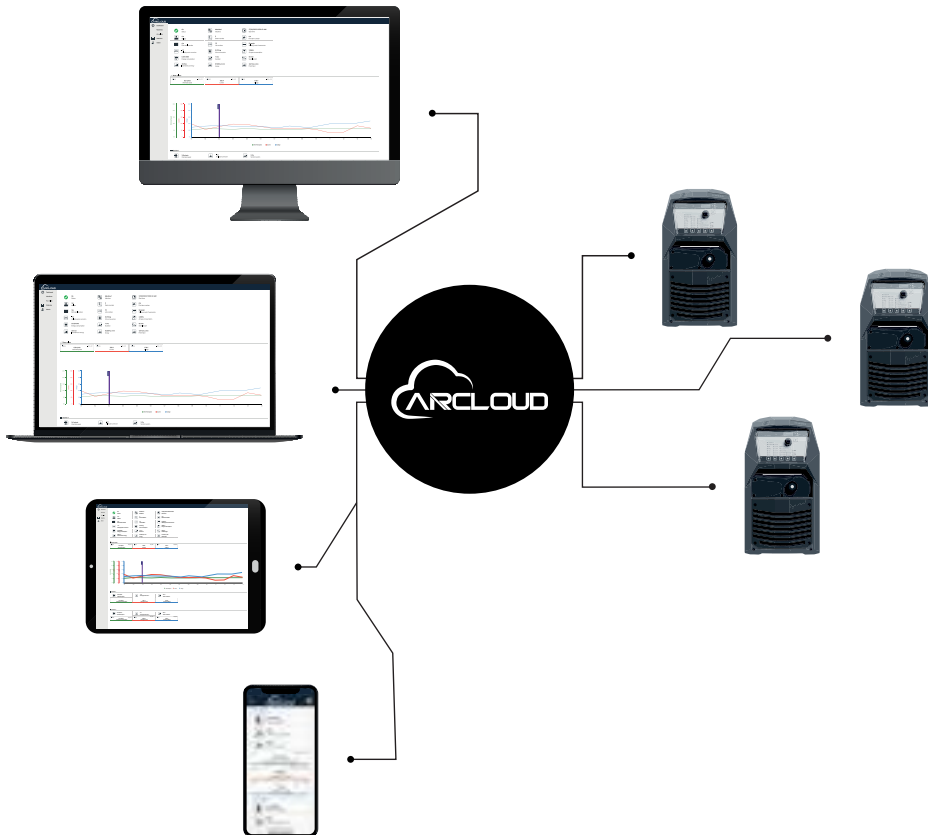
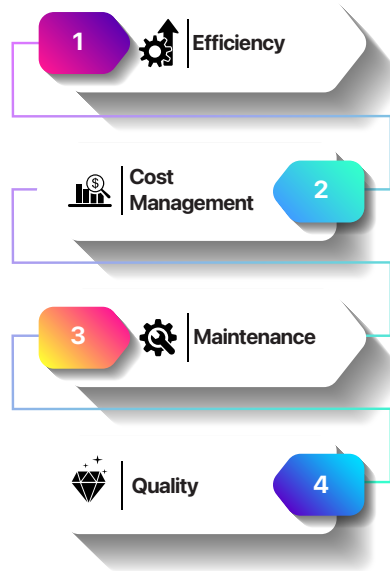
External Changable Couplings

Plug Double Setscrew

Socket Brass-Nut

Industrial Wheels

Optional Wire Feeder Wheels



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