

# KOLARC

BUILDING THE FUTURE



**AGINT**  
INNOVATIVE WELDING

KM, KT, KS  
Catalogue  
2025

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## ABBREVIATIONS

MMA Manual Metal Arc (Shielded Metal Arc Welding)

MIG/MAG Metal Inert Gas / Metal Active Gas

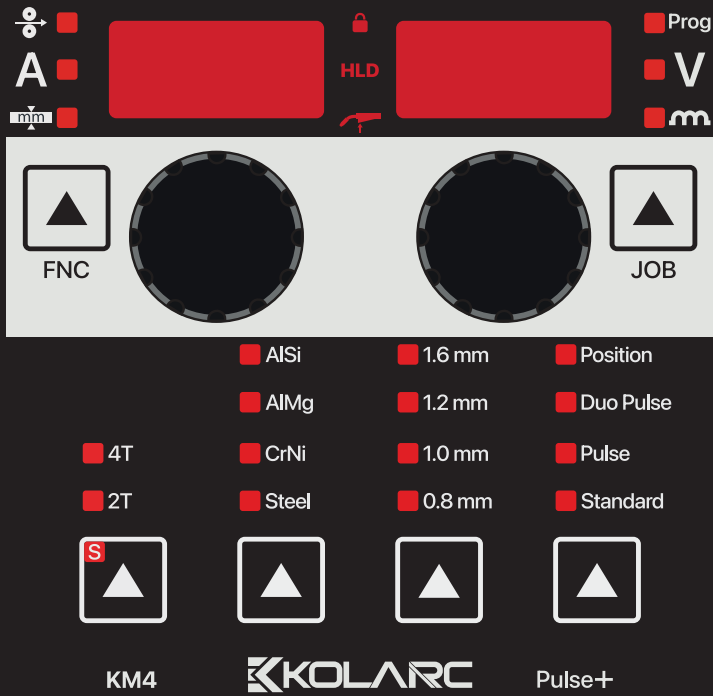
CC Constant Current

CV Constant Voltage

CC + CV Constant Current + Constant Voltage

# KM Pulse+

## Series



## KM Pulse+ Job & Function List

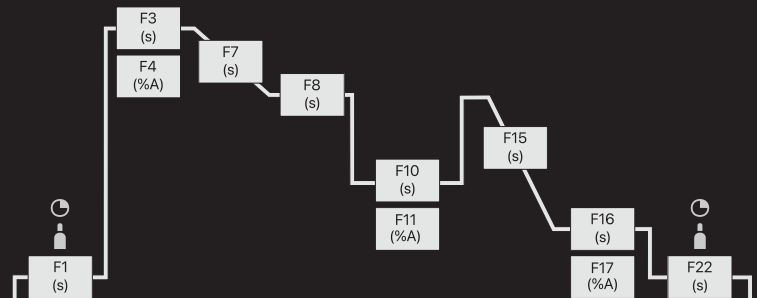
| Standard - Pulse         |              |                        | 0.8 | 1.0 | 1.2 | 1.6 |
|--------------------------|--------------|------------------------|-----|-----|-----|-----|
| SG2 / SG3                |              | Ar+18%CO <sub>2</sub>  | 8   | 10  | 12  | 16  |
|                          |              | Ar+10%CO <sub>2</sub>  | 18  | 20  | 22  | 26  |
|                          |              | CO <sub>2</sub> 100%   | 28  | 30  | 32  | 36  |
| CrNi                     | 308 / 1.4316 | Ar+2.5%CO <sub>2</sub> | 58  | 60  | 62  | 66  |
| CuSi                     |              | Ar100%                 | 178 | 180 | 182 | 186 |
| CuAl                     |              | Ar100%                 | 188 | 190 | 192 | 196 |
| 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 <sub>2</sub>  | 238 | 240 | 242 | 246 |
| Steel / FluxCore Rutil   |              | Ar+18%CO <sub>2</sub>  | 248 | 250 | 252 | 256 |
|                          |              | CO <sub>2</sub> 100%   |     |     | 262 | 266 |
| Steel / FluxCore Basic   |              | Ar+18%CO <sub>2</sub>  |     |     | 602 |     |
| Steel FluxCore High Str. |              | Ar+18%CO <sub>2</sub>  |     |     | 592 |     |
| Steel / FluxCore Rutil   |              | Self Shielded          |     | 720 | 722 |     |
| XDeep - Pulse            |              |                        | 0.8 | 1.0 | 1.2 | 1.6 |
| SG2 / SG3                |              | Ar+18%CO <sub>2</sub>  | 298 | 300 | 302 | 306 |
|                          |              | Ar+10%CO <sub>2</sub>  | 308 | 310 | 312 | 316 |
| Application              |              |                        |     |     |     |     |
| MIG/MAG Manual           |              |                        | 4   |     |     |     |
| TIG (Lift Arc)           |              |                        | 5   |     |     |     |
| MMA                      |              |                        | 6   |     |     |     |
| Gouging                  |              |                        | 7   |     |     |     |

# 99

## Program Memory



## 4x4 Rollers Wire Drive

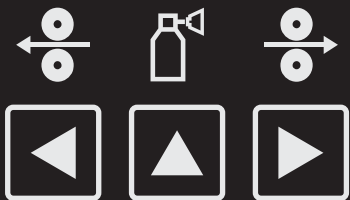


| Function | Description                    | Min  | Max  |
|----------|--------------------------------|------|------|
| F1       | Gas pre-flow (s)               | 0    | 10   |
| F2       | Start wire speed (m/min)       | 1    | 11   |
| F3       | Start time (s)                 | 0    | 10   |
| 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 (%)             | 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   |

| Function | Description                   | Min | Max |
|----------|-------------------------------|-----|-----|
| 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  |
| 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  |



## Wire Push Pull-Back Gas Testing



## Spool Cover With Wire View

## KM600 Pulse+ HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2371   00001                                |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Pulse                                     |                                              |
| Hose Package, 600 5m                                       |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM36 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM600 W Pulse+ HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1351mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2372   00001                                |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Pulse                                   |                                              |
| Hose Package, 600 W 5m                                     |                                              |
| Cooling Unit, KWL                                          |                                              |
| Coolant (2.5L)                                             |                                              |
| Trolley, XM                                                |                                              |
| Torch, KM50 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM500 Pulse+ HP 5m



| Technical Specifications                                   |                                            |
|------------------------------------------------------------|--------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                  |
| Welding Current                                            | 10 A - 500 A                               |
| Duty Cycle, 40°C                                           | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
|                                                            | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
|                                                            | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                |
| Factory Delivered Roller                                   | 1.0 + 1.2 mm / Steel                       |
| Weight                                                     | Air Cooled , 77 kg                         |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                     |
| Certification                                              | <b>CE</b>                                  |
| Stock Code                                                 | M2360 00001                                |
| Product Components                                         |                                            |
| Power Source, KM500 Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                                            |
| Wire Feeder, KM4 Pulse                                     |                                            |
| Hose Package, 500 5m                                       |                                            |
| Trolley, KM                                                |                                            |
| Torch, KM36 4m                                             |                                            |
| Ground Clamp (3m, 70mm <sup>2</sup> )                      |                                            |

## KM500 W Pulse+ HP 5m



| Technical Specifications                                   |                                            |
|------------------------------------------------------------|--------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                  |
| Welding Current                                            | 10 A - 500 A                               |
| Duty Cycle, 40°C                                           | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
|                                                            | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
|                                                            | MIG 500A 40%, TIG 430A 60% , MMA 360A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                |
| Factory Delivered Roller                                   | 1.0 + 1.2 mm / Steel                       |
| Weight                                                     | Liquid Cooled , 100 kg                     |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1261mm                     |
| Certification                                              | <b>CE</b>                                  |
| Stock Code                                                 | M2363 00001                                |
| Product Components                                         |                                            |
| Power Source, KM500 Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                                            |
| Wire Feeder, KM4 W Pulse                                   |                                            |
| Hose Package, 500 W 5m                                     |                                            |
| Cooling Unit, KW                                           |                                            |
| Coolant (2.5L)                                             |                                            |
| Trolley, KM                                                |                                            |
| Torch, KM50 4m                                             |                                            |
| Ground Clamp (3m, 70mm <sup>2</sup> )                      |                                            |

## KM320 C Pulse+



| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                               | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 50 kg                           |
| Dimentions (W, L, H)                                           | 263mm x 215mm x 540mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2375 00001                                  |
| Product Components                                             |                                              |
| Power Source, KM320 C Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                                              |
| Torch, KM36 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                          |                                              |

## KM320 CW Pulse+



| Technical Specifications                                         |                                              |
|------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                    | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                  | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                 | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                  | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                           | 63 V - 82 V                                  |
| Factory Delivered Roller                                         | 0.8 + 1.0 mm / Steel                         |
| Weight                                                           | Liquid Cooled , 65 kg                        |
| Dimentions (W, L, H)                                             | 532mm x 970mm x 949mm                        |
| Certification                                                    | <b>CE</b>                                    |
| Stock Code                                                       | M2378 00001                                  |
| Product Components                                               |                                              |
| Power Source, KM320 C W Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                                              |
| Cooling Unit, KWS                                                |                                              |
| Coolant (2.5L)                                                   |                                              |
| Trolley, KM                                                      |                                              |
| Torch, KM50 4m                                                   |                                              |
| Gas Hose (1.5m)                                                  |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                            |                                              |

## KM270 C Pulse+



| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 270 A                                 |
| Duty Cycle, 40°C                                               | MIG 270A 60%, TIG 270A 60% , MMA 270A 60%    |
|                                                                | MIG 210A 100%, TIG 210A 100% , MMA 210A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                           | 234mm x 483mm x 417mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2381   00001                                |
| Product Components                                             |                                              |
| Power Source, KM270 C Pulse (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                          |                                              |

## KM220 C Pulse+

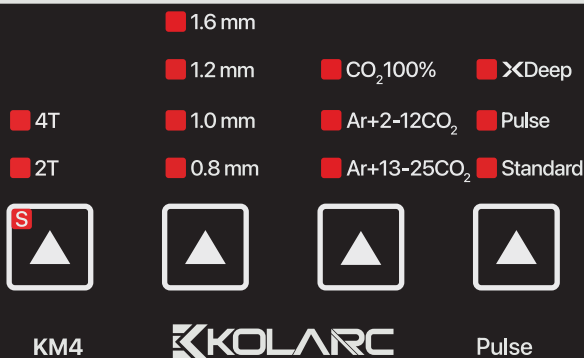
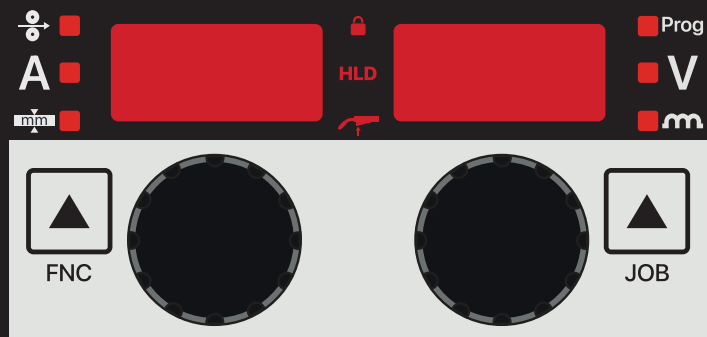


| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 230 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 210 A                                 |
| Duty Cycle, 40°C                                               | MIG 220A 60%, TIG 220A 60% , MMA 220A 60%    |
|                                                                | MIG 170A 100%, TIG 170A 100% , MMA 170A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                           | 234mm x 483mm x 417mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2384   00001                                |
| Product Components                                             |                                              |
| Power Source, KM220 C Pulse (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                          |                                              |



# KM Pulse

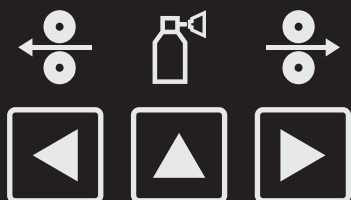
## Series



**99**  
Program  
Memory



**4x4 Rollers  
Wire Drive**



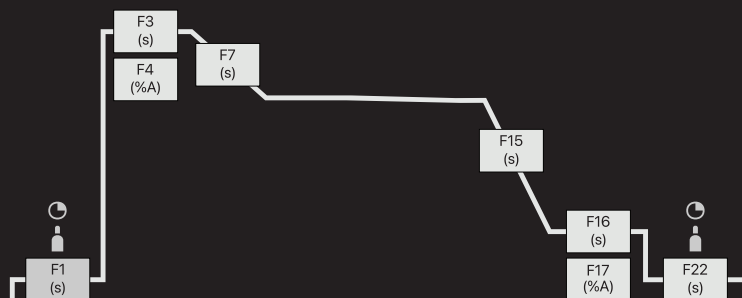
**Wire Push  
Pull-Back  
Gas Testing**



**Spool Cover  
With Wire  
View**

## KM Pulse Job & Function List

| Standard - Pulse         |                       | 0.8 | 1.0 | 1.2 | 1.6 |
|--------------------------|-----------------------|-----|-----|-----|-----|
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 8   | 10  | 12  | 16  |
|                          | Ar+10%CO <sub>2</sub> | 18  | 20  | 22  | 26  |
|                          | CO <sub>2</sub> 100%  | 28  | 30  | 32  | 36  |
| Flux Cored Wire          |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| Steel / FluxCore Metal   | Ar+18%CO <sub>2</sub> | 238 | 240 | 242 | 246 |
| Steel / FluxCore Rutil   | Ar+18%CO <sub>2</sub> | 248 | 250 | 252 | 256 |
|                          | CO <sub>2</sub> 100%  |     |     | 262 | 266 |
| Steel / FluxCore Basic   | Ar+18%CO <sub>2</sub> |     |     | 602 |     |
| Steel FluxCore High Str. | Ar+18%CO <sub>2</sub> |     |     | 592 |     |
| Steel / FluxCore Rutil   | Self Shielded         |     | 720 | 722 |     |
| XDeep - Pulse            |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 298 | 300 | 302 | 306 |
|                          | Ar+10%CO <sub>2</sub> | 308 | 310 | 312 | 316 |
| 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    |
| F11      | Duo base amper (%)             | 1    | 100  |
| 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  |
| 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  |

## KM600 Pulse HP 5m



## KM600 W Pulse HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2371 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Pulse                                     |                                              |
| Hose Package, 600 5m                                       |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM36 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1351mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2372 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Pulse                                   |                                              |
| Hose Package, 600 W 5m                                     |                                              |
| Cooling Unit, KWL                                          |                                              |
| Coolant (2.5L)                                             |                                              |
| Trolley, XM                                                |                                              |
| Torch, KM50 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM500 Pulse HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                           | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                            | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                            | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.0 + 1.2 mm / Steel                         |
| Weight                                                     | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                       |
| Certification                                              | CE                                           |
| Stock Code                                                 | M2360 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM500 Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Pulse                                     |                                              |
| Hose Package, 500 5m                                       |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM36 4m                                             |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                      |                                              |

## KM500 W Pulse HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                           | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                            | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                            | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.0 + 1.2 mm / Steel                         |
| Weight                                                     | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1261mm                       |
| Certification                                              | CE                                           |
| Stock Code                                                 | M2363 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM500 Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Pulse                                   |                                              |
| Hose Package, 500 W 5m                                     |                                              |
| Cooling Unit, KW                                           |                                              |
| Coolant (2.5L)                                             |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM50 4m                                             |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                      |                                              |

## KM320 C Pulse



## KM320 CW Pulse



| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                               | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 50 kg                           |
| Dimentions (W, L, H)                                           | 263mm x 215mm x 540mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2375 00001                                  |
| Product Components                                             |                                              |
| Power Source, KM320 C Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                                              |
| Torch, KM36 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                          |                                              |

| Technical Specifications                                         |                                              |
|------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                    | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                  | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                 | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                  | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                           | 63 V - 82 V                                  |
| Factory Delivered Roller                                         | 0.8 + 1.0 mm / Steel                         |
| Weight                                                           | Liquid Cooled , 65 kg                        |
| Dimentions (W, L, H)                                             | 532mm x 970mm x 949mm                        |
| Certification                                                    | <b>CE</b>                                    |
| Stock Code                                                       | M2378 00001                                  |
| Product Components                                               |                                              |
| Power Source, KM320 C W Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                                              |
| Cooling Unit, KWS                                                |                                              |
| Coolant (2.5L)                                                   |                                              |
| Trolley, KM                                                      |                                              |
| Torch, KM50 4m                                                   |                                              |
| Gas Hose (1.5m)                                                  |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                            |                                              |

## KM270 C Pulse



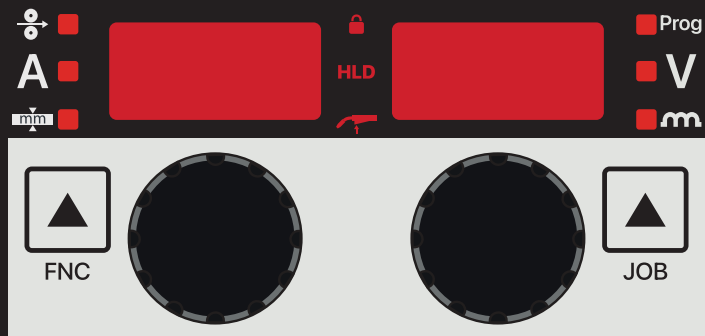
| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 270 A                                 |
| Duty Cycle, 40°C                                               | MIG 270A 60%, TIG 270A 60% , MMA 270A 60%    |
|                                                                | MIG 210A 100%, TIG 210A 100% , MMA 210A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                           | 234mm x 483mm x 417mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2381   00001                                |
| Product Components                                             |                                              |
| Power Source, KM270 C Pulse (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, KM25 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                          |                                              |

## KM220 C Pulse



| Technical Specifications                                       |                                              |
|----------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                  | 230 V ( - 10 % / + 15 % )                    |
| Welding Current                                                | 10 A - 210 A                                 |
| Duty Cycle, 40°C                                               | MIG 220A 60%, TIG 220A 60% , MMA 220A 60%    |
|                                                                | MIG 170A 100%, TIG 170A 100% , MMA 170A 100% |
| Open - Circuit Voltage                                         | 63 V - 82 V                                  |
| Factory Delivered Roller                                       | 0.8 + 1.0 mm / Steel                         |
| Weight                                                         | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                           | 234mm x 483mm x 417mm                        |
| Certification                                                  | <b>CE</b>                                    |
| Stock Code                                                     | M2384   00001                                |
| Product Components                                             |                                              |
| Power Source, KM220 C Pulse (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, KM25 4m                                                 |                                              |
| Gas Hose (1.5m)                                                |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                          |                                              |

# KM Synergic Series



1.6 mm  
1.2 mm  
1.0 mm  
0.8 mm  
4T  
2T  
CO<sub>2</sub>100%  
Ar+2-12CO<sub>2</sub>  
Ar+13-25CO<sub>2</sub>  
Standard



KM4

KOLARC

Synergic

## KM Synergic Job & Function List

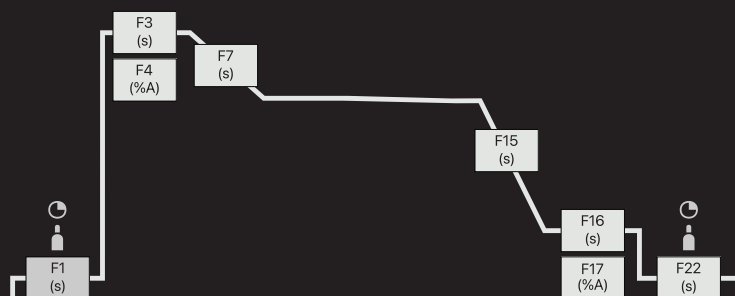
| Standard - Pulse         |                       | 0.8 | 1.0 | 1.2 | 1.6 |
|--------------------------|-----------------------|-----|-----|-----|-----|
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 8   | 10  | 12  | 16  |
|                          | Ar+10%CO <sub>2</sub> | 18  | 20  | 22  | 26  |
|                          | CO <sub>2</sub> 100%  | 28  | 30  | 32  | 36  |
| Flux Cored Wire          |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| Steel / FluxCore Metal   | Ar+18%CO <sub>2</sub> | 238 | 240 | 242 | 246 |
| Steel / FluxCore Rutil   | Ar+18%CO <sub>2</sub> | 248 | 250 | 252 | 256 |
|                          | CO <sub>2</sub> 100%  |     |     | 262 | 266 |
| Steel / FluxCore Basic   | Ar+18%CO <sub>2</sub> |     |     | 602 |     |
| Steel FluxCore High Str. | Ar+18%CO <sub>2</sub> |     |     | 592 |     |
| Steel / FluxCore Rutil   | Self Shielded         |     | 720 | 722 |     |
| XDeep - Pulse            |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 298 | 300 | 302 | 306 |
|                          | Ar+10%CO <sub>2</sub> | 308 | 310 | 312 | 316 |
| Application              |                       |     |     |     |     |
| MIG/MAG Manual           |                       | 4   |     |     |     |
| TIG (Lift Arc)           |                       | 5   |     |     |     |
| MMA                      |                       | 6   |     |     |     |
| Gouging                  |                       | 7   |     |     |     |

# 99

## Program Memory



## 4x4 Rollers Wire Drive

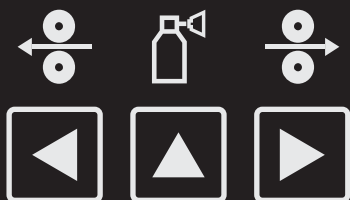


| Function | Description                    | Min  | Max  |
|----------|--------------------------------|------|------|
| F1       | Gas pre-flow (s)               | 0    | 10   |
| F2       | Start wire speed (m/min)       | 1    | 11   |
| F3       | Start time (s)                 | 0    | 10   |
|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

| Function | Description                   | Min | Max |
|----------|-------------------------------|-----|-----|
| 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  |
| 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  |



## Wire Push Pull-Back Gas Testing



## Spool Cover With Wire View



## KM600 Synergic HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2371   00001                                |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Pulse                                     |                                              |
| Hose Package, 600 5m                                       |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM36 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM600 W Synergic HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1351mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2374   00001                                |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Pulse                                   |                                              |
| Hose Package, 600 W 5m                                     |                                              |
| Cooling Unit, KWL                                          |                                              |
| Coolant (2.5L)                                             |                                              |
| Trolley, XM                                                |                                              |
| Torch, KM50 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM500 Synergic HP 5m



| Technical Specifications                                      |                                              |
|---------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                 | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                               | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                              | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                               | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                               | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                        | 63 V - 82 V                                  |
| Factory Delivered Roller                                      | 1.0 + 1.2 mm / Steel                         |
| Weight                                                        | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                          | 532mm x 948mm x 1031mm                       |
| Certification                                                 | CE                                           |
| Stock Code                                                    | M2361   00001                                |
| Product Components                                            |                                              |
| Power Source, KM500 Synergic (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Synergic                                     |                                              |
| Hose Package, 500 5m                                          |                                              |
| Trolley, KM                                                   |                                              |
| Torch, KM36 4m                                                |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                         |                                              |

## KM500 W Synergic HP 5m



| Technical Specifications                                      |                                              |
|---------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                 | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                               | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                              | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                               | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                               | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                        | 63 V - 82 V                                  |
| Factory Delivered Roller                                      | 1.0 + 1.2 mm / Steel                         |
| Weight                                                        | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                          | 532mm x 970mm x 1261mm                       |
| Certification                                                 | CE                                           |
| Stock Code                                                    | M2364   00001                                |
| Product Components                                            |                                              |
| Power Source, KM500 Synergic (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Synergic                                   |                                              |
| Hose Package, 500 W 5m                                        |                                              |
| Cooling Unit, KW                                              |                                              |
| Coolant (2.5L)                                                |                                              |
| Trolley, KM                                                   |                                              |
| Torch, KM50 4m                                                |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                         |                                              |

## KM320 C Synergic



## KM320 CW Synergic



| Technical Specifications                                         |                                              |
|------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                    | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                  | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                 | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                  | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                           | 63 V - 82 V                                  |
| Factory Delivered Roller                                         | 0.8 + 1.0 mm / Steel                         |
| Weight                                                           | Air Cooled , 50 kg                           |
| Dimentions (W, L, H)                                             | 263mm x 215mm x 540mm                        |
| Certification                                                    | <b>CE</b>                                    |
| Stock Code                                                       | M2376 00001                                  |
| Product Components                                               |                                              |
| Power Source, KM320 C Synergic (Cable, 4x2.5mm <sup>2</sup> ,5m) |                                              |
| Torch, KM36 4m                                                   |                                              |
| Gas Hose (1.5m)                                                  |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                            |                                              |

| Technical Specifications                                           |                                              |
|--------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                      | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                    | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                   | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                    | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                             | 63 V - 82 V                                  |
| Factory Delivered Roller                                           | 0.8 + 1.0 mm / Steel                         |
| Weight                                                             | Liquid Cooled , 65 kg                        |
| Dimentions (W, L, H)                                               | 532mm x 970mm x 949mm                        |
| Certification                                                      | <b>CE</b>                                    |
| Stock Code                                                         | M2379 00001                                  |
| Product Components                                                 |                                              |
| Power Source, KM320 C W Synergic (Cable, 4x2.5mm <sup>2</sup> ,5m) |                                              |
| Cooling Unit, KWS                                                  |                                              |
| Coolant (2.5L)                                                     |                                              |
| Trolley, KM                                                        |                                              |
| Torch, KM50 4m                                                     |                                              |
| Gas Hose (1.5m)                                                    |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                              |                                              |

## KM270 C Synergic



| Technical Specifications                                          |                                              |
|-------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                     | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                   | 10 A - 270 A                                 |
| Duty Cycle, 40°C                                                  | MIG 270A 60%, TIG 270A 60% , MMA 270A 60%    |
|                                                                   | MIG 210A 100%, TIG 210A 100% , MMA 210A 100% |
| Open - Circuit Voltage                                            | 63 V - 82 V                                  |
| Factory Delivered Roller                                          | 0.8 + 1.0 mm / Steel                         |
| Weight                                                            | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                              | 234mm x 483mm x 417mm                        |
| Certification                                                     | <b>CE</b>                                    |
| Stock Code                                                        | M2382 00001                                  |
| Product Components                                                |                                              |
| Power Source, KM270 C Synergic (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                    |                                              |
| Gas Hose (1.5m)                                                   |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                             |                                              |

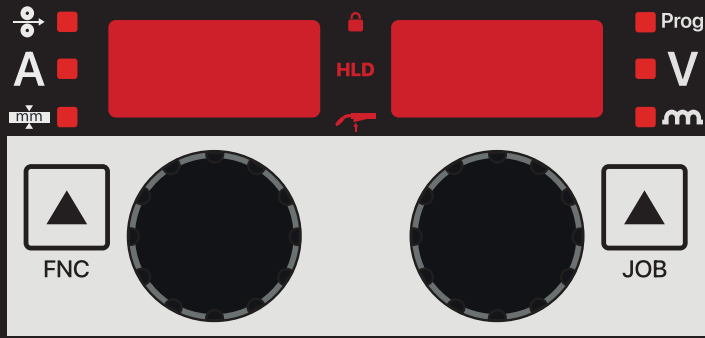
## KM220 C Synergic



| Technical Specifications                                          |                                              |
|-------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                     | 230 V ( - 10 % / + 15 % )                    |
| Welding Current                                                   | 10 A - 210 A                                 |
| Duty Cycle, 40°C                                                  | MIG 220A 60%, TIG 220A 60% , MMA 220A 60%    |
|                                                                   | MIG 170A 100%, TIG 170A 100% , MMA 170A 100% |
| Open - Circuit Voltage                                            | 63 V - 82 V                                  |
| Factory Delivered Roller                                          | 0.8 + 1.0 mm / Steel                         |
| Weight                                                            | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                              | 234mm x 483mm x 417mm                        |
| Certification                                                     | <b>CE</b>                                    |
| Stock Code                                                        | M2385 00001                                  |
| Product Components                                                |                                              |
| Power Source, KM220 C Synergic (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                    |                                              |
| Gas Hose (1.5m)                                                   |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                             |                                              |

# KM Shipyard

## Series



4T

2T



KM4

KOLARC

Shipyard

## KM Shipyard Job & Function List

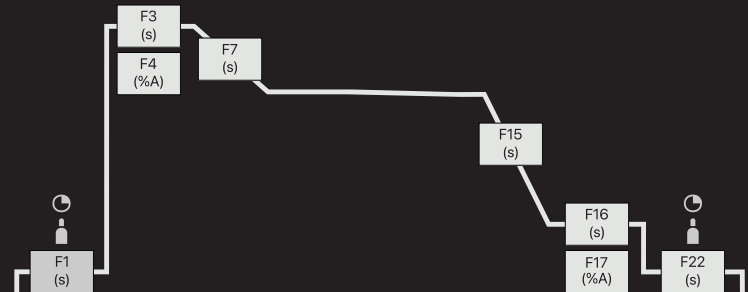
| Standard - Pulse         |                       | 0.8 | 1.0 | 1.2 | 1.6 |
|--------------------------|-----------------------|-----|-----|-----|-----|
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 8   | 10  | 12  | 16  |
|                          | Ar+10%CO <sub>2</sub> | 18  | 20  | 22  | 26  |
|                          | CO <sub>2</sub> 100%  | 28  | 30  | 32  | 36  |
| Flux Cored Wire          |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| Steel / FluxCore Metal   | Ar+18%CO <sub>2</sub> | 238 | 240 | 242 | 246 |
| Steel / FluxCore Rutil   | Ar+18%CO <sub>2</sub> | 248 | 250 | 252 | 256 |
|                          | CO <sub>2</sub> 100%  |     |     | 262 | 266 |
| Steel / FluxCore Basic   | Ar+18%CO <sub>2</sub> |     |     | 602 |     |
| Steel FluxCore High Str. | Ar+18%CO <sub>2</sub> |     |     | 592 |     |
| Steel / FluxCore Rutil   | Self Shielded         |     | 720 | 722 |     |
| XDeep - Pulse            |                       | 0.8 | 1.0 | 1.2 | 1.6 |
| SG2 / SG3                | Ar+18%CO <sub>2</sub> | 298 | 300 | 302 | 306 |
|                          | Ar+10%CO <sub>2</sub> | 308 | 310 | 312 | 316 |
| Application              |                       |     |     |     |     |
| MIG/MAG Manual           |                       | 4   |     |     |     |
| TIG (Lift Arc)           |                       | 5   |     |     |     |
| MMA                      |                       | 6   |     |     |     |
| Gouging                  |                       | 7   |     |     |     |

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## Program Memory

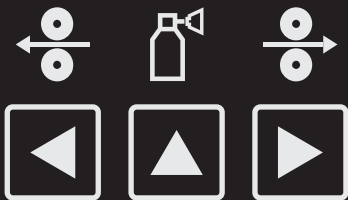


## 4x4 Rollers Wire Drive



| 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    |
| F11      | Duo base amper (%)             | 1    | 100  |
| 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  |
| F50      | RL cable calibration (mOhm)      | 0   | 30  |
| F31      | TIG V stop limit (V)             | 10  | 30  |
| F32      | TIG comfort stop sensitivity (V) | -2  | +2  |



## Wire Push Pull-Back Gas Testing



## Spool Cover With Wire View

## KM600 Shipyard HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                       | 532mm x 948mm x 1031mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2391 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Pulse                                     |                                              |
| Hose Package, 600 5m                                       |                                              |
| Trolley, KM                                                |                                              |
| Torch, KM36 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM600 W Shipyard HP 5m



| Technical Specifications                                   |                                              |
|------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                            | 10 A - 600 A                                 |
| Duty Cycle, 40°C                                           | MIG 600A 60%, TIG 600A 60% , MMA 600A 60%    |
|                                                            | MIG 500A 100%, TIG 500A 100% , MMA 500A 100% |
| Open - Circuit Voltage                                     | 63 V - 82 V                                  |
| Factory Delivered Roller                                   | 1.2 + 1.6 mm / Steel                         |
| Weight                                                     | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                       | 532mm x 970mm x 1351mm                       |
| Certification                                              | <b>CE</b>                                    |
| Stock Code                                                 | M2392 00001                                  |
| Product Components                                         |                                              |
| Power Source, KM600 Pulse (Cable, 4x6mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Pulse                                   |                                              |
| Hose Package, 600 W 5m                                     |                                              |
| Cooling Unit, KWL                                          |                                              |
| Coolant (2.5L)                                             |                                              |
| Trolley, XM                                                |                                              |
| Torch, KM50 4m                                             |                                              |
| Ground Clamp (3m, 95mm <sup>2</sup> )                      |                                              |

## KM500 Shipyard HP 5m



## KM500 W Shipyard 5m



| Technical Specifications                                      |                                              |
|---------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                 | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                               | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                              | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                               | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                               | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                        | 63 V - 82 V                                  |
| Factory Delivered Roller                                      | 1.0 + 1.2 mm / Steel                         |
| Weight                                                        | Air Cooled , 77 kg                           |
| Dimentions (W, L, H)                                          | 532mm x 948mm x 1031mm                       |
| Certification                                                 | <b>CE</b>                                    |
| Stock Code                                                    | M2362 00001                                  |
| Product Components                                            |                                              |
| Power Source, KM500 Shipyard (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 Shipyard                                     |                                              |
| Hose Package, 500 5m                                          |                                              |
| Trolley, KM                                                   |                                              |
| Torch, KM36 4m                                                |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                         |                                              |

| Technical Specifications                                      |                                              |
|---------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                 | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                               | 10 A - 500 A                                 |
| Duty Cycle, 40°C                                              | MIG 500A 40%, TIG 500A 40% , MMA 500A 40%    |
|                                                               | MIG 430A 60%, TIG 430A 60% , MMA 430A 60%    |
|                                                               | MIG 360A 100%, TIG 360A 100% , MMA 360A 100% |
| Open - Circuit Voltage                                        | 63 V - 82 V                                  |
| Factory Delivered Roller                                      | 1.0 + 1.2 mm / Steel                         |
| Weight                                                        | Liquid Cooled , 100 kg                       |
| Dimentions (W, L, H)                                          | 532mm x 970mm x 1261mm                       |
| Certification                                                 | <b>CE</b>                                    |
| Stock Code                                                    | M2365 00001                                  |
| Product Components                                            |                                              |
| Power Source, KM500 Shipyard (Cable, 4x4mm <sup>2</sup> , 5m) |                                              |
| Wire Feeder, KM4 W Shipyard                                   |                                              |
| Hose Package, 500 W 5m                                        |                                              |
| Cooling Unit, KW                                              |                                              |
| Coolant (2.5L)                                                |                                              |
| Trolley, KM                                                   |                                              |
| Torch, KM50 4m                                                |                                              |
| Ground Clamp (3m, 70mm <sup>2</sup> )                         |                                              |



## KM320 C Shipyard



## KM320 CW Shipyard



| Technical Specifications                                         |                                              |
|------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                    | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                  | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                 | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                  | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                           | 63 V - 82 V                                  |
| Factory Delivered Roller                                         | 0.8 + 1.0 mm / Steel                         |
| Weight                                                           | Air Cooled , 50 kg                           |
| Dimentions (W, L, H)                                             | 263mm x 215mm x 540mm                        |
| Certification                                                    | <b>CE</b>                                    |
| Stock Code                                                       | M2377 00001                                  |
| Product Components                                               |                                              |
| Power Source, KM320 C Shipyard (Cable, 4x2.5mm <sup>2</sup> ,5m) |                                              |
| Torch, KM36 4m                                                   |                                              |
| Gas Hose (1.5m)                                                  |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                            |                                              |

| Technical Specifications                                           |                                              |
|--------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                      | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                    | 10 A - 320 A                                 |
| Duty Cycle, 40°C                                                   | MIG 320A 60%, TIG 320A 60% , MMA 320A 60%    |
|                                                                    | MIG 240A 100%, TIG 240A 100% , MMA 240A 100% |
| Open - Circuit Voltage                                             | 63 V - 82 V                                  |
| Factory Delivered Roller                                           | 0.8 + 1.0 mm / Steel                         |
| Weight                                                             | Liquid Cooled , 65 kg                        |
| Dimentions (W, L, H)                                               | 532mm x 970mm x 949mm                        |
| Certification                                                      | <b>CE</b>                                    |
| Stock Code                                                         | M2378 00001                                  |
| Product Components                                                 |                                              |
| Power Source, KM320 C W Shipyard (Cable, 4x2.5mm <sup>2</sup> ,5m) |                                              |
| Cooling Unit, KWS                                                  |                                              |
| Coolant (2.5L)                                                     |                                              |
| Trolley, KM                                                        |                                              |
| Torch, KM50 4m                                                     |                                              |
| Gas Hose (1.5m)                                                    |                                              |
| Ground Clamp (3m, 50mm <sup>2</sup> )                              |                                              |

## KM270 C Shipyard



| Technical Specifications                                          |                                              |
|-------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                     | 400 V ( - 10 % / + 15 % )                    |
| Welding Current                                                   | 10 A - 270 A                                 |
| Duty Cycle, 40°C                                                  | MIG 270A 60%, TIG 270A 60% , MMA 270A 60%    |
|                                                                   | MIG 210A 100%, TIG 210A 100% , MMA 210A 100% |
| Open - Circuit Voltage                                            | 63 V - 82 V                                  |
| Factory Delivered Roller                                          | 0.8 + 1.0 mm / Steel                         |
| Weight                                                            | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                              | 234mm x 483mm x 417mm                        |
| Certification                                                     | <b>CE</b>                                    |
| Stock Code                                                        | M2383 00001                                  |
| Product Components                                                |                                              |
| Power Source, KM270 C Shipyard (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                    |                                              |
| Gas Hose (1.5m)                                                   |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                             |                                              |

## KM220 C Shipyard



| Technical Specifications                                          |                                              |
|-------------------------------------------------------------------|----------------------------------------------|
| Input Voltage                                                     | 230 V ( - 10 % / + 15 % )                    |
| Welding Current                                                   | 10 A - 210 A                                 |
| Duty Cycle, 40°C                                                  | MIG 220A 60%, TIG 220A 60% , MMA 220A 60%    |
|                                                                   | MIG 170A 100%, TIG 170A 100% , MMA 170A 100% |
| Open - Circuit Voltage                                            | 63 V - 82 V                                  |
| Factory Delivered Roller                                          | 0.8 + 1.0 mm / Steel                         |
| Weight                                                            | Air Cooled , 25 kg                           |
| Dimentions (W, L, H)                                              | 234mm x 483mm x 417mm                        |
| Certification                                                     | <b>CE</b>                                    |
| Stock Code                                                        | M2386 00001                                  |
| Product Components                                                |                                              |
| Power Source, KM220 C Shipyard (Cable, 4x1.5mm <sup>2</sup> , 5m) |                                              |
| Torch, MX25 4m                                                    |                                              |
| Gas Hose (1.5m)                                                   |                                              |
| Ground Clamp (3m, 35mm <sup>2</sup> )                             |                                              |

Hose Package

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| Product Components   |
|----------------------|
| Hose Package, 600 1m |
| Hose Package, 500 1m |

Hose Package W

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| Product Components     |
|------------------------|
| Hose Package, 600 W 1m |
| Hose Package, 500 W 1m |

KT  
Series

## KT400 Pulse



| Technical Specifications                                   |                               |
|------------------------------------------------------------|-------------------------------|
| Input Voltage                                              | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                            | 10 A - 400 A                  |
| Duty Cycle, 40°C                                           | TIG 400A 60% , MMA 400A 60%   |
|                                                            | TIG 320A 100% , MMA 320A 100% |
| Open - Circuit Voltage                                     | 58 V - 75 V                   |
| Weight                                                     | 20 kg                         |
| Dimentions (W, L, H)                                       | 532mm x 622mm x 974mm         |
| Certification                                              | <b>CE</b>                     |
| Stock Code                                                 | M1200 00001                   |
| Product Components                                         |                               |
| Power Source, KT400 Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                               |
| Torch, TX26 (4m)                                           |                               |
| Gas Hose (1.5m)                                            |                               |
| Ground Clamp (3m, 50mm <sup>2</sup> )                      |                               |

## KT400 W Pulse



| Technical Specifications                                     |                               |
|--------------------------------------------------------------|-------------------------------|
| Input Voltage                                                | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                              | 10 A - 400 A                  |
| Duty Cycle, 40°C                                             | TIG 400A 60% , MMA 400A 60%   |
|                                                              | TIG 320A 100% , MMA 320A 100% |
| Open - Circuit Voltage                                       | 58 V - 75 V                   |
| Weight                                                       | 65 kg                         |
| Dimentions (W, L, H)                                         | 532mm x 860mm x 974mm         |
| Certification                                                | <b>CE</b>                     |
| Stock Code                                                   | M1201 00001                   |
| Product Components                                           |                               |
| Power Source, KT400 W Pulse (Cable, 4x4mm <sup>2</sup> , 5m) |                               |
| Cooling Unit, KW                                             |                               |
| Coolant (2.5L)                                               |                               |
| Trolley, KT                                                  |                               |
| Torch, TX18 (4m)                                             |                               |
| Gas Hose (1.5m)                                              |                               |
| Ground Clamp (3m, 50mm <sup>2</sup> )                        |                               |

## KT270 Pulse



| Technical Specifications                                     |                               |
|--------------------------------------------------------------|-------------------------------|
| Input Voltage                                                | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                              | 10 A - 270 A                  |
| Duty Cycle, 40°C                                             | TIG 270A 40% , MMA 270A 40%   |
|                                                              | TIG 230A 60% , MMA 230A 60%   |
|                                                              | TIG 200A 100% , MMA 200A 100% |
| Open - Circuit Voltage                                       | 58 V - 75 V                   |
| Weight                                                       | 20 kg                         |
| Dimention (W, L, H)                                          | 175mm x 310mm x 493mm         |
| Certification                                                | CE                            |
| Stock Code                                                   | M1180 00001                   |
| Product Components                                           |                               |
| Power Source, KT270 Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                               |
| Torch, TX26 (4m)                                             |                               |
| Gas Hose (1.5m)                                              |                               |
| Ground Clamp (3m, 35mm <sup>2</sup> )                        |                               |

## KT270 W Pulse



| Technical Specifications                                       |                               |
|----------------------------------------------------------------|-------------------------------|
| Input Voltage                                                  | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                                | 10 A - 270 A                  |
| Duty Cycle, 40°C                                               | TIG 270A 40% , MMA 270A 40%   |
|                                                                | TIG 230A 60% , MMA 230A 60%   |
|                                                                | TIG 200A 100% , MMA 200A 100% |
| Open - Circuit Voltage                                         | 58 V - 75 V                   |
| Weight                                                         | 65 kg                         |
| Dimention (W, L, H)                                            | 175mm x 310mm x 493mm         |
| Certification                                                  | CE                            |
| Stock Code                                                     | M1181 00001                   |
| Product Components                                             |                               |
| Power Source, KT270 W Pulse (Cable, 4x2.5mm <sup>2</sup> , 5m) |                               |
| Cooling Unit, KW                                               |                               |
| Coolant (2.5L)                                                 |                               |
| Trolley, KT                                                    |                               |
| Torch, TX18 (4m)                                               |                               |
| Gas Hose (1.5m)                                                |                               |
| Ground Clamp (3m, 35mm <sup>2</sup> )                          |                               |

## KT250 Pulse

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| Technical Specifications                                     |                               |
|--------------------------------------------------------------|-------------------------------|
| Input Voltage                                                | 230 V ( - 10 % / + 15 % )     |
| Welding Current                                              | 10 A - 220 A                  |
| Duty Cycle, 40°C                                             | TIG 250A 35% , MMA 220A 25%   |
|                                                              | TIG 190A 60% , MMA 140A 60%   |
|                                                              | TIG 145A 100% , MMA 105A 100% |
| Open - Circuit Voltage                                       | 58 V - 75 V                   |
| Weight                                                       | 25 kg                         |
| Dimentions (W, L, H)                                         | 175mm x 310mm x 493mm         |
| Certification                                                | CE                            |
| Stock Code                                                   | M1299 00001                   |
| Product Components                                           |                               |
| Power Source, KT250 Pulse (Cable, 3x2.5mm <sup>2</sup> , 5m) |                               |
| Torch, TX26 (4m)                                             |                               |
| Gas Hose (1.5m)                                              |                               |
| Ground Clamp (3m, 35mm <sup>2</sup> )                        |                               |

KS  
Series



## KS400



| Technical Specifications                             |                               |
|------------------------------------------------------|-------------------------------|
| Input Voltage                                        | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                      | 10 A - 400 A                  |
| Duty Cycle, 40°C                                     | TIG 400A 60% , MMA 400A 60%   |
|                                                      | TIG 230A 100% , MMA 190A 100% |
| Open - Circuit Voltage                               | 58 V - 75 V                   |
| Weight                                               | 25 kg                         |
| Dimensions (W, L, H)                                 | 216mm x 350mm x 415mm         |
| Certification                                        | <b>CE</b>                     |
| Stock Code                                           | M2353   00001                 |
| Product Components                                   |                               |
| Power Source, KS400 (Cable, 4x4mm <sup>2</sup> , 5m) |                               |
| Electrode Holder (5m, 35mm <sup>2</sup> )            |                               |
| Ground Clamp (3m, 35mm <sup>2</sup> )                |                               |

## KS270



| Technical Specifications                               |                               |
|--------------------------------------------------------|-------------------------------|
| Input Voltage                                          | 400 V ( - 10 % / + 15 % )     |
| Welding Current                                        | 10 A - 270 A                  |
| Duty Cycle, 40°C                                       | TIG 270A 35% , MMA 270A 25%   |
|                                                        | TIG 200A 60% , MMA 170A 60%   |
|                                                        | TIG 150A 100% , MMA 130A 100% |
| Open - Circuit Voltage                                 | 58 V - 75 V                   |
| Weight                                                 | 25 kg                         |
| Dimensions (W, L, H)                                   | 216mm x 350mm x 415mm         |
| Certification                                          | <b>CE</b>                     |
| Stock Code                                             | M0001   00001                 |
| Product Components                                     |                               |
| Power Source, KS270 (Cable, 4x2.5mm <sup>2</sup> , 5m) |                               |
| Electrode Holder (5m, 35mm <sup>2</sup> )              |                               |
| Ground Clamp (3m, 35mm <sup>2</sup> )                  |                               |

KS220



| Technical Specifications                  |                               |
|-------------------------------------------|-------------------------------|
| Input Voltage                             | 230 V ( - 10 % / + 15 % )     |
| Welding Current                           | 10 A - 220 A                  |
| Duty Cycle, 40°C                          | TIG 220A 35% , MMA 220A 25%   |
|                                           | TIG 160A 60% , MMA 140A 60%   |
|                                           | TIG 120A 100% , MMA 100A 100% |
| Open - Circuit Voltage                    | 58 V - 75 V                   |
| Weight                                    | 25 kg                         |
| Dimentions (W, L, H)                      | 216mm x 350mm x 415mm         |
| Certification                             | CE                            |
| Stock Code                                | M2354 00001                   |
| Product Components                        |                               |
| Power Source, KS220 (Cable, 4x2.5mm2, 5m) |                               |
| Electrode Holder (5m, 35mm2)              |                               |
| Ground Clamp (3m, 35mm2)                  |                               |

KS160

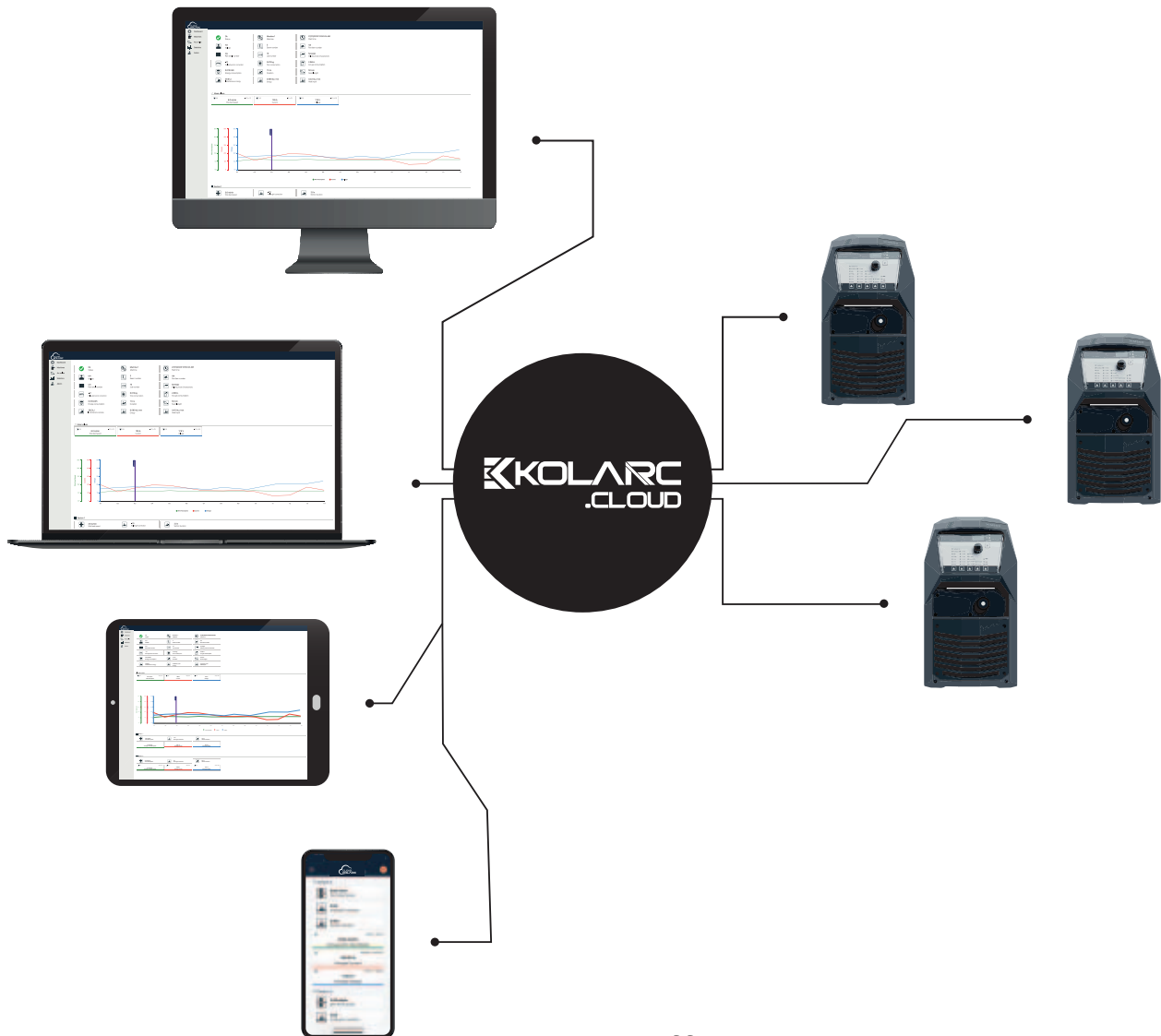


| Technical Specifications                  |                            |
|-------------------------------------------|----------------------------|
| Input Voltage                             | 230 V ( - 10 % / + 15 % )  |
| Welding Current                           | 10 A - 160 A               |
| Duty Cycle, 40°C                          | TIG 160A 35%, MMA 160A 35% |
|                                           | TIG 110A 60%, MMA 110A 60% |
|                                           | TIG 90A 100%, MMA 90A 100% |
| Open - Circuit Voltage                    | 58 V - 75 V                |
| Weight                                    | 3.5 kg                     |
| Dimentions (W, L, H)                      | 216mm x 107mm x 233mm      |
| Certification                             | CE                         |
| Stock Code                                | M2350 00001                |
| Product Components                        |                            |
| Power Source, KS160 (Cable, 3x2.5mm2, 5m) |                            |
| Electrode Holder (3m, 16mm2)              |                            |
| Ground Clamp (2m, 16mm2)                  |                            |

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