

2.2.7. OptiMIG 451 DW

Primary:

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| Voltage: | 3 x 400 V |
| Frequency: | 50 / 60 Hz |
| Continuous power: | 14.5 kVA |
| Continuous current: | 21 A |
| Max. current: | 36 A |
| cos phi (450 A): | 0.8 |
| cos phi (150 A): | 0.85 |

Secondary:

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| Open circuit voltage: | 17 - 52 V |
| Welding voltage: | 15 - 36.5 V |
| Welding current: | 25 - 450 A |
| Duty cycle 40 % (10 min.): | 450 A (40 °C) |
| Duty cycle 60 % (10 min.): | 420 A (40 °C) |
| Duty cycle 100 %: | 340 A (40 °C) |



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| Protection class: | IP 23 |
| Insulation: | H |
| Cooling: | AF |
| Mains switch: | 3 phase |
| Voltage control: | 42 steps 6-step coarse selector 7-step fine selector |
| Operation modes: | 2-/4-stroke/stitch/spot welding |
| Wire feed speed: | automatic setting through synergic controller (can be switched off) |
| Arc trim: | adjustable +/- 30 % at potentiometer or TEDAC torch |
| Wire selection: | selector switch |
| Wire burn back: | adjustable |
| Spot welding/interm. time: | adjustable |
| Creep start: | adjustable |
| Safety cut-off: | in 4-stroke operation |
| Wire insertion auto: | in 2-stroke operation |
| Functions: | gas test, wire inching |
| Digital display: | 2 digital displays for current, voltage, wire feed speed and material thickness with pre-display and hold function |
| Control lamp: | mains on, temp. protection, failure |
| Controller: | MAG 30 plug-in controller at the front panel |
| Rectifier: | silicon press-in diodes |
| Norm: | EN 60974-1 "S" / CE |
| Torch cooling: | integrated water cooler |
| Gas bottle holder: | 10, 20, 50 l cylinders |
| Mains supply cable: | 4 x 4.0 mm ² , 5 m long with plug 3 x 400 V, 32 A |
| Gas hose: | 2 m long |
| Choke: | 100%, option: 60% |
| Socket 50 mm ² : | for earth lead |
| Lifting eyes: | 4 pieces (option) |
| Push pull torch: | connector (option) |
| Weight: | 220 kg |
| Dimensions l x w x h: | 990 x 510 x 1135 mm incl. gas bottle holder |

Wire feeder: separately mounted, model DV-26

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|--------------------------|---|
| Supply: | 26 V-DC |
| Wire feed motor: | DC motor with worm gear drive 0.5 - 25 m/min. |
| Gear: | 4-roller-drive DV-26 |
| Potentiometer: | Wire feed speed |
| Wire feed support: | D 300/15 DIN 8559 |
| Torch connection: | Euro connector |
| Connection cable: | 1.6 m, 70 mm ² , water cooled |
| Standard wire equipment: | mild steel 1.2 mm |
| Weight: | 18 kg |
| Dimensions: | 610 x 400 x 180 mm |