

# ALUMIG-250P

Synergy, Pulse and Double Pulse MIG



## Quick Specs

- ◆ **Processes:**  
MIG/MAG, Flux-Cored,  
Pulse MIG,  
Double Pulse MIG,  
MMA(Stick)
- ◆ **Input Power:**  
ALUMIG-250P:  
200-240V/1-PH/50-60Hz
- ◆ **Rated Output at 40°C (104°F):**  
ALUMIG-250P: 250A/26.5V/60%
- ◆ **Applications:**  
Metal Fabrication,  
Maintenance and Repair,  
Auto Body,  
Light Industrial

## TOP Features:

- ✓ **Multi-Process capable** – Welds MIG, flux-cored, stick, pulsed MIG, and advanced process of Pulse-On-Pulse.
- ✓ **Pulse MIG** – Cost savings, better quality, improved productivity and easier operation.
- ✓ **Aluminum Pulse Process** – Welds 4XXX (AlSi wires) and 5XXX (AlMg wires) series aluminum for superior quality welding.
- ✓ **Double Pulse** – Delivers a stacked dime appearance when welding aluminum.
- ✓ **Dynamic control** – Set arc control to crisp or soft depending on your preference and application.
- ✓ **Synergic control** – Set weld procedures with one control, simple and easy to operate.
- ✓ **Synergic MIG** provides communication between power source, feeder and gun. As wire speed increases or decreases, the arc voltage also increases or decreases to maintain a constant welding arc.
- ✓ **Special Trigger Hold (S4T)** allows to hold the preset Initial Current by user until get a successful Arc Start on Aluminumplate.
- ✓ **Featured Wave-form control system:** Maintains a stable, smooth arc for short arc welding on steel. Improved penetration on thicker aluminum sections.
- ✓ **Burn Back function.**
- ✓ **Fast, precise, clean arc ignition and arc ending.**
- ✓ **10 channels memory capacity.**

## Synergy MIG

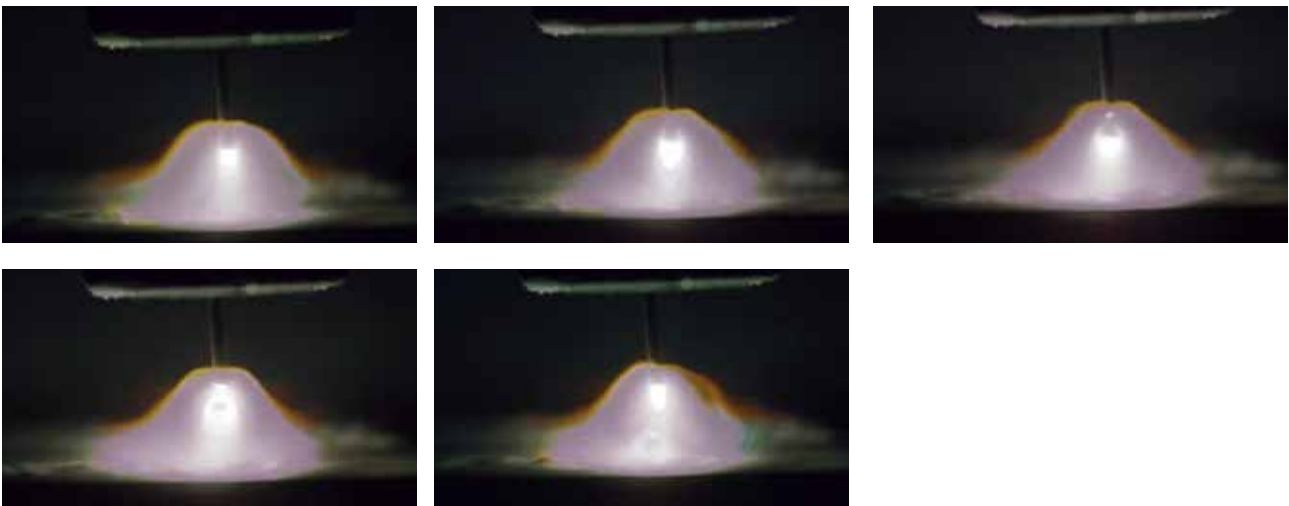
The synergic operation of the machine makes it easy to use, even for the beginning welder. Simply set wire type and diameter, then choose a wire speed. Now you're off to weld! As wire speed increases/decreases, the arc voltage also increases/decreases to maintain a constant welding arc.

2. Voltage is automatically set.

1. Use one knob to set procedures.



## Pulse MIG



The Pulsed MIG process works by forming one droplet of molten metal at the end of the electrode per pulse. Then, just the right amount of current is added to push that one droplet across the arc and into the puddle. The transfer of these droplets occurs through the arc, one droplet per pulse.

### Advantage:

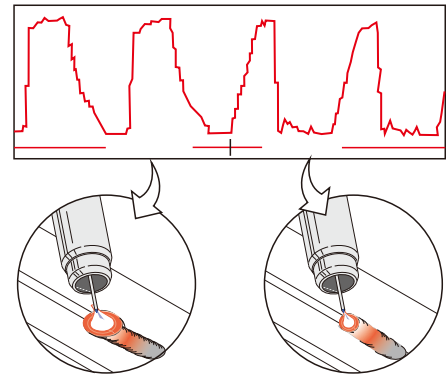
- ◆ Absent or very low levels of spatter.
- ◆ More resistant to lack of fusion defects than other modes of GMAW metal transfer.
- ◆ Excellent weld bead appearance.
- ◆ Reduced levels of heat induced distortion.
- ◆ Ability to weld out-of-position.
- ◆ Lower hydrogen deposit.
- ◆ Reduces the tendency for arc blow.
- ◆ Lends itself to robotic and hard automation applications.

## Double Pulse MIG

Using Waveform Control Technology, the welding machine alternates between high and low energy pulses. This combination of high and low pulses produces the "rippled" bead appearance. The high energy pulses provide a hotter arc (longer arc duration), which improves cleaning action at the base material. The low energy pulses allow the weld puddle to cool, which controls the heat input for good penetration.

### Advantage:

- ◆ Minimal distortion, even when gap conditions and wire placement vary.
- ◆ Outstanding control of arc characteristics, making it easier to produce excellent welds.
- ◆ Rippled bead appearance requires no weaving to produce a uniform bead.
- ◆ Controls the arc length and heat input together for excellent penetration profile.
- ◆ Controls the arc heat, making it ideal for welding thinner materials.



## Technical Specifications

Item No	ALUMIG-250P
Rated Input Voltage	1PH ~ 230V ±15%
Max. Load Power Capacity	10.35KVA
Rated Duty Cycle(40°C) 60%	MIG: 250A/26.5V
	MMA: 250A/28V
100%	MIG: 200A/24V
	MMA: 200A/28V
Welding Current/Voltage Range	MIG: 10A/14.5V~250A/26.5V
	MMA:10A/20.4V~250A/30V
Open Circuit Voltage	55V
Power Factor	0.8
Efficiency	80%
Pre-Gas Time	0.1-15S
Flow-Gas Time	0.1-15S
Wire-feed Mechanism	4 Rollers
Wire-feed Speed Range	0~25m/ min
Wire Spool Capacity	300mm (15kg)
Filler Wires Ø (mm) Fe, Ss:	0.6~1.2 mm
FLUX CORED:	0.9~1.2 mm
Al:	0.8~1.2 mm
Dimension	790x250x650mm
Weight	32KG

# Accessories

## Standard accessories

**MIG-24**



Gas nozzle

Technical data (EN 60 974-7):

Rating:	250 A CO <sub>2</sub>
	220 A mixed gas M21 (DIN EN ISO 14175)
Duty cycle:	60%
Wire size:	∅ 0.8–1.2 mm



Contact tip



Contact tip holder



Gas diffuser



Electrode holder with cable 2M  
Earth clamp with cable 2M

## Optional accessories

**BINZEL MB EVO PRO 24**



Technical data (EN 60 974-7):

Rating:	250 A CO <sub>2</sub>
	220 A mixed gas M21 (DIN EN ISO 14175)
Duty cycle:	60%
Wire size:	∅ 0.8–1.2 mm



Argon gas regular  
or CO<sub>2</sub> gas regular with heater



Push-pull Troch:  
QTLB-24KD/36KD