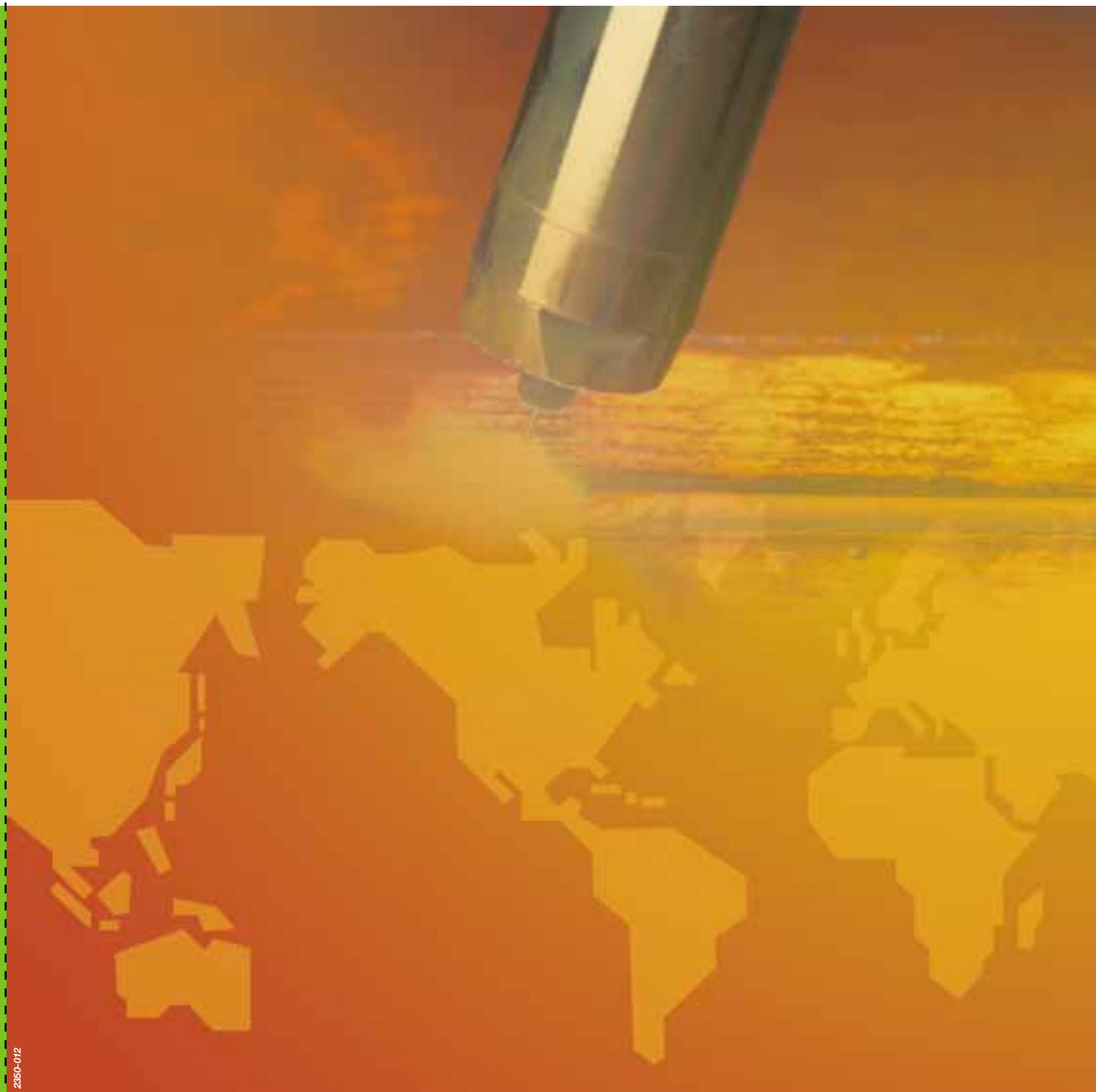


Chapter 3

MIG/MAG welding

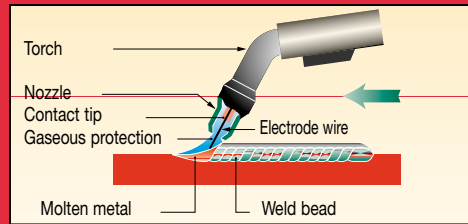


MIG/MAG welding

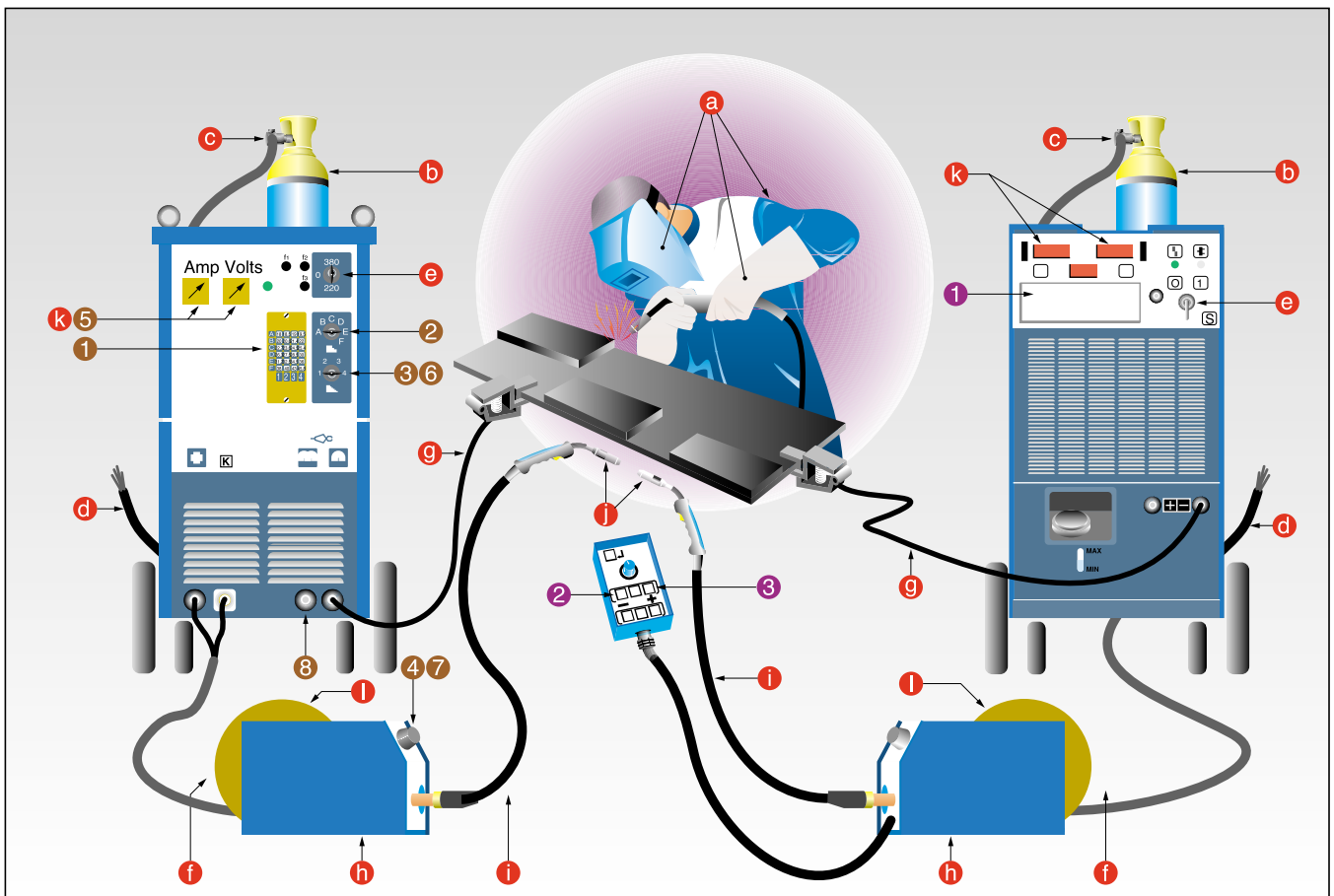


2000-489

The transfer of metal



MIG/MAG welding overview and selection guide



CLASSICAL SET

Setting by stepped increments

Sequence of setting:

- 1 - Approximate determination of arc voltage
- 2 - Approximate setting of arc voltage
- 3 - Fine setting of arc voltage
- 4 - Wire speed setting
- 5 - I and V meters while welding (an option with certain sets)
- 6 - Arc voltage correction
- 7 - Wire speed control correction
- 8 - Selection of the inductance

a - Welder's protection

b - Gas

c - Pressure regulator/flowmeter

d - Primary power supply

e - On/off switch

f - Harness and sheath

g - Earth cable + clamp

h - Wire feeder

i - Torch cable

j - Torch

k - Display of parameters

l - Wire reel

SYNERGIC SET

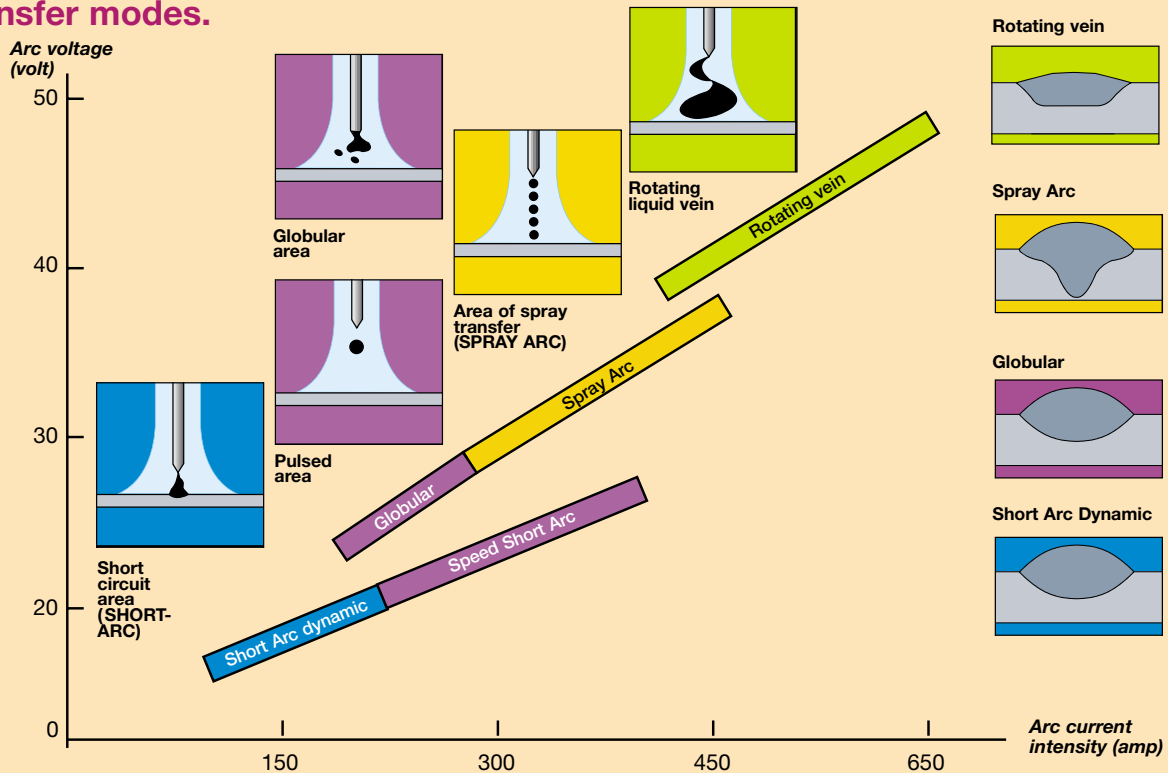
Setting by single button

Sequence of setting:

- 1 - Pre-display:
 - wire type
 - gas
 - wire diameter
 - with or without pulse
- 2 - Wire speed setting (approximate welding current is displayed)
- 3 - Fine adjustment of the arc length (using arc voltage)

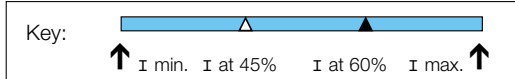
MIG/MAG welding

MIG/MAG welding process. Transfer modes.



Selection criteria for MIG/MAG power sources

Name of product	Power supply	Setting mode		Complementary processes		Welding current (Ampere)						
		switch	continuous	MMA	pulsed MIG	100	200	300	400	500	600	
MINICITO 1700	Single-phase	✓	-	-	-	▲						
MINICITO 2000i	Single-phase	-	✓	✓	-		▲					
CITOLINE 1700 M	Single-phase	✓	-	-	-	▲						
CITOLINE 2000 M	Single-phase	✓	✓	✓	✓	▲						
CITOLINE 2500 M / MS	Single-phase	✓	✓	✓	✓		▲					
CITOLINE 2000 T	Three-phase	✓	-	-	-		▲					
CITOLINE 2500 T	Three-phase	✓	-	-	-		▲					
CITOLINE 3000 T	Three-phase	✓	-	-	-			▲				
CITOLINE 3500 T	Three-phase	✓	-	-	-			▲				
CITOLINE 3000 TS	Three-phase	✓	✓	✓	✓			▲				
CITOLINE 3500 TS	Three-phase	✓	-	-	-			▲				
CITOLINE 4500 TS / TSW	Three-phase	✓	-	-	-				▲			
CITOMAG 400 S (W) / S MV (W)	Three-phase	-	✓	-	-				▲			
CITOMAG 500 S (W)	Three-phase	-	✓	-	-					▲		
CITOMIG 300 XP / XP S	Three-phase	✓	-	-	-			▲				
CITOMIG 400 XP / XP W	Three-phase	✓	-	-	-				▲			
CITOMIG 400 XP S / XP SW	Three-phase	✓	-	-	-					▲		
CITOMIG 500 XP S / XP SW	Three-phase	✓	-	-	-						▲	
CITOPULS MX 320 / MXW 320	Three-phase	-	✓	✓	✓						▲	
CITOPULS MXW 420	Three-phase	-	✓	✓	✓							▲
CITOWAVE MXW 280	Three-phase	-	✓	✓	✓							▲
CITOWAVE MXW 400	Three-phase	-	✓	✓	✓							▲
CITOWAVE MXW 500	Three-phase	-	✓	✓	✓							▲



MIG/MAG welding

MIG: Metal Inert Gas

MIG welding uses a continuous electrode for filler metal and an externally supplied inert gas for shielding.

MAG: Metal Active Gas

MIG welding uses a continuous electrode for filler metal and an externally supplied active gas for shielding.

MIG pulse: the current varies during welding, the power source provides a very accurate "shape wave". The pulse is above all used for steel, stainless steel and light alloys.

MIG Synergic:

The welding parameters are programmed in the power source set for a common evolution depending on a predefined law. One simple setting is needed which facilitates the use of these machines and improves the welding quality.

2 times mode:

The welding starts when the trigger of the torch is pulled and stops when the trigger is released.

4 times mode:

The pre-gas starts when the trigger is pulled and the welding starts when the trigger is released. With the next pull on the trigger, the welding stops and the post gas stays active until the trigger is released.

Spot mode

The power source starts to weld when the trigger is pulled. The welding stops automatically after a pre-set delay.

Intermittence mode

This a point mode which is repeatable. If the pulled trigger is maintained, welding will be repeated after another interval time (can be adjusted).

Speed regulation:

The welding wire is electronically regulated which ensures a constant feed of the wire.

Burn back:

This solves the problem of wire sticking in the molten pool on completion of the arc weld cycle.

Soft start:

Firstly the wire advances slowly just up to the short circuit point and the arc starts. The value of the wire speed is programmed in the set up.

OPTI' system:

Optimisation of welding parameters depending on needs of the welder (available only on CITOMAG installations).

A.N.D

Device avoiding arc ruptures (available only on CITOMAG installations).

Arc progressive extinction or crater filler

Allows correct finishing of the weld with the suppression of the crater at the end of the welding due to a progressive extinction of the arc (CITOPULS -CITOWAVE) or by levels (on CITOMAG installations).

Protection against Ball effect

At the end of the welding cycle in short arc circuit transfer, this device avoids the formation of the ball at the end of the wire. This contributes greatly to arc striking (on CITOMAG - CITOPULS and CITOWAVE installations).



Selection criteria for MIG/MAG power sources

Name of product	Wire diameter (mm)															Wire feeder		Weight (kg)	
	Steel and stainless steel					Aluminium					Cored wire					Number of rollers	Built-in		
	0.6	0.8	1.0	1.2	1.6	0.8	1.0	1.2	1.6	2.4	0.8	0.9	1.0	1.2	1.6				2.4
MINICITO 1700	■	■	-	-	-	-	-	-	-	-	-	-	■	-	-	-	2	yes	27
MINICITO 2000i	■	■	■	-	-	-	■	-	-	-	-	-	■	-	-	-	2	yes	29
CITOLINE 1700 M	■	■	■	-	-	-	■	-	-	-	-	-	■	-	-	-	2	yes	38.5
CITOLINE 2000 M	■	■	■	-	-	-	■	-	-	-	-	-	■	-	-	-	4	yes	52
CITOLINE 2500 M / MS	■	■	■	-	-	-	■	■	-	-	-	-	■	■	-	-	4	yes/no	86
CITOLINE 2000 T	■	■	■	-	-	-	■	-	-	-	-	-	■	-	-	-	4	yes	71
CITOLINE 2500 T	■	■	■	-	-	-	■	■	-	-	-	-	■	■	-	-	4	yes	80
CITOLINE 3000 T	-	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	yes	96
CITOLINE 3500 T	-	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	yes	116
CITOLINE 3000 TS	-	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	no	120
CITOLINE 3500 TS	-	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	no	125
CITOLINE 4500 TS / TSW	-	■	■	■	-	-	■	■	■	-	-	-	■	■	■	-	4	no	135
CITOMAG 400 S (W) / S MV (W)	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	-	4	no	143
CITOMAG 500 S (W)	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	■	4	no	200
CITOMIG 300 XP / XP S	■	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	yes/no	101
CITOMIG 400 XP / XP W	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	-	4	yes/no	161
CITOMIG 400 XP S / XP SW	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	-	4	yes/no	161
CITOMIG 500 XP S / XP SW	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	■	4	no	201
CITOPULS MX 320 / MXW 320	■	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	no	75/91
CITOPULS MXW 420	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	-	4	no	91
CITOWAVE MXW 280	■	■	■	■	-	-	■	■	-	-	-	-	■	■	-	-	4	yes	76
CITOWAVE MXW 400	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	-	4	no	91
CITOWAVE MXW 500	-	■	■	■	■	-	■	■	■	-	-	-	■	■	■	■	4	no	91

MINICITO and CITOLINE M

The MINICITO 1700 and the MINICITO 2000i are portable MIG/MAG units for the welding of solid wires and flux-cored wires. With the CITOLINE range, an extremely stable arc will be obtained due to the self-regulation of the wire feed speed, the 4 roller feeding system (2 rollers for CITOLINE 1700 M) and voltage regulation.

1
MINICITO 1700

7 product advantages:

- polarity reversal
- "on site" concept
- suitable for welding with self shielded flux-cored wires (without gas)
- delivered ready to use
- 2 roller plate
- 4 step voltage adjustment
- 1 choke output



2007-231


To order

- **Standard equipment:**
 - 1 power source
 - 1 earth cable L = 3 m with clamp
 - 1 primary cable L = 2.4 m with SCHUKO plug
 - 1 spool adapter for 1 kg reels
 - 1 accessory kit for solid wires 0.6-0.8 mm
- **Add-ons:**
 - Torch M 141 3 m
 - Cat. no. W 000 345 123

2
MINICITO 2000i

8 product advantages:

- Multi-processes: MIG / TIG / MMA
- digital display
- 9 stored welding programs
- possibility to memorise another 11 welding programs
- polarity reversal
- suitable for welding with self-shielded flux-cored wires (without gas)
- 2T/4T and spot modes
- 2 roller plate



2007-665

To order

- **Standard equipment:**
 - 1 power source
 - 1 connected primary cable L = 4 m
 - 1 earth cable L = 4 m with clamp
 - 1 equipped gas hose 2 m
 - 1 accessory kit for solid wire 0.6 - 0.8 mm
 - 1 additional roller kit 1.0 - 1.2 mm
- **Add-ons:**
 - WMT 25 A torch 3 m
 - Cat. no. W 000 010 602
 - WMT 25 A torch 4 m
 - Cat. no. W 000 010 603
- **Option:**
 - 15 kg spool support
 - Cat. no. W 000 253 322

3
CITOLINE 1700 M

12 product advantages:

- specialised for thin sheet
- user-friendly front panel
- 2T and spot modes
- European connector
- 2 roller plate
- 6 step voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for 15 kg reels
- polarity reversal
- 1 choke output



2007-124

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 cylinder holder
 - 1 connected primary cable L = 2.3 m with SCHUKO plug
 - 1 earth cable with clamp (not mounted)
 - 1 equipped gas hose 2 m
 - 1 accessory kit for solid wires 0.6-0.8 mm
 - 1 additional rollers kit 1.0 - 1.2 mm
 - 1 metallic spool adapter
- **Add-ons:**
 - WMT 15 A torch 3 m
 - Cat. no. W 000 010 600
 - WMT 15 A torch 4 m
 - Cat. no. W 000 010 601

Technical specifications	1 MINICITO 1700	2 MINICITO 2000i	3 CITOLINE 1700 M
Power supply single-phase	230 V ± 10% - 50-60 Hz	230 V ± 10% - 50-60 Hz	230 V ± 10% - 50-60 Hz
Primary consumption at I max.	21 A	35 A	24 A
Effective consumption	11 A	21 A	7.5 A
Open circuit voltage	18 - 32 V	70 V (MMA) - 50 V (MIG) - 25 V (TIG)	18 - 32 V
Welding current	30 - 140 A	20 - 180 A (MMA) / 30 - 200 A (MIG) / 5 - 200 A (TIG)	30 - 170 A
Protection class	IP 21	IP 23	IP 21
Insulation class	H	H	H
Duty cycle at 100%	60 A	115 A (MMA) - 125 A (MIG, TIG)	60 A
10 min. cycle at 60%	75 A	140 A (MMA) - 155 A (MIG, TIG)	75 A
(at 40 °C) at 35%	120 A (at 25%)	180 A (at 40% MMA) - 200 A (MIG, TIG)	140 A (at 18%)
Number of rollers	2	2	2
Wire diameters	0.6 - 0.8 mm	0.6 - 1.0 mm	0.6 - 1.0 mm
Dimensions W x H x L)	260 x 430 x 400 mm	235 x 470 x 570 mm	440 x 670 x 750 mm
Net weight	27 kg	29 kg	38.5 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	Direct connection	WMT family	WMT family

CITOLINE M/MS ranges

1

CITOLINE 2000 M

10 product advantages:

- user-friendly front panel
- 2T/4T and spot modes
- 4 roller plate
- polarity reversal
- suitable for welding with self shielded flux-cored wires without gas
- 8 step voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- 1 choke output



2007-587

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 cylinder holder
 - 1 connected primary cable L = 3.4 m with plug
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8 mm
 - 1 metallic spool adapter Cat. no. W 000 261 963
- **Add-ons:**
 - WMT 25 A torch 3 m Cat. no. W 000 010 602
 - WMT 25 A torch 4 m Cat. no. W 000 010 603
- **Options:**
 - A-V digital kit Cat. no. W 000 352 093
 - Torch arm rest Cat. no. W 000 261 845

2

CITOLINE 2500 M

10 product advantages:

- user-friendly front panel
- 2T/4T and spot modes
- 4 roller plate
- polarity reversal
- suitable for welding with self shielded flux-cored wires without gas
- 12 step fine voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- 1 choke output



2007-163

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 cylinder holder
 - 1 connected primary cable L = 4 m
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8-1.0 mm
 - 1 metallic spool adapter Cat. no. W 000 261 964
- **Add-ons:**
 - WMT 25 A torch 3 m Cat. no. W 000 010 602
 - WMT 25 A torch 4 m Cat. no. W 000 010 603
- **Options:**
 - A-V digital kit Cat. no. W 000 352 093
 - Torch arm rest Cat. no. W 000 261 845

3

CITOLINE 2500 MS

11 product advantages:

- power source with pivot foot to allow easy installation of the wire feeder
- separate wire feeder with digital display
- kit accessory for solid wires 0.8 - 1.2 mm
- 2T/4T and spot modes
- 4 roller plate
- 12 step fine voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- inclined wire feeder front panel for a complete view
- 1 choke output



2007-172

To order

- **Standard equipment:**
 - 1 power source with handle and wheels to move easily in the working area
 - 1 cylinder holder
 - 1 connected primary cable L = 4 m
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 metallic spool adapter Cat. no. W 000 261 972
- **Add-ons:**
 - Wire feeder DV 4004 CTL 5 m Cat. no. W 000 262 182
 - Wire feeder DV 4004 CTL 10 m Cat. no. W 000 262 183
 - WMT 25 A torch 3 m Cat. no. W 000 010 602
 - WMT 25 A torch 4 m Cat. no. W 000 010 603
- **Options:**
 - A-V digital kit for power source Cat. no. W 000 352 093
 - Torch arm rest Cat. no. W 000 261 846

Technical specifications	1 CITOLINE 2000 M	2 CITOLINE 2500 M	3 CITOLINE 2500 MS
Power supply single-phase	230 V ± 10% - 50 Hz	230 V ± 10% - 50 Hz	230 V ± 10% - 50 Hz
Primary consumption at I max.	32 A	54 A	54 A
Effective consumption	14.3 A	29.6 A	29.6 A
Open circuit voltage	18 - 35 V	20 - 53 V	20 - 53 V
Welding current	35 - 180 A	32 - 250 A	32 - 250 A
Protection class	IP 23	IP 23	IP 23
Insulation class	H	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 85 A at 60% 110 A at 30% 180 A (at 20%)	140 A 180 A 250 A	140 A 180 A 250 A
Number of rollers	4	4	4
Wire diameters	0.6 - 1.0 mm	0.8 - 1.0 - (1.2) mm	0.8 - 1.0 - (1.2) mm
Dimensions (W x H x L)	500 x 870 x 950 mm	500 x 870 x 950 mm	500 x 870 x 950 mm
Net weight	52 kg	86 kg	86 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	WMT family	WMT family	WMT family

CITOLINE T range

Basic equipment, compact version (T):

- units with digital display as standard on CITOLINE 3000 T / 3500 T, optional for CITOLINE 2000 M / 2500 M / 2000 T / 2500 T,
- units equipped with cooled wire feed and purge gas functions.

4

CITOLINE 2000 T

11 product advantages:

- user-friendly front panel
- specialised for thin sheets
- 2T/4T and spot modes
- 4 roller plate
- inversion of polarity
- 7 step voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- 1 choke output



2007-167

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 ergonomic lower cylinder holder
 - 1 upper cylinder support with torch
 - 1 connected primary cable L = 3 m with plug
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8-1.0 mm
 - 1 metallic spool adapter
- Cat. no. W 000 261 966
- **Add-ons:**
 - WMT 25 A torch 3 m
 - Cat. no. W 000 010 602
 - WMT 25 A torch 4 m
 - Cat. no. W 000 010 603
- **Options:**
 - A-V digital kit
 - Cat. no. W 000 352 093
 - Torch arm rest
 - Cat. no. W 000 261 845

5

CITOLINE 2500 T

11 product advantages:

- user-friendly front panel
- specialised for thin sheets
- 2T/4T and spot modes
- 4 roller plate
- inversion of polarity
- 10 steps voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- 2 choke outputs



2007-176

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 ergonomic lower cylinder holder
 - 1 upper cylinder support with torch rest
 - 1 connected primary cable L = 3 m with plug
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8-1.0 mm
 - 1 metallic spool adapter
- Cat. no. W 000 261 967
- **Add-ons:**
 - WMT 25 A torch 3 m
 - Cat. no. W 000 010 602
 - WMT 25 A torch 4 m
 - Cat. no. W 000 010 603
- **Options:**
 - A-V digital kit
 - Cat. no. W 000 352 093
 - Torch arm rest
 - Cat. no. W 000 261 845

Technical specifications	4 CITOLINE 2000 T	5 CITOLINE 2500 T
Power supply three-phase	230 /400 V ± 10% - 50 Hz	230 /400 V ± 10% - 50 Hz
Primary consumption at I max.	19 - 11 A	27 - 16 A
Effective consumption	10.4 - 6 A	14.8 - 8.5 A
Open circuit voltage	18 - 35 V	18 - 40 V
Welding current	27 - 200 A	35 - 250 A
Protection class	IP 23	IP 23
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)		
at 100%	110 A	140 A
at 60%	140 A	170 A
at 30%	200 A	250 A
Number of rollers	4	4
Wire diameter	0.6 - 1.0 mm	0.8 - 1.0 - (1.2) mm
Dimensions (L x W x H)	500 x 870 x 950 mm	500 x 870 x 950 mm
Net weight	71 kg	80 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	WMT family	WMT family

CITOLINE T range

Basic equipment, compact version (T):

- units with digital display as standard on CITOLINE 3000 T / 3500 T, optional for CITOLINE 2000 M / 2500 M / 2000 T / 2500 T,
- units equipped with cooled wire feed and purge gas functions.

6

CITOLINE 3000 T

11 product advantages:

- user-friendly front panel
- digital meter
- 2T/4T and spot modes
- 4 roller plate
- inversion of polarity
- 2 x 7 step / voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- 2 choke outputs



2007-179

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 ergonomic lower cylinder holder
 - 1 upper cylinder support with torch rest
 - 1 connected primary cable L = 3 m with plug
 - 1 earth cable L = 3 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8-1.0 mm
 - 1 metallic spool adapter
- **Add-ons:**
 - WMT 25 A torch 3 m
Cat. no. W 000 010 602
 - WMT 25 A torch 4 m
Cat. no. W 000 010 603
 - WMT 36 A torch 3 m
Cat. no. W 000 010 605
 - WMT 36 A torch 4 m
Cat. no. W 000 010 606
- **Options:**
 - Torch arm rest
Cat. no. W 000 261 845

7

CITOLINE 3500 T

11 product advantages:

- user-friendly front panel
- digital meter
- 2T/4T and spot modes
- 4 roller plate
- inversion of polarity
- 3 x 7 step / voltage adjustment
- 3 choke outputs
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas



2007-185

To order

- **Standard equipment:**
 - 1 power source with wheels
 - 1 ergonomic lower cylinder holder
 - 1 upper cylinder support with torch rest
 - 1 connected primary cable L = 4 m with plug
 - 1 earth cable L = 4 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8 -1.2 mm
 - 1 metallic spool adapter
- **Add-ons:**
 - WMT 36 A torch 3 m
Cat. no. W 000 010 605
 - WMT 36 A torch 4 m
Cat. no. W 000 010 606
- **Options:**
 - Torch arm rest
Cat. no. W 000 261 845

Technical specifications	6 CITOLINE 3000 T	7 CITOLINE 3500 T
Power supply three-phase	230/400 V ± 10% - 50 Hz	230/400 V ± 10% - 50 Hz
Primary consumption at I max.	33 - 19 A	41,5 - 24 A
Effective consumption	19,5 - 11,3 A	25 - 14,2 A
Open circuit voltage	18 - 45 V	18 - 45 V
Welding current	35 - 300 A	35 A - 350 A
Protection class	IP 23	IP 23
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 180 A at 60% 230 A at 35% 300 A	210 A 270 A 350 A
Number of rollers	4	4
Wire diameter	0.8 - 1.2 mm	0.8 - 1.2 mm
Dimensions (L x W x H)	620 x 940 x 1000 mm	620 x 940 x 1000 mm
Net weight	96 kg	116 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	WMT family	WMT family

CITOLINE TS range

Basic equipment, separate version (TS):

- wire feeders with harness of length 5 or 10 m (other lengths on demand),
- wire feeder with harness 10 m and cooling unit for the water cooled version of CITOLINE 4500 TS (W).

1

CITOLINE 3000 TS

13 product advantages:

- power source with self / protected safety switch
- pivot foot to allow easy installation of the wire feeder
- separate wire feeder with digital display
- 1 accessory kit for solid wires 0.8-1.2 mm
- 2T/4T and spot modes
- 4 roller
- 2 x 7 step / voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- inclined wire feeder front panel for a complete view
- 2 choke outputs

To order

Standard equipment:

- 1 power source with handle and wheels
- 1 ergonomic lower cylinder holder
- 1 upper cylinder support with torch rest
- 1 connected primary cable L = 3 m long
- 1 earth cable L = 5 m with clamp and DINSE connector
- 1 equipped gas hose 2 m long
- 1 metallic spool adapter

Cat. no. W 000 261 981

Add-ons:

- Wire feeder DV 4004 CTL 5 m
Cat. no. W 000 262 182
- Wire feeder DV 4004 CTL 10 m
Cat. no. W 000 262 183
- Weldline WMT 25 A torch 3 m
Cat. no. W 000 010 602
- WMT 25 A torch 4 m
Cat. no. W 000 010 603
- WMT 36 A torch 3 m
Cat. no. W 000 010 605
- WMT 36 A torch 4 m
Cat. no. W 000 010 606

Options:

- A-V digital kit for power source
Cat. no. W 000 352 093
- Torch arm rest
Cat. no. W 000 261 846



2007-182

2

CITOLINE 3500 TS

13 product advantages:

- power source with self protected safety switch
- pivot foot to allow easy installation of the wire feeder
- separate wire feeder with digital display
- 1 accessory kit for solid wires 0.8-1.2 mm
- 2T/4T and spot modes
- 4 roller
- 3 x 7 step voltage adjustment
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- inclined wire feeder front panel for a complete view
- 3 choke outputs

To order

Standard equipment:

- 1 power source with handle and wheels
- 1 ergonomic lower cylinder holder
- 1 upper cylinder support with torch rest
- 1 connected primary cable L = 3 m long
- 1 earth cable L = 5 m with clamp and DINSE connector
- 1 equipped gas hose 2 m long
- 1 metallic spool adapter

Cat. no. W 000 261 974

Add-ons:

- Wire feeder DV 4004 CTL 5 m
Cat. no. W 000 262 182
- Wire feeder DV 4004 CTL 10 m
Cat. no. W 000 262 183
- WMT 36 A torch 3 m
Cat. no. W 000 010 605
- WMT 36 A torch 4 m
Cat. no. W 000 010 606

Options:

- A-V digital kit for power source
Cat. no. W 000 352 093
- Torch arm rest
Cat. no. W 000 261 846



2007-598

Technical specifications	1 CITOLINE 3000 TS	2 CITOLINE 3500 TS
Power supply three-phase	230 /400 V ± 10% - 50 Hz	230/400 V ± 10% - 50 Hz
Primary consumption at I max.	34 - 19.5 A	42 - 24 A
Effective consumption	20.1 - 11.5 A	25 - 14.2 A
Open circuit voltage	18 - 42 V	18 - 45 V
Welding current	35 - 300 A	35 - 350 A
Protection class	IP 23	IP 23
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 180 A at 60% 230 A at 35% 300 A	210 A 270 A 350 A
Number of rollers	4	4
Wire diameter	0.8 - 1.2 mm	0.8 - 1.2 mm
Dimensions (L x W x H)	500 x 865 x 900 mm	500 x 865 x 900 mm
Net weight	120 kg	125 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	WMT family	WMT family

CITOLINE TS

Wire feeder wear parts

3

CITOLINE 4500 TS (W)

13 product advantages:

- power source with self protected safety switch
- pivot foot to allow easy installation of the wire feeder
- separate wire feeder with digital display
- 1 accessory kit for solid wires 0.8-1.2 mm
- 2T/4T and spot modes
- 4 roller
- 3 x 10 step voltage adjustment
- 3 choke outputs
- burn back time
- slope up wire speed
- thermal protection
- suitable for welding with self shielded flux-cored wires without gas
- inclined wire feeder front panel for a complete view

To order

Standard equipment:

- 1 power source with handle and wheels
 - 1 ergonomic lower cylinder holder
 - 1 upper cylinder support with torch rest
 - 1 connected primary cable L = 4 m
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 metallic spool adapter
- Cat. no. W 000 261 975

Add-ons:

Accessories for air cooled set

- Wire feeder DV 4004 CTL 5 m
Cat. no. W 000 262 182
- Wire feeder DV 4004 CTL 10 m
Cat. no. W 000 262 183
- Weldline WMT 36 A torch 3 m
Cat. no. W 000 010 605
- Weldline WMT 36 A torch 4 m
Cat. no. W 000 010 606

Accessories for water cooled set

- Wire feeder (heavy duty)
DV 4004 CTL W - 42 V - 10 m
Cat. no. W 000 271 010
- Wire feeder DV 4004 CTLW 10 m
Cat. no. W 000 262 184
- Cooler unit
Cat. no. W 000 262 188
- WMT 500 A torch 3 m
Cat. no. W 000 010 608
- WMT 500 A torch 4 m
Cat. no. W 000 010 609

Options:

- A-V digital kit for power source
Cat. no. W 000 352 093
- Torch arm rest
Cat. no. W 000 261 846
- Anti freeze liquid 1 L
Cat. no. W 000 227 236



2007-191

MINICITO 2000i (feeder 2 rollers)

Rollers for solid wires	Ø 0.6 - 0.8 mm	W 000 352 037
	Ø 1.0 - 1.2 mm	W 000 352 036
Rollers for aluminium wire	Ø 1.0 - 1.2 mm	W 000 270 323
Rollers for flux cored wire	Ø 1.0 - 1.2 mm	W 000 270 320
Entry wire guide		W 000 227 907

MINICITO 1700 - CITOLINE 1700 M (feeder 2 rollers)

Entry wire guide		W 000 231 810
A Roller for solid wires	Ø 0.6 - 0.8 mm	W 000 232 110
	Ø 1.0 - 1.2 mm	W 000 232 112

CITOLINE RANGE COMPACT / SEPARATE (feeder 4 rollers)

Entry wire guide		W 000 233 472
Middle wire guide		W 000 252 183
Exit wire guide		W 000 269 661
B Kit 2 Rollers for solid wire	Ø 0.6 mm	W 000 050 096
	Ø 0.8 mm	W 000 050 097
	Ø 1.0 mm	W 000 050 098
	Ø 1.2 mm	W 000 050 099
B Kit 2 Rollers for aluminium wire	Ø 1.6 mm	W 000 218 767
	Ø 0.8 mm	W 000 050 100
	Ø 1.0 mm	W 000 050 101
B Kit 2 Rollers for flux-cored wires	Ø 1.2 mm	W 000 050 102
	Ø 1.0 - 1.2 mm	W 000 264 870
	Ø 1.4 - 1.6 mm	W 000 265 883



2000-500

Technical specifications		3 CITOLINE 4500 TS / TS W
Power supply three-phase		230/400 V ± 10% - 50 Hz
Primary consumption at I max.		60 - 34.5 A
Effective consumption		35.5 - 20.5 A
Open circuit voltage		19 - 54 V
Welding current		51 - 450 A
Protection class		IP 23
Insulation class		H
Duty cycle	at 100%	270 A
10 min. cycle	at 60%	345 A
(at 40 °C)	at 35%	450 A
Number of rollers		4
Wire diameter		0.8 - 1.2 - (1.6) mm
Dimensions (L x W x H)		610 x 915 x 1030 mm
Net weight		135 kg
Standards		EN 60974-1; EN 60974-10
Torch types		WMT family

CITOMAG 400 S (W)

MIG/MAG welding installations, continuous adjustment with separate wire feeder for intensive industrial work.

4

CITOMAG 400 S (W)

17 product advantages:

- simple to use
- synergic and manual adjustment
- digital display and pre-setting
- wire feeder 4 rollers
- purge gas
- wire feed advance without power
- 2T/4T/modes
- built-in crater filler function
- pre gas, burn back and post gas times adjustment
- arc extinction device
- adjustable voltage striking
- arc dynamics adjustment
- missing phase detector
- disengageable fan
- inversion of polarity
- 2 lifting eyes
- reliability and robustness



To order

- **Standard equipment:**
 - 1 power source with handle wheels and cylinder holder
 - 1 connected primary cable L = 5 m
 - 1 earth cable L = 5 m with clamp
 - 1 equipped gas hose 2 m
 - Cat. No. W 000 261 979
- **Add-ons:**
- **Accessories for air cooled sets:**
 - DV44i feeder D37 with harness 5 m air
 - Cat. No. W 000 268 844
 - with harness 10 m air
 - Cat. No. W 000 268 845
 - with harness 15 m air
 - Cat. No. W 000 268 846

- CITORCH M 341 torch with cable 3 m air
- Cat. No. W 000 345 091
- with cable 4 m air
- Cat. No. W 000 345 092
- with cable 5 m air
- Cat. No. W 000 345 093

Accessories for water cooled sets:

- DV44i feeder D37 with harness 5 m water
- Cat. No. W 000 268 847
- with harness 10 m water
- Cat. No. W 000 268 848
- with harness 15 m water
- Cat. No. W 000 268 849
- CITORCH M 241W torch with cable 3 m water
- Cat. No. W 000 345 088
- with cable 4 m water
- Cat. No. W 000 345 089
- with cable 5 m water
- Cat. No. W 000 345 090
- Cooler unit
- Cat. No. W 000 305 009
- **Options:**
 - Slinging arm
 - Cat. No. W 000 305 061
 - BB Box remote control, 2 buttons,
 - Cat. No. W 000 305 112
 - Feeder pivot
 - Cat. No. W 000 305 010
 - Torch arm boom
 - Cat. No. W 000 261 846
 - FREEZCOOL 20 L
 - Cat. No. W 000 010 168

Technical specifications	4 CITOMAG 400 S (W)	5 CITOMAG 400 S MV (W)	6 CITOMAG 500 S (W)
Power supply three-phase	230/400 V ± 10% 50-60 Hz	220 to 240/380/400/415/440 V ± 10% 50-60 Hz	220 to 240/380/400/415/440 V ± 10% 50-60 Hz
Primary consumption at I max.	51.4 A (230 V) - 29.5 A (400 V)	51.4 A (230 V) - 29.5 A (400 V)	77.6 A (230 V) - 44.6 A (400 V)
Effective consumption	32.2 A (230 V) - 18.3 A (400 V)	32.2 A (230 V) - 18.3 A (400 V)	60.1 A (230 V) - 34.5 A (400 V)
Open circuit voltage	38.9 - 48.2 V	38.9 - 48.2 V	61 V
Welding current	50 - 400 A	50 - 400 A	40 - 520 A
Protection class	IP 23	IP 23	IP 23
Insulation class	H	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 270 A at 60% 350 A at 40% 400 A	270 A 350 A 400 A	370 A 520 A -
Number of rollers	4	4	4
Wire diameter	0.8 - 1.2 mm	0.8 - 1.2 mm	0.8 - 1.6 mm
Dimensions (L x W x H)	1015 x 530 x 830 mm	1015 x 530 x 830 mm	1120 x 712 x 1330 mm
Net weight	137 kg	143 kg	185 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	CITORCH M family	CITORCH M family	CITORCH M family

CITOMAG 400 S MV (W) and 500 S (W)

MIG/MAG welding installations, continuous adjustment with separate wire feeder for intensive industrial work.

5

CITOMAG 400 S MV (W)

18 product advantages:

- simple to use
- synergic and manual adjustment
- digital display and pre-setting
- wire feeder 4 rollers
- purge gas
- wire feed advance without power
- 2T/4T/modes
- built-in crater filler function
- pre gas, burn back and post gas times adjustment
- arc extinction device
- adjustable voltage striking
- arc dynamics adjustment
- missing phase detector
- disengageable fan
- inversion of polarity
- 2 lifting eyes
- reliability and robustness
- multi-voltage



2008-040R

To order

• Standard equipment:

- 1 power source with handle wheels and cylinder holder
- 1 connected primary cable L = 5 m
- 1 earth cable L = 5 m with clamp
- 1 equipped gas hose 2 m
- Cat. No. W 000 261 978

• Add-ons:

Accessories for air cooled sets:

- DV44i feeder D37 with harness 5 m air
Cat. No. W 000 268 844
- DV44i feeder D37 with harness 10 m air
Cat. No. W 000 268 845
- DV44i feeder D37 with harness 15 m air
Cat. No. W 000 268 846
- CITORCH M 341 torch with cable 3 m air
Cat. No. W 000 345 091
- CITORCH M 341 torch with cable 4 m air
Cat. No. W 000 345 092
- CITORCH M 341 torch with cable 5 m air
Cat. No. W 000 345 093

Accessories for water cooled sets:

- DV44i feeder D37 with harness 5 m water
Cat. No. W 000 268 847
- DV44i feeder D37 with harness 10 m water
Cat. No. W 000 268 848
- DV44i feeder D37 with harness 15 m water
Cat. No. W 000 268 849
- CITORCH M 241W torch with cable 3 m water
Cat. No. W 000 345 088
- CITORCH M 241W torch with cable 4 m water
Cat. No. W 000 345 089
- CITORCH M 241W torch with cable 5 m water
Cat. No. W 000 345 090
- Cooler unit
Cat. No. W 000 305 009

• Options:

- Slings arm
Cat. No. W 000 305 061
- BB Box remote control, 2 buttons,
Cat. No. W 000 305 112
- Feeder pivot
Cat. No. W 000 305 010
- Torch arm boom
Cat. No. W 000 261 846
- FREEZCOOL (20 L)
Cat. No. W 000 010 168

6

CITOMAG 500 S (W)

18 product advantages:

- simple to use
- synergic and manual adjustment
- digital display and pre-setting
- wire feeder 4 rollers
- purge gas
- wire feed advance without power
- 2T/4T/modes
- built-in crater filler function
- pre gas, burn back and post gas times adjustment
- arc extinction device
- adjustable voltage striking
- arc dynamics adjustment
- missing phase detector
- disengageable fan
- inversion of polarity
- 2 lifting eyes
- reliability and robustness
- multi-voltage



2008-042

To order

• Standard equipment:

- 1 power source with handle wheels and cylinder holder
- 1 connected primary cable L = 5 m
- 1 earth cable L = 5 m with clamp
- 1 equipped gas hose 2 m
- Cat. No. W 000 261 980

• Add-ons:

Accessories for air cooled sets:

- DV44i feeder D37 with harness 5 m air
Cat. No. W 000 268 844
- DV44i feeder D37 with harness 10 m air
Cat. No. W 000 268 845
- DV44i feeder D37 with harness 15 m air
Cat. No. W 000 268 846
- CITORCH M 441 torch with cable 3 m air
Cat. No. W 000 261 563
- CITORCH M 441 torch with cable 4 m air
Cat. No. W 000 261 564
- CITORCH M 441 torch with cable 5 m air
Cat. No. W 000 261 568

Accessories for water cooled sets:

- DV44i feeder D37 with harness 5 m water
Cat. No. W 000 268 847
- DV44i feeder D37 with harness 10 m water
Cat. No. W 000 268 848
- DV44i feeder D37 with harness 15 m water
Cat. No. W 000 268 849
- CITORCH M 341W torch with cable 3 m water
Cat. No. W 000 345 094
- CITORCH M 341W torch with cable 4 m water
Cat. No. W 000 345 095
- CITORCH M 341W torch with cable 5 m water
Cat. No. W 000 345 096
- Cooler unit
Cat. No. W 000 305 009

• Options:

- Slings arm
Cat. No. W 000 305 061
- BB Box remote control, 2 buttons
Cat. No. W 000 305 112
- Feeder pivot
Cat. No. W 000 305 010
- Torch arm boom
Cat. No. W 000 261 846
- FREEZCOOL (20 L)
Cat. No. W 000 010 168

CITOMIG XP air/water cooled: compact range

The CITOMIG XP range are conventional switch based MIG-MAG welding installations with help system setting (ESP). These units are equipped with digital wire speed regulation, maintaining a constant value in the wire-feed supply regardless of variations in resistance. This characteristic produces a perfectly stable arc for top-quality weld beads in terms of defects and surface appearance.

1

CITOMIG 300 XP

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes
- 4 roller plate
- inversion of polarity
- 12 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-358

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support and handle
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8 - 1.2 mm
Cat. no. W 000 260 959
- **Add-ons:**
 - CITORCH M 241 torch 3 m
Cat. no. W 000 345 085
 - CITORCH M 241 torch 4 m
Cat. no. W 000 345 086
- **Options:**
 - Torch arm boom
Cat. No. W 000 261 845

2

CITOMIG 400 XP

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes
- 4 roller plate
- inversion of polarity
- 3 x 10 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-285

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support, handle and 4 lifting eyes
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8 - 1.6 mm
Cat. no. W 000 260 961
- **Add-ons:**
 - CITORCH M 341 torch 3 m
Cat. no. W 000 345 091
 - CITORCH M 341 torch 4 m
Cat. no. W 000 345 092
- **Options:**
 - Torch arm boom
Cat. No. W 000 261 845

3

CITOMIG 400 XP W

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes
- 4 roller plate
- inversion of polarity
- 3 x 10 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-285

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support, handle and 4 lifting eyes
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long
 - 1 accessory kit for solid wires 0.8 - 1.6 mm
 - 1 built-in cooling unit
Cat. no. W 000 260 962
- **Add-ons:**
 - CITORCH M 341 W torch 3 m
W 000 345 094
 - CITORCH M 341 W torch 4 m
W 000345 095
 - CITORCH M 441 W torch 3 m
W 000 345 100
 - CITORCH M 441 W torch 4 m
W 000 345 101
- **Options:**
 - Torch arm boom
Cat. No. W 000 261 845
 - FREEZCOOL (20 L)
Cat. No. W 000 010 168

Technical specifications	1 CITOMIG 300 XP	2 CITOMIG 400 XP / 3 400 XP W
Power supply	230 / 400 V ± 10% - 50 Hz three-phase	230 / 400 V ± 10% - 50 Hz three-phase
Primary consumption at I max.	27.7 - 16 A	47 - 27 A
Effective consumption	19.5 - 11.3 A	29.7 - 17.1 A
Open circuit voltage	16.5 - 35.8 V	16.6 - 45.8 V
Welding current	30 - 280 A	28 - 380 A
Protection class	IP 23	IP 23
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 200 A at 60% 240 A at 50% 270 A	280 A 320 A 380 A (at 40 %)
Number of rollers	4	4
Wire diameter	0.8 - 1.2 mm	0.8 - 1.6 mm
Dimensions (L x W x H)	780 x 390 x 825 mm	925 x 580 x 1060 mm
Net weight	98 kg	161 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	CITORCH M family	CITORCH M family

3

CITOMIG XP air/water cooled: compact range

4

CITOMIG 300 XP S

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes
- 4 roller plate
- 1 accessory kit for solid wires 0.8 -1.2 mm
- 12 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-357

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support and handle
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long Cat. no. W 000 260 960
- **Add-ons:**
 - Wire feeder DV 4004 XP 5 m air Cat. no. W 000 260 999
 - Wire feeder DV 4004 XP 10 m air Cat. no. W 000 261 000
 - CITORCH M 241 torch 3 m Cat. no. W 000 345 085
 - CITORCH M 241 torch 4 m Cat. no. W 000 345 086
- **Options:**
 - Torch arm boom Cat. No. W 000 261 846

5 6

CITOMIG 400 XP S / 400 S W

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes
- 4 roller plate
- 1 accessory kit for solid wires 0.8 -1.6 mm
- 3 x 10 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-288

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support, handle and 4 lifting eyes
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long Cat. no. W 000 260 964 (air version) Cat. no. W 000 260 963 (water version) with built-in colling unit
- **Add-ons:**
 - **Accessories for air cooled sets**
 - Wire feeder DV 4004 XP 5 m air Cat. no. W 000 260 999
 - Wire feeder DV 4004 XP 10 m air Cat. no. W 000 261 000
 - CITORCH M 341 torch 3 m Cat. no. W 000 345 091
 - CITORCH M 341 torch 4 m Cat. no. W 000 345 092
 - **Accessories for water cooled sets**
 - Wire feeder DV 4004 XP - 5 m water Cat. no. W 000 261 001
 - Wire feeder DV 4004 XP - 10 m water Cat. no. W 000 261 002
 - CITORCH M 341 W torch 3 m Cat. no. W 000 345 094
 - CITORCH M 341 W torch 4 m Cat. no. W 000 345 095
 - CITORCH M 441 W torch 3 m Cat. no. W 000 345 100
 - CITORCH M 441 W torch 4 m Cat. no. W 000 345 101
- **Options:**
 - Torch arm boom Cat. No. W 000 261 846
 - FREEZCOOL (20 L) Cat. No. W 000 010 168

7 8

CITOMIG 500 XP S / 500 S W

11 product advantages:

- user-friendly front panel
- pre-gas, post-gas and burn-back times adjustment
- ESP mode to adjust the welding parameters easily
- digital display
- 2T/4T, spot and intermittent modes,
- 4 roller plate
- 1 accessory kit for solid wires 1.0 -1.2 mm
- 3 x 10 step voltage adjustment
- disengageable ventilation
- wire feeding regulation system
- system for "spatter reduction"



2006-787

To order

- **Standard equipment:**
 - 1 power source with wheels, cylinder support, handle and 4 lifting eyes
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp and DINSE connector
 - 1 equipped gas hose 2 m long Cat. no. W 000 260 965 (air version) Cat. no. W 000 260 966 (water version) built-in colling unit
- **Add-ons:**
 - **Accessories for air cooled sets**
 - Wire feeder DV 4004 XP 5 m air Cat. no. W 000 260 999
 - Wire feeder DV 4004 XP 10 m air Cat. no. W 000 261 000
 - CITORCH M 441 torch 3 m Cat. no. W 000 345 097
 - CITORCH M 441 torch 4 m Cat. no. W 000 345 098
 - **Accessories for water cooled sets**
 - Wire feeder DV 4004 XP 5 m water Cat. no. W 000 261 001
 - Wire feeder DV 4004 XP 10 m water Cat. no. W 000 261 002
 - CITORCH M 441 W torch 3 m Cat. no. W 000 345 100
 - CITORCH M 441 W torch 4 m Cat. no. W 000 345 101
- **Options:**
 - Torch arm boom Cat. No. W 000 261 846
 - FREEZCOOL (20 L) Cat. No. W 000 010 168

Technical specifications	4 CITOMIG 300 XP S	5 CITOMIG 400 XP S / 6 400 XP S W	7 CITOMIG 500 XP S / 8 500 XP S W
Power supply three-phase	230 / 400 V ± 10% - 50 Hz	230 / 400 V ± 10% - 50 Hz	230 / 400 V ± 10% - 50 Hz
Primary consumption at I max.	27.7 - 16 A	47 - 27 A	63.3 - 36.6 A
Effective consumption	19.5 - 11.3 A	29.7 - 17.1 A	44.7 - 25.9 A
Open circuit voltage	16.5 - 35.8 V	16.6 - 45.8 V	15.8 - 50.4 V
Welding current	30 - 270 A	28 - 380 A	16 - 480 A
Protection class	IP 23	IP 23	IP 23
Insulation class	H	H	H
Duty cycle at 100%	200 A	280 A	350 A
10 min. cycle at 60%	240 A	320 A	410 A
(at 40 °C) at 50%	270 A	380 A (at 40 %)	480 A
Number of rollers	4	4	4
Wire diameter	0.8 - 1.2 mm	0.8 - 1.6 mm	0.8 - 1.6 mm
Dimensions (L x W x H)	780 x 390 x 825 mm	925 x 580 x 1060 mm	925 x 580 x 1060 mm
Net weight	98 kg	161 kg	201 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	CITORCH M family	CITORCH M family	CITORCH M family

The new generation of CITOPULS power sources

The CITOPULS range has been designed for all applications requiring very high quality welding for all thicknesses and all materials used in the main industrial sectors. The direct adjustment of the parameters on the front panel makes the utilisation of the power source much easier for the operator. A set up program allows numerous adjustments of the welding cycles, the welding modes and processes, to ensure the optimum use of these power sources.

CITOPULS range

Product advantages:

- **Regulation and numerical controls:** total control of power supply wave forms for an improvement of the processes, and of the thicknesses, and exact parameter reproduction
- **Increased power (Voltage/Current):** increases the arc rigidity with pulsed mode, which improves penetration and allows a good fusion of "hard-to-weld" wires
- **More processes:** Soft current, Speed Short Arc™ (SSA™), pulsed and MMA
- **More memory:** 99 welding programs on CITOPULS MX (W) 320 and 121 welding programs on CITOPULS MXW 420 for all welding applications
The remote control box also allows memorisation of 10 programs
- **More cycles:** 2T/ 4T/ Spot weld/Cold Double Pulse current (CDP)
- **More options:** large options offer in order to make the welding process easier and safer
- **Potentiometer torch**



1

CITOPULS MX 320



To order:

- **Standard equipment air cooled**
 - 1 power source
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp
 - 1 equipped gas hose 2 m long
- **Options:**
 - Workshop trolley for power source Cat. no. W 000 055 046
 - Pivot standard (requires power source workshop trolley) Cat. no. W 000 055 048
 - Workshop trolley for DMY 4000 feeder Cat. no. W 000 055 050
 - Wire feed suspension support Cat. no. W 000 055 101
 - CITO-JOB remote control Cat. no. W 000 055 079
 - Power box 230/400 V 3ph - 50/60 Hz - 20 kVA Cat. no. W 000 305 106
 - Push-pull control card Cat. no. W 000 055 061
 - Push-pull torch CITORCH MPP 352 - 8 m Cat. no. W 000 267 609
 - Workshop trolley for DMY 4000 WKS feeder Cat. no. W 000 267 595
- **Add-ons:**
 - Wire feeder DMY 4000 CDR Cat. no. W 000 257 873
 - Reinforced wire feeder DMY 4000 WKS Cat. no. W 000 267 594
 - Harness air cooled L = 2 m for steel Cat. no. W 000 055 088 L = 5 m for steel Cat. no. W 000 055 089 L = 10 m for steel Cat. no. W 000 055 090
 - CITORCH M 341 torch 3 m Cat. no. W 000 345 091
 - CITORCH M 341 torch 4 m Cat. no. W 000 345 092
 - CITORCH M P 341 torch 3 m Cat. no. W 000 345 117
 - CITORCH M P 341 torch 4 m Cat. no. W 000 345 118



Technical specifications	1 CITOPULS MX 320
Power supply three-phase	400 V ± 10% - 50/60 Hz
Primary consumption at I max.	25.9 A
Effective consumption	25.9 A
Open circuit voltage	113 V
Welding current	20 - 320 A
Protection class	IP 23 S
Insulation class	H
Duty cycle 10 min. cycle at 100% (at 40 °C)	320 A
Number of rollers	4
Wire diameter	0.6 - 1.2 mm
Dimensions (L x W x H)	845 x 380 x 855 mm
Net weight	75 kg
Standards	EN 60974-1; EN 60974-10
Torch types	CITORCH M and MP families



The new generation of CITOPULS power sources

CITOPULS range

2

CITOPULS MXW 320



2006-106

To order:

• **Standard equipment water cooled:**

- 1 power source
- 1 connected primary cable L = 5 m
- 1 earth cable L = 5 m with clamp
- 1 equipped gas hose 2 m long

Cat. no. W 000 055 003

• **Add-ons:**

- Wire feeder DMY 4000
Cat. no. W 000 257 873
- Reinforced wire feeder DMY 4000 WKS
Cat. no. W 000 267 594
- Harness water cooled
L = 2 m for steel
Cat. no. W 000 055 091
L = 5 m for steel
Cat. no. W 000 055 092
L = 10 m for steel
Cat. no. W 000 055 093
L = 15 m for steel
Cat. no. W 000 055 094
L = 2 m for aluminium
Cat. no. W 000 055 095
L = 10 m for aluminium
Cat. no. W 000 055 096
L = 15 m for aluminium
Cat. no. W 000 055 097
- CITORCH M 341 W torch 3 m
Cat. no. W 000 345 094
- CITORCH M 341 W torch 4 m
Cat. no. W 000 345 095

- CITORCH M P 341W torch 3 m
Cat. no. W 000 345 119
- CITORCH M P 341W torch 4 m
Cat. no. W 000 345 120
- FREEZCOOL (10 L cans)
Cat. no. W 000 010 167

• **Options:**

- Workshop trolley for power source
Cat. no. W 000 055 046
- Pivot standard (requires power source workshop trolley)
Cat. no. W 000 055 048
- Workshop trolley for DMY 4000 feeder
Cat. no. W 000 055 050
- Wire feed suspension support
Cat. no. W 000 055 101
- CITO-JOB remote control
Cat. no. W 000 055 079
- Push-pull control card
Cat. no. W 000 055 061
- Push-pull torch
CITORCH MPP 451 W - 8 m
Cat. no. W 000 267 608
- Workshop trolley for DMY 4000 WKS feeder
Cat. no. W 000 267 595

3

CITOPULS MXW 420



2007-891

DMY 4000 WKS

To order:

• **Standard equipment water cooled:**

- 1 power source
- 1 connected primary cable L = 5 m
- 1 earth cable L = 5 m with clamp
- 1 equipped gas hose 2 m long

Cat. no. W 000 257 776

• **Add-ons:**

- Wire feeder DMY 4000
Cat. no. W 000 257 873
- Reinforced wire feeder DMY 4000 WKS
Cat. no. W 000 267 594
- Harness water cooled
L = 2 m for steel
Cat. no. W 000 055 091
L = 5 m for steel
Cat. no. W 000 055 092
L = 10 m for steel
Cat. no. W 000 055 093
L = 15 m for steel
Cat. no. W 000 055 094
L = 2 m for aluminium
Cat. no. W 000 055 095
L = 10 m for aluminium
Cat. no. W 000 055 096
L = 15 m for aluminium
Cat. no. W 000 055 097
- CITORCH M 441 W torch 3 m
Cat. no. W 000 345 100
- CITORCH M 441 W torch 4 m
Cat. no. W 000 345 101

- CITORCH M P 441 W torch 3 m
Cat. no. W 000 345 121
- CITORCH M P 441 W torch 4 m
Cat. no. W 000 345 122
- FREEZCOOL (10 L cans)
Cat. no. W 000 010 167

• **Options:**

- Workshop trolley for power source
Cat. no. W 000 055 046
- Pivot standard (requires power source workshop trolley)
Cat. no. W 000 055 048
- Workshop trolley for DMY 4000 feeder
Cat. no. W 000 055 050
- Wire feed suspension support
Cat. no. W 000 055 101
- CITO-JOB remote control
Cat. no. W 000 055 079
- Push-pull control card
Cat. no. W 000 055 061
- Push-pull torch
CITORCH MPP 451 W - 8 m
Cat. no. W 000 267 608
- Workshop trolley for DMY 4000 WKS feeder
Cat. no. W 000 267 595

Technical specifications	2 CITOPULS MXW 320	3 CITOPULS MXW 420
Power supply three-phase	400 V ± 10% - 50/60 Hz	400 V ± 10% - 50/60 Hz
Primary consumption at I max.	25.9 A	36.4 A
Effective consumption	25.9 A	26.7 A
Open circuit voltage	113 V	113 V
Welding current	20 - 320 A	20 - 420 A
Protection class	IP 23 S	IP 23 S
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 320 A at 60% - at 45% -	350 A 400 A 420 A
Number of rollers	4	4
Wire diameter	0.6 - 1.2 mm	0.8 - 1.6 mm
Dimensions (L x W x H)	845 x 380 x 855 mm	845 x 380 x 855 mm
Net weight	91 kg	91 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	CITORCH M and MP families	CITORCH M and MP families

The new generation of CITOWAVE power sources

User-friendliness and high levels of performance make CITOWAVE the ideal partner for all manual, automatic and robotic welding applications. A wide graphic screen allows the operator to navigate easily around a menu bar for adjusting the various parameters of the unit.

CITOWAVE range

Product advantages:

- **Control of aluminium welding (Spray Modal™):** special welding transfer which provides reduced porosity and increases the penetration
- **Regulation and numerical controls:** total control of wave shape to improve the welding processes ensuring a good reproduction of parameters
- **Advanced torch "DIGITAL":** a range of ergonomic torches with the possibility on the handle to
 - select the program number
 - adjust the wire feed speed
 - adjust the arc length
- **Increased power (Voltage/Current):** increases the arc rigidity with pulsed mode, which improves penetration and allows a good fusion of "hard-to-weld" wires
- **More processes:** Soft current, Pulsed, SSA, SSP, SM, CDP, MIG brazing, MMA, and PR Spray
- **More memory:** 115 welding programs on CITOWAVE MX 280 and 153 welding programs on CITOWAVE MXW 400/500 for all welding applications. The power sources also allow memorization of 100 programs, selectable from the wire feeder, remote control and CITORCH M E family
- **More controls:** parameters monitoring, indication of defects, parameter blocking on several levels, printing, 99 programs, calibration...
- **More cycles:** 2T/ 4T/ Spot weld/Cold Double Pulse current (CDP)
- **More options:** large options offer in order to make the welding process easier and safer

1 CITOWAVE MX 280



To order:

- **Standard equipment air cooled:**
 - 1 power source
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp
 - 1 equipped gas hose 2 m long
 - 1 built-in wire feed 4 rollers
 Cat. no. W 000 055 013
- **Add-ons:**
 - CITORCH M 341 torch 3 m
Cat. no. W 000 345 091
 - CITORCH M 341 torch 4 m
Cat. no. W 000 345 092
 - CITORCH M E 341 torch 3 m
Cat. no. W 000 345 111
 - CITORCH M E 341 torch 4 m
Cat. no. W 000 345 112
- **Options:**
 - Workshop trolley for power source
Cat. no. W 000 055 046
 - CITO-JOB remote control
Cat. no. W 000 055 079
 - Power box 230/400 V
3ph - 50/60 Hz - 20 kVA
Cat. no. W 000 305 100
 - Push-pull control card
Cat. no. W 000 055 061
 - Push-pull torch
CITORCH MPP 352 - 8 m
Cat. no. W 000 267 609

Technical specifications	1 CITOWAVE MX 280
Power supply three-phase	400 V ± 10% - 50/60 Hz
Primary consumption at I max.	21.4 A
Effective consumption	21.4 A
Open circuit voltage	113 V
Welding current	20 - 280 A
Protection class	IP 23 S
Insulation class	H
Duty cycle 10 min. cycle (at 40 °C) at 100%	280 A
Number of rollers	4
Wire diameter	0.6 - 1.2 mm
Dimensions (L x W x H)	845 x 380 x 855 mm
Net weight	76 kg
Standards	EN 60974-1; EN 60974-10
Torch types	CITORCH M and ME families



The new generation of CITOWAVE power sources

CITOWAVE range

2 CITOWAVE MXW 400



To order:

- **Standard equipment water cooled:**
 - 1 power source
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp
 - 1 equipped gas hose 2 m long
- **Add-ons:**
 - Wire feeder DMX 5000
Cat. no. W 000 257 782
 - Harness water cooled
L = 5 m for steel
Cat. no. W 000 055 092
L = 10 m for steel
Cat. no. W 000 055 093
L = 15 m for steel
Cat. no. W 000 055 094
L = 10 m for aluminium
Cat. no. W 000 055 096
L = 15 m for aluminium
Cat. no. W 000 055 097
 - CITORCH M 341 W torch 3 m
Cat. no. W 000 345 094
 - CITORCH M 341 W torch 4 m
Cat. no. W 000 345 095
 - CITORCH M E 341 W torch 3 m
Cat. no. W 000 345 113
- **Options:**
 - CITORCH M E 341 W torch 4 m
Cat. no. W 000 345 114
 - FREEZCOOL (10 L cans)
Cat. no. W 000 010 167
 - Workshop trolley for power source
Cat. no. W 000 055 046
 - Pivot standard
(requires power source workshop trolley)
Cat. no. W 000 055 048
 - Workshop trolley for wire feeder
Cat. no. W 000 055 050
 - Wire feed suspension support
Cat. no. W 000 055 101
 - CITO-JOB remote control
Cat. no. W 000 055 079
 - Push-pull control card
Cat. no. W 000 055 061
 - Push-pull torch
CITORCH MPP 451 W - 8 m
Cat. no. W 000 267 608

3 CITOWAVE MXW 500



To order:

- **Standard equipment water cooled:**
 - 1 power source
 - 1 connected primary cable L = 5 m long
 - 1 earth cable L = 5 m with clamp
 - 1 equipped gas hose 2 m long
- **Add-ons:**
 - Wire feeder DMX 5000
Cat. no. W 000 257 782
 - Harness water cooled
L = 5 m for steel
Cat. no. W 000 055 092
L = 10 m for steel
Cat. no. W 000 055 093
L = 15 m for steel
Cat. no. W 000 055 094
L = 10 m for aluminium
Cat. no. W 000 055 096
L = 15 m for aluminium
Cat. no. W 000 055 097
 - CITORCH M 441 W torch 3 m
Cat. no. W 000 345 100
 - CITORCH M 441 W torch 4 m
Cat. no. W 000 345 101
 - CITORCH M E 441 W torch 3 m
Cat. no. W 000 345 115
- **Options:**
 - CITORCH M E 441 W torch 4 m
Cat. no. W 000 345 116
 - FREEZCOOL (10 L cans)
Cat. no. W 000 010 167
 - Workshop trolley for power source
Cat. no. W 000 055 046
 - Pivot standard
(requires power source workshop trolley)
Cat. no. W 000 055 048
 - Workshop trolley for wire feeder
Cat. no. W 000 055 050
 - Wire feed suspension support
Cat. no. W 000 055 101
 - CITO-JOB remote control
Cat. no. W 000 055 079
 - Push-pull control card
Cat. no. W 000 055 061
 - Push-pull torch
CITORCH MPP 451 W - 8 m
Cat. no. W 000 267 608

Technical specifications	2 CITOWAVE MXW 400	3 CITOWAVE MXW 500
Power supply three-phase	400 V ± 10% - 50/60 Hz	400 V ± 10% - 50/60 Hz
Primary consumption at I max.	34.5 A	45.2 A
Effective consumption	26.7 A	35 A
Open circuit voltage	113 V	113 V
Welding current	20 - 400 A	20 - 500 A
Protection class	IP 23 S	IP 23 S
Insulation class	H	H
Duty cycle 10 min. cycle (at 40 °C)	at 100% 350 A at 60% 400 A	450 A 500 A
Number of rollers	4	4
Wire diameter	0.8 - 1.6 mm	0.8 - 1.6 mm
Dimensions (L x W x H)	845 x 380 x 855 mm	845 x 380 x 855 mm
Net weight	91 kg	91 kg
Standards	EN 60974-1; EN 60974-10	EN 60974-1; EN 60974-10
Torch types	CITORCH M and ME families	CITORCH M and ME families

MIG/MAG welding new processes

Processes advantages for a perfect assembly:

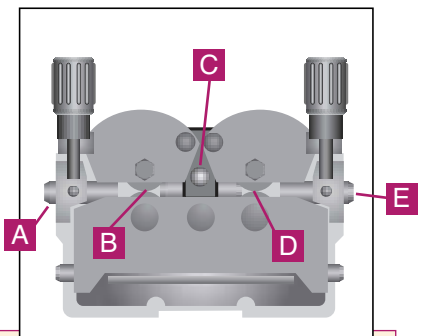
This new generation of power sources provides new welding methods able to meet quality and productivity levels to answer the needs of the main industrial sectors (especially road and rail transport, automotive industry and shipbuilding).

Process	Definition	Customer advantages	Power source
Speed Short Arc™ (SSA)	The Speed Short Arc™ allows a high travel speed due to a rigid arc and a cold regime. It is very effective for welding thin steel plates, working in position and in closed angle and filling bevels. The SSA™ is used for short circuit welding though the normal globular regime travel speed domain.	<ul style="list-style-type: none"> • Increase in travel speed • Reduced distortion (thin steel sheets) • Suited to welding in position • Tolerance and usability 	CITOWAVE CITOPULS
Spray Modal™ (SM)	Spray Modal™ is a process that strongly reduces micro porosity and increases penetration. It can be used in all positions and is particularly effective on aluminium sheets greater than 3 mm. Spray-MODAL™ uses a low-frequency modulated current which has the effect of removing hydrogen bubbles from the weld pool before solidification.	<ul style="list-style-type: none"> • Reduces porosity • Increases penetration • All-position welding • Higher travel speed 	CITOWAVE
Soft Silence Pulse™ (SSP)	The Soft Silence Pulse™ is a quieter pulsed mode mainly intended for stainless steel welding applications. The SSP™ produces a softer but very stable arc with good wetting of the weld bead. This waveform significantly reduces spatter and gives a very fine appearance to the weld bead.	<ul style="list-style-type: none"> • Reduction of noise • Good wetting of the weld bead • Reduction of spatter • Good weld bead appearance 	CITOWAVE
Cold Double Pulse™ (CDP)	The Cold Double Pulse™ produces very high quality welds on thin material while avoiding distortion. CDP™ gives a TIG appearance to the weld and is very effective on very thin aluminium or stainless steel sheet (< 2 mm). The operating technique is made easier due to good control of the weld pool even on badly-prepared sheets. This sequencer mode automatically chains hot arc and cold arc regimes together.	<ul style="list-style-type: none"> • Effective on thin sheets • Reduces distortion • Easy operating technique • TIG appearance weld bead 	CITOPULS CITOWAVE

Options and parts for CITOWAVE and CITOPULS

Length	Air harnesses	Water harnesses	Water harnesses for aluminium
2 m	W 000 055 088	W 000 055 091	W 000 055 095
5 m	W 000 055 089	W 000 055 092	-
10 m	W 000 055 090	W 000 055 093	W 000 055 096
15 m	-	W 000 055 094	W 000 055 097
25 m	-	-	W 000 055 098

Options	CITOPULS	CITOWAVE
• Workshop trolley for power sources	W 000 055 046	W 000 055 046
• Workshop trolley for wire feeder	W 000 055 050	W 000 055 050
• Pivot stand (requires power source workshop trolley)	W 000 055 048	W 000 055 048
• Wire feed suspension cradle	W 000 055 101	W 000 055 101
• CITO-JOB remote control (digital display)	W 000 055 079	W 000 055 079
• Torch with potentiometer CITORCH M P	See page 60	-
• Torch with integrated adjustment and display CITORCH M E	-	See page 60



Wire feeder wear parts DV 44i / D37 - DV 4004 XP - DMY 4000 - DMY 4000 WKS - DMX 5000

Wire Ø	A	B D	C	E	Alukit			
	Entry wire guide	Rollers	Middle wire guide	Exit wire guide				
Steel	0.6	W 000 305 150	W 000 162 834	W 000 255 654	-			
	0.8					W 000 160 942	-	W 000 241 685
	1.0					W 000 267 599	W 000 267 598	W 000 241 682
	1.2					-	W 000 160 945	-
1.6	-	-	-	-	-			
Alu	1.0 - 1.2	-	-	-	W 000 255 648			
	1.2 - 1.6	-	-	-	W 000 255 649			
	1.6 - 2.4	-	-	-	W 000 255 650			
Cored wire	1.0 - 1.2	W 000 305 150	W 000 162 834	W 000 255 655	-			
	1.2 - 1.6	-	W 000 266 330	W 000 241 682	-			
	1.6 - 2.4	W 000 257 395	W 000 266 331	W 000 257 397	W 000 241 682			

CITORCH M / M E / M P

Main features:

- Regular wire feeding with minimum friction
- Adjustable Stick-out option
- High intensities option
- Limited number of spare and wear parts



- 1 Ergonomic handle
- 2 Simple trigger
- 3 Handle spring
- 4 Insulated and reinforced neck
- 5 One piece nozzle
- 6 Alloyed copper contact tip
- 7 Extra flexible coaxial cable with ultra-resistant elastomer outer
- 8 Back connector spring

CITORCH M	241	341	441	241W	341W	441W
	Air cooling			Water cooling		
Duty cycle	60%			100%		
	270 A	350 A	450 A	270 A	370 A	450 A
Wire diameter	0.8-1.0 (1.2) mm	(0.8) 1.0-1.2 (1.6) mm	1.0-1.6 mm	0.8-1.0 (1.2) mm	(0.8) 1.0-1.2 (1.6) mm	1.0-1.6 mm
Options	Stick-out setting. High current alum. liner.	Stick-out setting. High current alum. liner. High-current nozzle + contact tip.	Stick-out setting. High current alum. liner. High-current nozzle + contact tip.	Stick-out setting. High current alum. liner.	Stick-out setting. High current alum. liner.	Stick-out setting. High current alum. liner.

To order

3 m cable	W 000 345 085	W 000 345 091	W 000 345 094	W 000 345 088	W 000 345 094	W 000 345 100
4 m cable	W 000 345 086	W 000 345 092	W 000 345 095	W 000 345 089	W 000 345 095	W 000 345 101
5 m cable	W 000 345 087	W 000 345 093	W 000 345 096	W 000 345 090	W 000 345 096	W 000 345 102

A range of torches with integrated adjustments:

Advantages CITORCH M E / P

- Setting directly on torch
- Adjustment during welding
- Parameters reading (on **CITORCH M E**)
- Easy to use

Type	CITORCH M E for CITOWAVE: integrated adjustment and display				CITORCH M P for CITOPULS: integrated adjustment			
	241	341	341 W	441 W	341	341 W	441 W	
Duty cycle	60%	270 A	350 A	-	-	350 A	-	-
	100%	-	-	350 A	450 A	-	350 A	450 A
Wire diameter	0.8 - 1.0 mm possible (1.2)	1.0 - 1.2 mm possible (0.8 and 1.6)	1.0 - 1.2 mm possible (0.8 and 1.6)	1.0 - 1.6 mm	1.0 - 1.2 mm possible (0.8 and 1.6)	1.0 - 1.2 mm possible (0.8 and 1.6)	1.0 - 1.6 mm	
Standard lengths	3 m	W 000 345 109	W 000 345 111	W 000 345 113	W 000 345 115	W 000 345 117	W 000 345 119	W 000 345 121
	4 m	W 000 345 110	W 000 345 112	W 000 345 114	W 000 345 116	W 000 345 118	W 000 345 120	W 000 345 122
Cooling		air	air	liquid	liquid	air	liquid	liquid

Feature benefits of CITORCH M E

- Easy access to the regulation buttons
- Possible adjustment of parameters in semi-synergic mode
- Display 3 digits with 3 indicators for visualisation of selection

CITORCH M E

- 1 Display for parameters setting
- 2 Regulation + & -: to adjust the welding intensity and the wire feeding speed
- 3 Welding program selection -/+

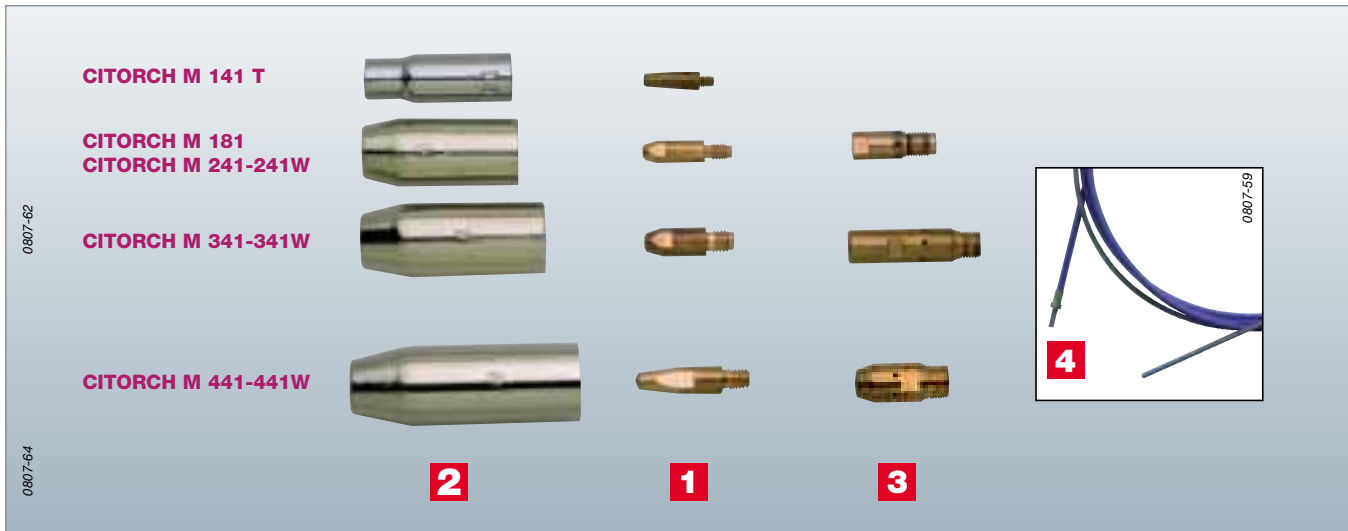


CITORCH M P with potentiometer

- 2 separate adjustments: wire feeding speed and welding intensity



Wear parts for CITORCH torches



CITORCH M	Contact tip (mm)	1 Contact tip	Nozzle (mm)	2 Nozzle	3 Tip holder	4 Internal liner			
						3 m	4 m	5 m	
141T	Steel	0.6	W 000 345 612	11,0	W 000 345 403	-	W 000 345 370	W 000 345 371	-
		0.8	W 000 345 613	11,0	W 000 345 403	-	W 000 345 372	W 000 345 373	-
		1.0	W 000 345 614	14,0	W 000 345 404	-	W 000 345 372	W 000 345 373	-
181	Steel	0.8	W 000 345 615	12,0	W 000 345 408	W 000 345 335	W 000 345 374	W 000 345 375	W 000 345 376
		1.0	W 000 345 616	14,0	W 000 345 409	W 000 345 335	W 000 345 374	W 000 345 375	W 000 345 376
	Aluminium	1.0	W 000 345 617	12,0	W 000 345 408	W 000 345 335	W 000 345 386	W 000 345 385	-
		-	-	14,0	W 000 345 409	-	-	-	-
241-241 W	Steel	0.8	W 000 345 615	12,0	W 000 354 410	W 000 345 335	W 000 010 730	W 000 010 731	W 000 010 732
		1.0	W 000 345 616	12,0	W 000 345 410	W 000 345 335	W 000 010 730	W 000 010 731	W 000 010 732
		1.2	W 000 345 618	14,0	W 000 345 411	W 000 345 335	W 000 010 733	W 000 010 734	W 000 010 735
	Aluminium	1.0	W 000 345 617	12,0	W 000 345 410	W 000 345 335	W 000 010 736	W 000 010 737	W 000 010 738
		1.2	W 000 345 619	14,0	W 000 345 411	W 000 345 335	W 000 010 736	W 000 010 737	W 000 010 738
341-341 W	Steel	0.8	W 000 345 620	14,0	W 000 345 421	W 000 345 341	W 000 010 730	W 000 010 731	W 000 010 732
		1.0	W 000 345 621	16,0	W 000 345 422	W 000 345 341	W 000 010 730	W 000 010 731	W 000 010 732
		1.2	W 000 345 623	16,0	W 000 345 422	W 000 345 341	W 000 010 733	W 000 010 734	W 000 010 735
		1.6	W 000 345 626	14,0	W 000 345 421	W 000 345 341	W 000 010 867	W 000 010 868	W 000 010 869
	Aluminium	1.0	W 000 345 622	16,0	W 000 345 422	W 000 345 341	W 000 010 736	W 000 010 737	W 000 010 738
		1.2	W 000 345 624	16,0	W 000 345 422	W 000 345 341	W 000 010 736	W 000 010 737	W 000 010 738
441-441 W	Steel	1.0	W 000 345 628	16,0	W 000 345 423	W 000 345 347	W 000 010 733	W 000 010 734	W 000 010 735
		1.2	W 000 345 630	16,0	W 000 345 423	W 000 345 347	W 000 010 733	W 000 010 734	W 000 010 735
		1.6	W 000 345 633	19,0	W 000 345 428	W 000 345 347	W 000 010 867	W 000 010 868	W 000 010 869
	Aluminium	1.0	W 000 345 629	16,0	W 000 345 423	W 000 345 347	W 000 010 736	W 000 010 737	W 000 010 738
		1.2	W 000 345 631	16,0	W 000 345 423	W 000 345 347	W 000 010 736	W 000 010 737	W 000 010 738
		1.6	W 000 345 634	19,0	W 000 345 428	W 000 345 347	W 000 010 745	W 000 010 746	W 000 010 747

WMT torches



A complete range of MIG-MAG torches

Product advantages:

- wear parts compatible with the most common standard in Europe
- easily pivoting handle
- complete range



WMT 15A
Duty cycle at 60 %
180 A (CO₂)
Original equipment:
• steel wire 0.8 mm
• nozzle Ø 12.5 mm
Air cooled
Suitable wire diameter:
• 0.6 to 1.0 mm
Automation, welding
in restricted areas.

2004-616

To order

3 m	4 m	5 m
W 000 010 600	W 000 010 601	-



WMT 36A
Duty cycle at 60 %
340 A (CO₂)
Original equipment:
• steel wire 1.2 mm
• nozzle Ø 16 mm
Air cooled
Suitable wire diameter:
• 0.8 to 1.6 mm
Boiler making, tack welding,
metal frame.

2004-620

To order

3 m	4 m	5 m
W 000 010 605	W 000 010 606	W 000 010 607




WMT 25A
Duty cycle at 60 %
230 A (CO₂)
Original equipment:
• steel wire 1.0 mm
• nozzle Ø 14 mm
Air cooled
Suitable wire diameter:
• 0.8 to 1.2 mm
Steel work, metallic joinery.

2004-619

To order

3 m	4 m	5 m
W 000 010 602	W 000 010 603	W 000 010 604



WMT 500 W
Duty cycle at 100 %
500 A (CO₂)
Original equipment:
• steel wire 1.2 mm
• nozzle Ø 16.5 mm
water cooling
Suitable wire diameter:
• 0.8 to 1.6 mm
Intensive welding, boiler
making, tack welding,
metal frame.

2004-625

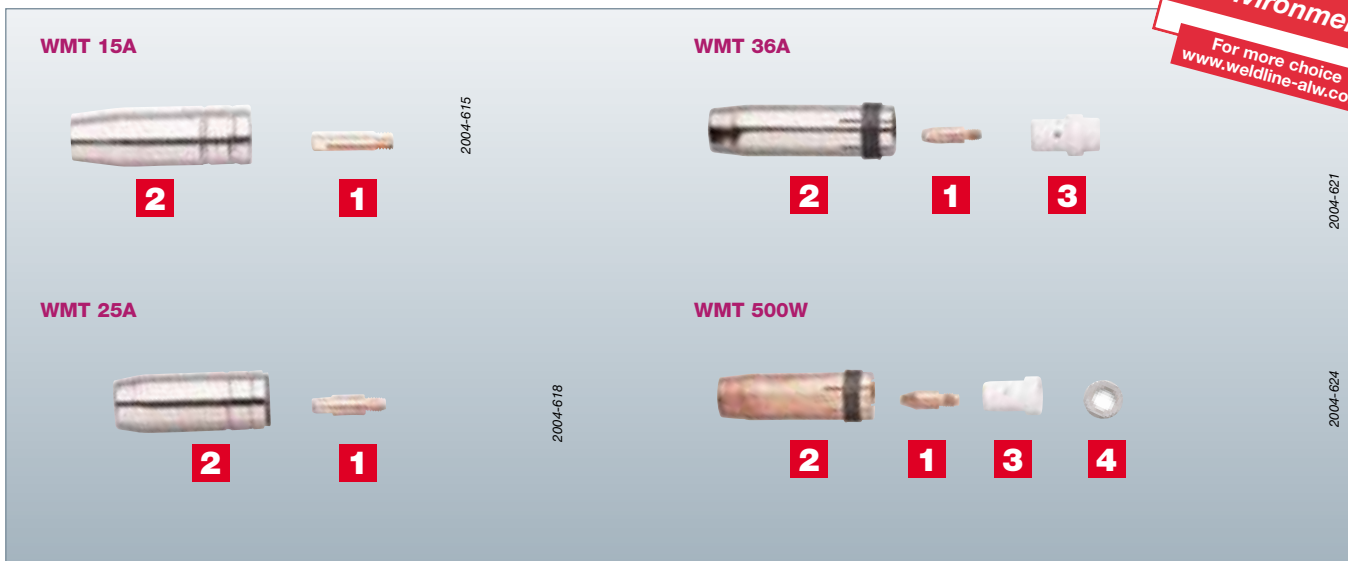
To order

3 m	4 m	5 m
W 000 010 608	W 000 010 609	W 000 010 610



2570-028

Wear parts for WMT torches



Wear parts	Diameter (mm)		WMT				
			15A	25A	36A	500 W	
1 Contact tip	Steel	0.6	W 000 010 820	-	-		
		0.8	W 000 010 821	W 000 010 826	W 000 010 834		
		1.0	W 000 010 822	W 000 010 827	W 000 010 835		
		1.2	-	W 000 010 828	W 000 010 836		
		1.6	-	-	W 000 010 837		
	Aluminium	1.0	-	W 000 010 850	W 000 010 853		
		1.2	-	W 000 010 851	W 000 010 854		
		1.6	-	-	W 000 010 855		
2 Nozzle			W 000 010 786	W 000 010 790	W 000 010 794	W 000 010 797	
Spring nozzle			W 000 010 789	W 000 010 793	-	-	
3 Isolating diffuser			-	-	W 000 010 780	W 000 010 783	
4 Isolating ring			-	-	-	W 000 010 748	
Internal liner	Steel	0.6 - 0.8	3 m	W 000 010 730	W 000 010 730	W 000 010 730	W 000 010 730
			4 m	W 000 010 731	W 000 010 731	W 000 010 731	W 000 010 731
			5 m	-	W 000 010 732	W 000 010 732	W 000 010 732
		1.0 - 1.2	3 m	W 000 010 733	W 000 010 733	W 000 010 733	W 000 010 733
			4 m	W 000 010 734	W 000 010 734	W 000 010 734	W 000 010 734
			5 m	-	W 000 010 735	W 000 010 735	W 000 010 735
		1.6	3 m	-	-	W 000 010 867	W 000 010 739
			4 m	-	-	W 000 010 868	W 000 010 740
			5 m	-	-	W 000 010 869	W 000 010 741
	Teflon	1.0 - 1.2	3 m	-	W 000 010 736	W 000 010 736	W 000 010 736
			4 m	-	W 000 010 737	W 000 010 737	W 000 010 737
			5 m	-	W 000 010 738	W 000 010 738	W 000 010 738
		1.6	3 m	-	-	W 000 010 745	W 000 010 745
			4 m	-	-	W 000 010 746	W 000 010 746
			5 m	-	-	W 000 010 747	W 000 010 747

