

SPARTUS® MasterMIG 250W DUAL PULSE SYNERGY

MULTIPROCESS, SYNERGIC MIG
WITH DOUBLE PULSE



PRELIMINARY INFORMATION

SPARTUS® MasterMIG 250 DUAL PULSE SYNERGY is a modern multi-functional inverter device for welding with MIG/MAG, TIG and MMA methods. During its production, modern technologies were used, such as: IGBT transistors, PWM, MCU control system. The device is powered from a 400V three-phase network and enables welding with a current of up to 250A for all three methods.



DEVICE DESCRIPTION

SPARTUS® MasterMIG 250 DUAL PULSE SYNERGY have a number of modern functions necessary for high-performance and high-quality MIG/MAG welding of materials such as steels, stainless steels, acid-resistant steels and aluminum alloys. It will be used especially when welding aluminum and its alloys, thanks to the use of advanced functions, dedicated to welding demanding alloys. The most important functions: 1P (Pulse) - MIG/MAG welding with pulsation, which significantly facilitates obtaining a spray arc, 2P (Dual Pulse) - MIG/MAG welding with double pulsation. Simple to use and intuitive function panel allows precise control of parameters for MIG/MAG, TIG and MMA methods. For the MIG/MAG methods it is possible to smoothly adjust the welding parameters such as: welding voltage, wire feed speed, inductance. In addition, the device is equipped with synergic programs in which the parameters are programmed - according to the welding mode and the material being welded.



EXAMPLES OF USE

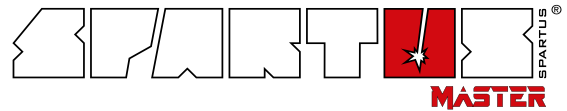
- workshop work,
- renovation works in the field,
- automotive - welding of galvanized car bodies (brazing),
- silencer welding,
- production sector,
- light industry.

Videopresentation of products



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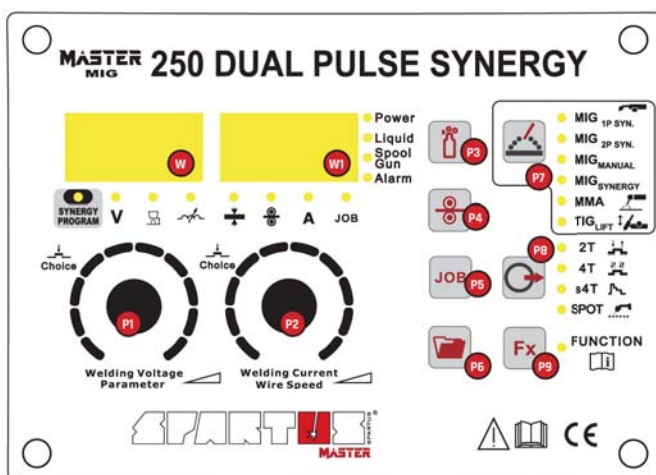


● TECHNICAL PARAMETERS

Input	~3× 400V ± 10% 50 / 60 Hz
Welding current MIG [A]	15 – 250
Duty cycle MIG [%]	60(250A) 100(195A)
MIG PARAMETERS	
Output working voltage MIG [V]	14.8 – 26.5
Wire feeding speed [m/min]	1.5 – 24
Wire feeder	built-in, 4-roll gear
Wire spool [kg]/[mm]	≤ 15 / Ø300
Wire diameter Ø [mm]	0.8 / 1.0 / 1.2
Synergic MIG/MAG programs	✓
1P – with pulse	20 programs
2P – with dual pulse	20 programs
SYNERGY – without pulse	17 programs
Pulsation/dual pulsation	✓
Dual pulse regulation	✓
dPC (pulse current delta) [%]	10 – 200
FdP (Frequency 2P) [Hz]	0.5 – 3.0
dut (double pulsation width) [%]	10 – 90
bAL (arc length of the current)	-10 – +10
SPOT welding	✓
Welding inductance adjustment	Wave Control (-10 – +10)
Operating mode	2T/4T/s4T
Operating mode s4T	✓
SCP (initial current) [%]	10 – 200
SAL (initial current arc length)	-10 – +10

ECP (final current) [%]	10 – 200
EAL (final current arc length)	-10 – +10
SFt (Slow Feed)	0 – 10
Burn Back	0 – 10
Pre-Gas/Post-Gas [s]	0 – 5 / 0 – 10
SPOOL GUN	✓
TIG PARAMETERS	
TIG welding current [A]	10 – 250
Arc ignition	Lift
dSL (time of current descent) [s]	0 – 10
MMA PARAMETERS	
Welding with MMA coated electrode	✓
MMA welding current [A]	10 – 250
ACF / HSt (Arc Force/Hot Start)	0 – 10 / 0 – 10
VRD	15.5
OTHERS	
Current consumption [A]	MIG 15.1 / MMA 18.2 / TIG 13.3
Power factor (cosφ)	0.70
Efficiency η [%]	85
Insulation class	H
Protection class	IP23
Weight [kg]	62.6
Dimensions [mm]	1100 x 580 x 700

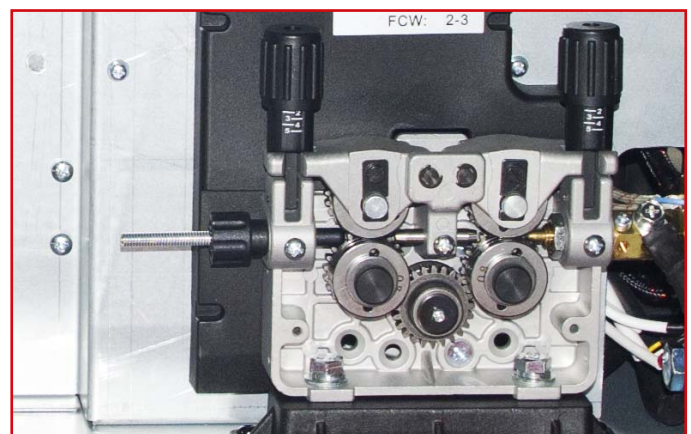
● FUNCTION PANEL



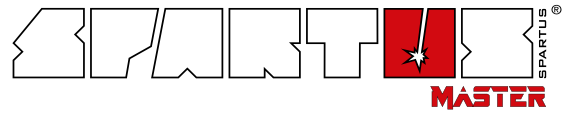
- P1 Welding adjustment knob for the W display
- P2 Welding adjustment knob for the W1 display
- P3 Gas test button
- P4 Button for inserting the welding wire into the MIG Gun
- P5 Selecting the operating mode
- P6 Device memory
- P7 Selection of welding mode
- P8 Selecting the operating mode
- P9 Selection of advanced process functions

● WIRE FEEDER

Professional four-roll wire feeder, which allows you to work with a long welding handle regardless of the type of wire used. Despite the small compact size and weight, the device is compatible with standard spools with welding wire D200 and D300 weighing up to 15kg.



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● STANDARD EQUIPMENT:

- cooler
- driving set
- work clamp 3m
- gas hose
- user's manual



● EQUIPMENT OF THE PACKAGE:

- cooler
- driving set
- MIG torch SPARTUS® SPM 241LCD
- electrode holder 3m
- work clamp 3m
- gas hose
- user's manual



parameter display
and control in the handle



 3, 4 or 5m

Included in the package price is a choice of SPARTUS® MIG torch of any length: 3, 4 or 5 m.

ORIGINAL, POLISH SPARTUS® TORCH

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SPARTUS® MIG

SPARTUS® TIG