

KOLARC

BUILDING THE FUTURE



Robotic Interface
Digital and IO available
for all XM Series

DeviceNet



EtherNet/IP



CC-Link IE Field Basic



CANopen

EtherCAT



TECHNICAL SPECIFICATIONS

Input Voltage
Mains Voltage Tolerance
Minimum Welding Current
Maximum Welding Current
MIG Duty Cycle, 40°C
TIG Duty Cycle, 40°C
MMA Duty Cycle, 40°C
Open – Circuit Voltage
Factory Delivered Roller
Weight
Standard Accessories

Dimensions (W, L, H)
Certification

XM600 W Pulse



400 V
- 10 % / + 15 %
5 A
600 A
600 A %60, 500 A %100
600 A %60, 500 A %100
600 A %60, 500 A %100
60 V
1.0 + 1.2 mm / Steel
Liquid Cooled 111 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (95 mm²)
Interconnection H.P (5 m)
XM50 Remote Controlled Torch
532mm x 974mm x 1270mm
CE

XM500 W Pulse



400 V
- 10 % / + 15 %
5 A
500 A
500 A %60, 400 A %100
500 A %60, 400 A %100
500 A %60, 400 A %100
60 V
1.0 + 1.2 mm / Steel
Liquid Cooled 107 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
XM50 Remote Controlled Torch
532mm x 974mm x 1270mm
CE

XM350 W

Pulse



XM270 CW

Pulse



XM220 C

Pulse

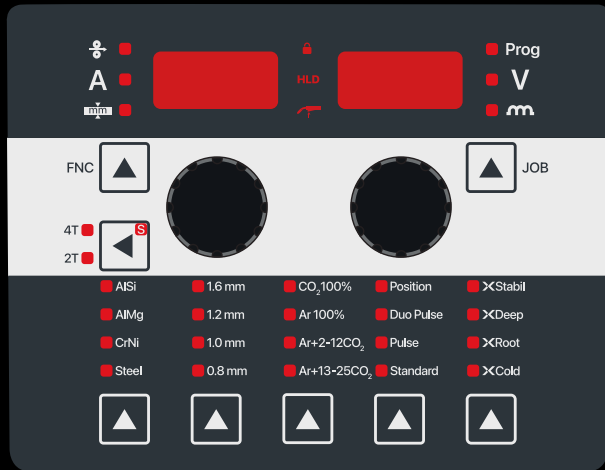


400 V
- 10 % / + 15 %
5 A
350 A
350 A %60, 300 A %100
350 A %60, 300 A %100
350 A %60, 300 A %100
60 V
1.0 + 1.2 mm / Steel
Liquid Cooled 77 kg
5 m Power Cable (4 x 6 mm²)
3 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
XM50 Remote Controlled Torch
513mm x 795mm x 1079mm
CE

400 V
- 10 % / + 15 %
5 A
325 A
270 A %60, 210 A %100
270 A %60, 210 A %100
270 A %60, 210 A %100
60 V
0.8 + 1.0 mm / Steel
Liquid Cooled 71 kg
4 m Power Cable (4 x 2.5 mm²)
3 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
XM50 Remote Controlled Torch
513mm x 963mm x 1015mm
CE

230 V
- 10 % / + 15 %
5 A
150 A
150 A %25, 110 A %60, 90 A %100
220 A %25, 110 A %60, 90 A %100
170 A %25, 110 A %60, 90 A %100
60 V
0.8 + 1.0 mm / Steel
Air Cooled 28 kg
4 m Power Cable (3 x 2.5 mm²)
3 m Earth Clamp (16 mm²)
Gas Hose (1.5 m)
MX36 Remote Controlled Torch
209mm x 403mm x 533mm
CE

It's Manual Or Robotic. Experience 406* welding programs



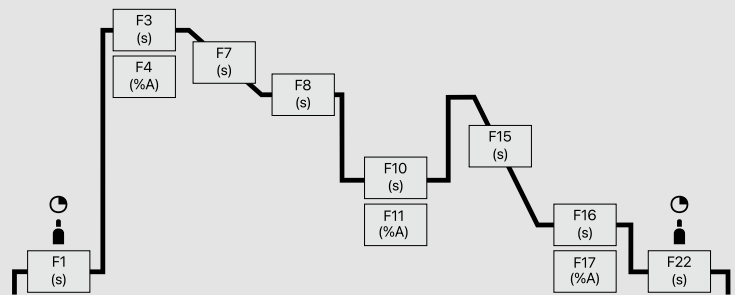
Pulse

Intuitive User Interface

*Welding jobs for 1.6 Wires are just available for 500 and 600 models.

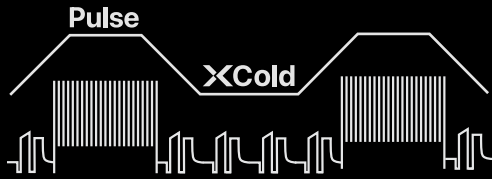
Synergic - Pulse		0.8	1.0	1.2	1.6		
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	8	10	12	16		
	Ar+10%CO ₂	18	20	22	26		
CNI	Ar+2.5%CO ₂	28	30	32	36		
		318 / 1.4576	38	40	42	46	
		316 / 1.4430	68	70	72	76	
		310 / 1.4842		520	522		
		309 / 1.4332	538	540	542	546	
		308 / 1.4316	58	60	62	66	
		307 / 1.4370	48	50	52	56	
		Duplex 2209 1.4462	78	80	82	86	
			Ar+20%He+2%CO ₂	88	90	92	96
			Ar100%	178	180	182	186
CuSi	Ar+2.5%CO ₂	558	560	562	566		
CuAl	Ar100%	188	190	192	196		
CuSi Brazing	Ar100%	198	200	202	206		
	Ar+2.5%CO ₂	208	210	212	216		
CuAl Brazing	Ar100%	218	220	222	226		
	Ar+2.5%CO ₂	228	230	232	236		
AlMg4,5 Mn	Ar100%	118	120	122	126		
	Ar+30%He	128	130	132	136		
AlMg3	Ar100%	530	532	536			
AlSi	Ar100%	138	140	142	146		
	Ar+30%He	148	150	152	156		
Al99	Ar100%	158	160	162	166		
	Ar+30%He	168	170	172	176		
XDeep - Pulse		0.8	1.0	1.2	1.6		
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	298	300	302	306		
	Ar+10%CO ₂	308	310	312	316		
CNI	Ar+2.5%CO ₂	620	622	626			
		318 / 1.4576	620	622	626		
		316 / 1.4430	640	642	646		
		310 / 1.4842		660	662		
		309 / 1.4332	670	672	676		
		308 / 1.4316	320	322	326		
		307 / 1.4370		632	636		
		Duplex 2209 1.4462	650	652	656		
		AlMg4,5 Mn	Ar100%	332	336		
		AlSi	Ar100%	342	346		
Al99	Ar100%	352	356				
CrNi / FluxCore Metal	Ar+18%CO ₂	608	610	612	616		
XRoot - Pulse		0.8	1.0	1.2	1.6		
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂		360	362			
	CO ₂ 100%		370	372			
	Ar+10%CO ₂		500	502			

XCold - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	378	380	382	386
	CO ₂ 100%	388	390	392	
	Ar+10%CO ₂		510	512	
CNI	Ar+2.5%CO ₂	318 / 1.4576	678	680	682
		316 / 1.4430	698	700	702
		308 / 1.4316	398	400	402
		307 / 1.4370	688	690	692
		Duplex 2209 1.4462	708	710	712
AlMg4,5 Mn	Ar100%	410	412		
AlSi	Ar100%	420	422		
Al99	Ar100%	430	432		
CuSi Brazing	Ar100%	438	440	442	
CuAl Brazing	Ar100%	448	450	452	
AlSi Brazing	Ar100%	460	462		
ZnAl Brazing	Ar100%	470	472		
ZnAl (St to Al Welding)	Ar100%	490	492		
Mg / Mg	Ar+30%He		572	576	
Cladding		0.8	1.0	1.2	1.6
NiCr-6625 / 2.4831	Ar+30%He	100	102	106	
	Ar+20%He+2%CO ₂	110	112	116	
NiCr-6617 / 2.4627	Ar+30%He		552	556	
CrNi / 309-2312 / 1.4332	Ar+2.5%CO ₂		542	546	
Co - Based	Ar100%		532	536	
XStabil		0.8	1.0	1.2	1.6
SG2 / SG3 - G3Si1 / G4Si1	Ar+18%CO ₂		730	732	
CrNi - 316 / 1.4430	Ar+2.5%CO ₂		750		
CrNi - 308 / 1.4316	Ar+2.5%CO ₂		740	742	
Flux Cored Wire		0.8	1.0	1.2	1.6
Steel / FluxCore Metal	Ar+18%CO ₂	238	240	242	246
	Ar+18%CO ₂	248	250	252	256
Steel / FluxCore Rutil	CO ₂ 100%		262	266	
	Ar+18%CO ₂		602		
CrNi / FluxCore Metal	Ar+2.5%CO ₂		272	276	
CrNi / FluxCore Rutil	Ar+18%CO ₂		282	286	
CrNi / FluxCore Rutil	CO ₂ 100%		292	296	
Steel FluxCore High Str.	Ar+18%CO ₂		592		
Steel / FluxCore Rutil	Self Shielded		720	722	
Application					
MIG/MAG Manual		4			
TIG (Lift Arc)		5			
MMA		6			
Gouging		7			

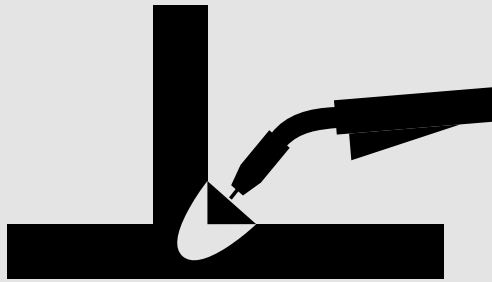


Function	Description	Min	Max
F1	Gas pre-flow (s)	0	10
F2	Start wire speed (m/min)	1	11
F3	Start time (s)	0	10
F4	Start current (%)	1	200
F5	Start arc correction (V)	-9.9	+9.9
F7	Start slope (s)	0	5
F15	End down slope (s)	0.05	10
F16	End time (s)	0	10
F17	End current (%)	1	200
F18	End arc correction (V)	-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
F31	TIG V stop limit (V)	10	30
F32	TIG comfort stop sensitivity (V)	-2	+2

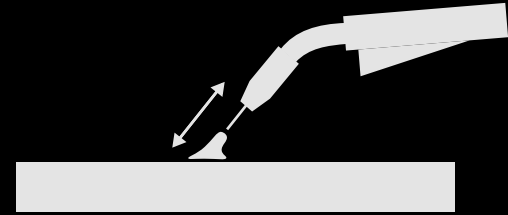
Function	Description	Min	Max
F25	Hot start time (s)	0	10
F26	Hot start current (%)	1	200
F27	Arc force (-)	-50	+50
F28	Antistick (s)	0	2
F29	VRD function (-)	0	1
F34	Tack/stich mode (-)	0	2
F35	Cooling mode (-)	0	4
F36	Motor current (A)	0	-
F37	Motor current limit (A)	0.7	7
F38	Auto load default values (-)	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
F49	Working mode	1	8
F50	RL cable calibration (mOhm)	0	30



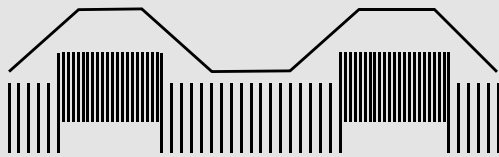
Position



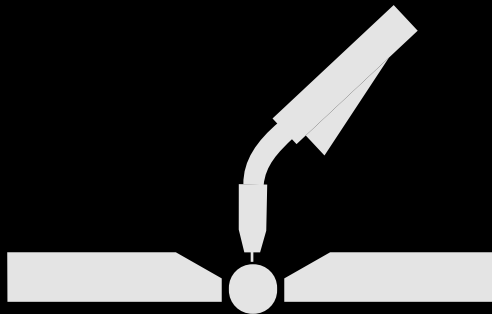
XDeep



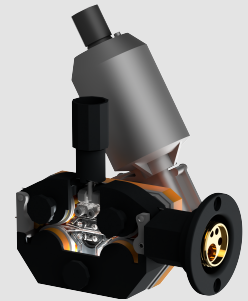
XStabil



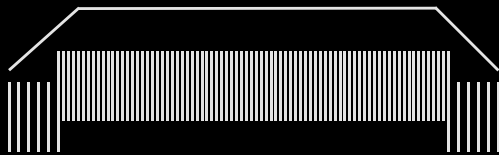
Duo Pulse



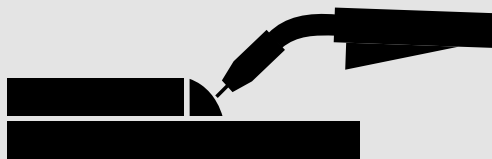
XRoot



**4x4 4 Rollers
Wire Drive**



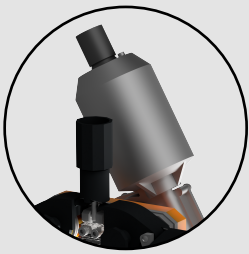
Pulse



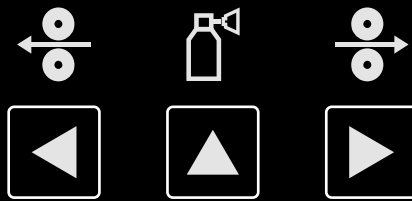
XCold



**Remote
Controlled Torch**



**256 PPR
(A-B-Index)
Optical Encoder**



**Wire Push
Pull-Back
Gas Testing**



**Spool Cover
With Wire
View**

99

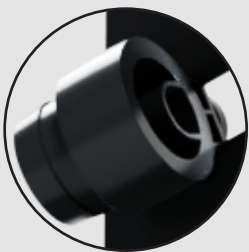
**Program
Memory**



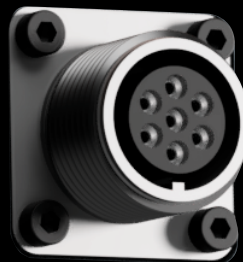
**Intelligent
Cooling**

RL

**Torch and Cable
Calibration**



**HP
Support**



**Military
Connector**

CAN-FD

**High Speed
Communication**

Gun Holder

Compact Wire Feeder

Modular IP23 Design

Touch Sense Ignition

Perfect Start with Wire Cut Function

Wire Speed Correction

Wire Feeder Cabinet Lighting

Wire Feeder MMA Connection

Gas Saving System

Gas Filter

Liquid Filter

Extension Cable Rack

External Changable Couplings

Plug Double Setscrew

Socket Brass-Nut

Industrial Wheels

Optional Wire Feeder Wheels

