

# KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Others



DeviceNet

EtherNet/IP

CANopen



**XM350 CW**  
Pulse



**XM350 C**  
Pulse



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

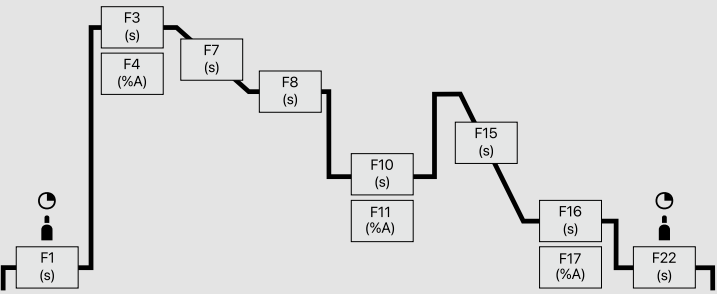
Dimensions (W, L, H)  
Certification

400 V  
- 10 % / + 15 %  
10 A  
350 A  
350 A %40, 300 A %60, 250 A %100  
350 A %40, 300 A %60, 250 A %100  
350 A %40, 300 A %60, 250 A %100  
68 V - 82 V  
1.0 + 1.2 mm / Steel  
Liquid Cooled 88 kg  
5m Power Cable ( 4x 2.5mm<sup>2</sup> )  
3m Earth Clamp ( 50mm<sup>2</sup> )  
Interconnection H.P ( 5m )  
Torch, XM50 4m  
532mm x 860mm x 974mm  
CE

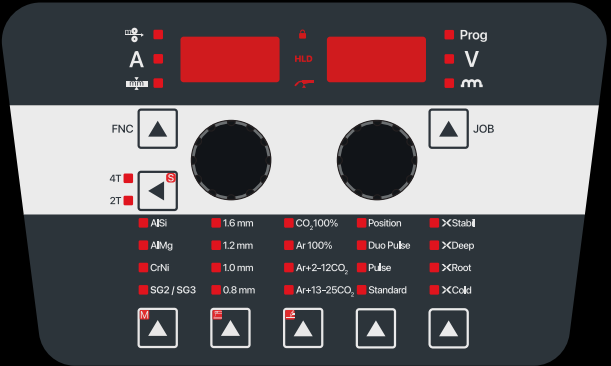
400 V  
- 10 % / + 15 %  
10 A  
350 A  
350 A %40, 300 A %60, 250 A %100  
350 A %40, 300 A %60, 250 A %100  
350 A %40, 300 A %60, 250 A %100  
68 V - 82 V  
1.0 + 1.2 mm / Steel  
Air Cooled , 86 kg  
5m Power Cable ( 4x2.5mm<sup>2</sup> )  
3m Earth Clamp ( 50mm<sup>2</sup> )  
Interconnection H.P ( 5m )  
Torch, MX36 4m  
532mm x 624mm x 974mm  
CE

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

| Standard-Pulse         |                                                                                              | 0.8                                                                    | 1.0 | 1.2                | 1.6                        | XDeep - Pulse              |                                                                                    | 0.8                                            | 1.0                          | 1.2              | 1.6 |     |
|------------------------|----------------------------------------------------------------------------------------------|------------------------------------------------------------------------|-----|--------------------|----------------------------|----------------------------|------------------------------------------------------------------------------------|------------------------------------------------|------------------------------|------------------|-----|-----|
| CrNi                   | SG2 / SG3<br>G3Si1 / G4Si1                                                                   | Ar+18%CO <sub>2</sub><br>Ar+10%CO <sub>2</sub><br>CO <sub>2</sub> 100% | 8   | 10                 | 12                         | 16                         | SG2 / SG3<br>G3Si1 / G4Si1                                                         | Ar+18%CO <sub>2</sub><br>Ar+10%CO <sub>2</sub> | 298                          | 300              | 302 | 306 |
|                        | 318 / 1.4576<br>316 / 1.4430<br>310 / 1.4842<br>309 / 1.4332<br>308 / 1.4316<br>307 / 1.4370 | Ar+2.5%CO <sub>2</sub>                                                 | 28  | 30                 | 32                         | 36                         | 318 / 1.4576                                                                       | Ar+2.5%CO <sub>2</sub>                         | 308                          | 310              | 312 | 316 |
|                        |                                                                                              |                                                                        | 38  | 40                 | 42                         | 46                         | 620                                                                                |                                                | 622                          | 626              |     |     |
|                        |                                                                                              |                                                                        | 68  | 70                 | 72                         | 76                         | 840                                                                                |                                                | 842                          | 846              |     |     |
|                        |                                                                                              |                                                                        | 520 | 522                | 524                        | 660                        | 662                                                                                |                                                |                              |                  |     |     |
|                        |                                                                                              |                                                                        | 538 | 540                | 542                        | 546                        | 670                                                                                |                                                | 672                          | 676              |     |     |
|                        |                                                                                              |                                                                        | 58  | 60                 | 62                         | 66                         | 320                                                                                |                                                | 322                          | 326              |     |     |
|                        | 48                                                                                           | 50                                                                     | 52  | 56                 |                            | 632                        | 636                                                                                |                                                |                              |                  |     |     |
|                        | 78                                                                                           | 80                                                                     | 82  | 86                 | 650                        | 652                        | 656                                                                                |                                                |                              |                  |     |     |
|                        | Duplex 2209<br>1.4462                                                                        | Ar+20%He+2%CO <sub>2</sub>                                             | 88  | 90                 | 92                         | 96                         | Duplex 2209 1.4462                                                                 |                                                |                              |                  |     |     |
|                        | CuSi                                                                                         | Ar100%                                                                 | 178 | 180                | 182                        | 186                        | AlMg4.5 Mn                                                                         | Ar100%                                         |                              | 332              | 336 |     |
| Ar+2.5%CO <sub>2</sub> |                                                                                              | 558                                                                    | 560 | 562                | 566                        | AlSi                       | Ar100%                                                                             |                                                | 342                          | 346              |     |     |
| Ar100%                 |                                                                                              | 188                                                                    | 190 | 192                | 196                        | A199                       | Ar100%                                                                             |                                                | 352                          | 356              |     |     |
| Ar100%                 |                                                                                              | 198                                                                    | 200 | 202                | 206                        | CrNi / FluxCore Metal      | Ar+18%CO <sub>2</sub>                                                              | 608                                            | 610                          | 612              | 616 |     |
| Ar+2.5%CO <sub>2</sub> |                                                                                              | 208                                                                    | 210 | 212                | 216                        | XRoot - Pulse              |                                                                                    | 0.8 <td>1.0<td>1.2<td>1.6</td></td></td>       | 1.0 <td>1.2<td>1.6</td></td> | 1.2 <td>1.6</td> | 1.6 |     |
| Ar100%                 |                                                                                              | 218                                                                    | 220 | 222                | 226                        | SG2 / SG3<br>G3Si1 / G4Si1 | Ar+18%CO <sub>2</sub><br>CO <sub>2</sub> 100%<br>Ar+10%CO <sub>2</sub>             |                                                | 360                          | 362              |     |     |
| Ar+2.5%CO <sub>2</sub> |                                                                                              | 228                                                                    | 230 | 232                | 236                        |                            |                                                                                    |                                                | 370                          | 372              |     |     |
| Ar100%                 |                                                                                              | 118                                                                    | 120 | 122                | 126                        |                            |                                                                                    |                                                | 500                          | 502              |     |     |
| Ar+30%He               |                                                                                              | 128                                                                    | 130 | 132                | 136                        | XCold - Pulse              |                                                                                    | 0.8 <td>1.0<td>1.2<td>1.6</td></td></td>       | 1.0 <td>1.2<td>1.6</td></td> | 1.2 <td>1.6</td> | 1.6 |     |
| Ar100%                 |                                                                                              | 530                                                                    | 532 | 534                | 536                        | SG2 / SG3<br>G3Si1 / G4Si1 | Ar+18%CO <sub>2</sub><br>CO <sub>2</sub> 100%<br>Ar+10%CO <sub>2</sub>             | 378                                            | 380                          | 382              | 386 |     |
| AlMg3                  |                                                                                              | Ar100%                                                                 | 138 | 140                | 142                        | 146                        | 318 / 1.4576<br>316 / 1.4430<br>308 / 1.4316<br>307 / 1.4370<br>Duplex 2209 1.4462 | Ar+2.5%CO <sub>2</sub>                         | 678                          | 680              | 682 |     |
|                        | Ar100%                                                                                       | 148                                                                    | 150 | 152                | 156                        | 698                        |                                                                                    |                                                | 700                          | 702              |     |     |
|                        | Ar+30%He                                                                                     | 158                                                                    | 160 | 162                | 166                        | 398                        |                                                                                    |                                                | 400                          | 402              |     |     |
|                        | Ar100%                                                                                       | 168                                                                    | 170 | 172                | 176                        | 688                        |                                                                                    |                                                | 690                          | 692              |     |     |
|                        | Ar100%                                                                                       | 708                                                                    | 710 | 712                | 716                        |                            |                                                                                    |                                                |                              |                  |     |     |
|                        | Ar100%                                                                                       | 410                                                                    | 412 |                    |                            |                            |                                                                                    |                                                |                              |                  |     |     |
|                        | AlMg3                                                                                        | Ar100%                                                                 | 420 | 422                |                            |                            | AlSi                                                                               | Ar100%                                         |                              | 430              | 432 |     |
|                        |                                                                                              | Ar100%                                                                 | 430 | 432                |                            |                            | A199                                                                               | Ar100%                                         |                              | 440              | 442 |     |
|                        |                                                                                              | Ar100%                                                                 | 440 | 442                |                            |                            | CuSi Brazing                                                                       | Ar100%                                         | 438                          | 440              | 442 |     |
|                        |                                                                                              | Ar100%                                                                 | 448 | 450                | 452                        | 456                        | CuAl Brazing                                                                       | Ar100%                                         | 448                          | 450              | 452 |     |
|                        |                                                                                              | Ar100%                                                                 | 460 | 462                |                            |                            | AlSi Brazing                                                                       | Ar100%                                         | 460                          | 462              |     |     |
| Ar100%                 |                                                                                              | 470                                                                    | 472 |                    |                            | ZnAl Brazing               | Ar100%                                                                             | 470                                            | 472                          |                  |     |     |
| Ar100%                 |                                                                                              | 490                                                                    | 492 |                    |                            | ZnAl (St to Al Welding)    | Ar100%                                                                             | 490                                            | 492                          |                  |     |     |
| Ar+30%He               |                                                                                              | 572                                                                    | 576 |                    |                            | Mg / Mg                    | Ar+30%He                                                                           |                                                | 572                          | 576              |     |     |
| Application            |                                                                                              |                                                                        |     |                    |                            | Cladding                   |                                                                                    | 0.8 <td>1.0<td>1.2<td>1.6</td></td></td>       | 1.0 <td>1.2<td>1.6</td></td> | 1.2 <td>1.6</td> | 1.6 |     |
| MIG/MAG Manual         |                                                                                              | 4                                                                      |     |                    | NiCr-6625 / 2.4831         | Ar+30%He                   | 100                                                                                | 102                                            | 106                          |                  |     |     |
| TIG (Lift Arc)         |                                                                                              | 5                                                                      |     |                    | Ar+20%He+2%CO <sub>2</sub> | 110                        | 112                                                                                | 116                                            |                              |                  |     |     |
| MMA                    | 6                                                                                            |                                                                        |     | NiCr-6617 / 2.4627 | Ar+30%He                   | 552                        | 556                                                                                |                                                |                              |                  |     |     |
| Gouging                | 7                                                                                            |                                                                        |     | Ar100%             | 532                        | 536                        |                                                                                    |                                                |                              |                  |     |     |

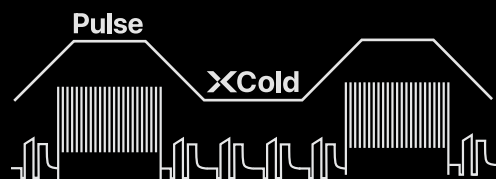


| MIG/MAG | Function | Description                      | Min  | Max  |
|---------|----------|----------------------------------|------|------|
|         | F1       | Gas pre-flow (s)                 | 0    | 10   |
|         | F2       | Start wire speed (m/min)         | 1.5  | 11   |
|         | F3       | 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    |
|         | F8       | Duo peak time (s)                | 0.05 | 10   |
|         | F10      | Duo base time (s)                | 0.05 | 10   |
|         | F11      | Duo base amper (%)               | 1    | 100  |
| MMA     | F12      | Duo base arc correction (v)      | -9.9 | +9.9 |
|         | F15      | End down slope (s)               | 0    | 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 (-)                | 0    | 15   |
|         | 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    | 10   |
| OTHERS  | 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    |
| TIG     | 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   |
|         | F48      | Status light template            | 0    | 4    |
|         | F49      | Working mode                     | 0    | 9    |
|         | F50      | RL cable calibration (mOhm)      | 0    | 30   |
|         | F31      | TIG V stop limit (V)             | -    | -    |
|         | F32      | TIG comfort stop sensitivity (V) | -2   | +2   |



Pulse

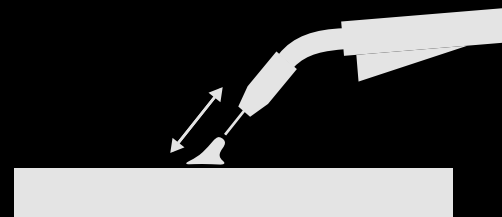
Intuitive User Interface



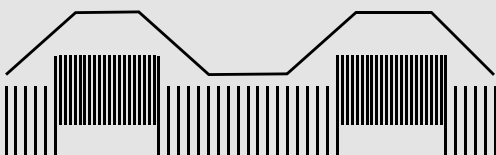
**Position**



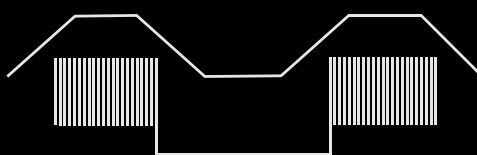
**4x4 Rollers  
Wire Drive**



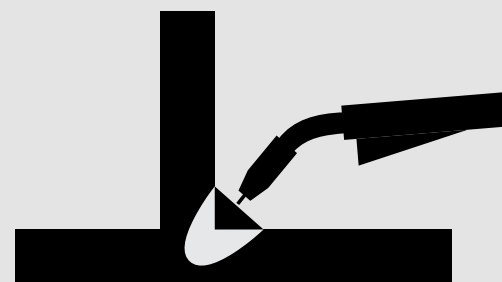
**XStabil**



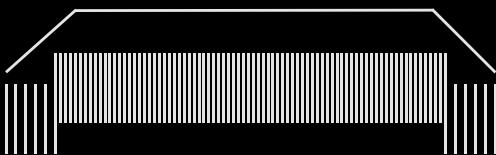
**Duo Pulse**



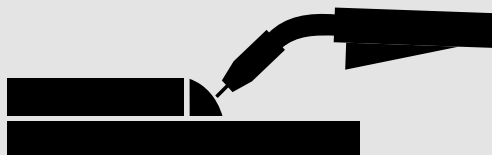
**Twin**



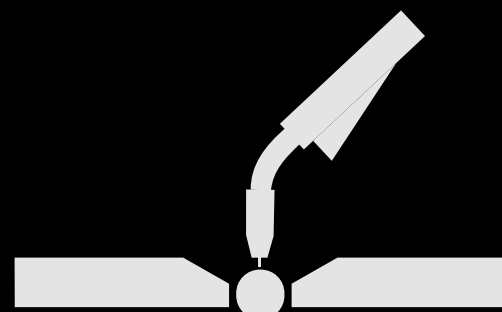
**XDeep**



**Pulse**



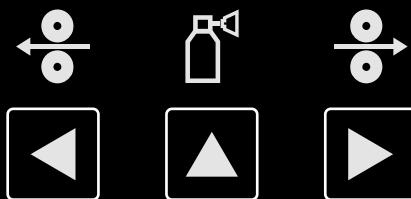
**XCold**



**XRoot**



**25.000 PPS**  
**Wire Speed Control**  
**Perfect Feedability**



**Wire Push**  
**Pull-Back**  
**Gas Testing**



**Spool Cover**  
**With Wire**  
**View**

**99**

**Program**  
**Memory**



**Intelligent**  
**Cooling**

**RL**

**Torch and Cable**  
**Calibration**



**Hose Pack**  
**Support**



**Torch**



**Military**  
**Connector**

**IP23 Design**

**Compact Wire Feeder**

**Industrial Wheels**

**Wire Feeder Wheels\***

**Ergonomic Robust Modular Design**

**Aluminum Gun Holder**

**Spatter Free Ignition**

**Wire Cut Function for Perfect Ignition**

**Wire Feeding Unit with LED Lighting**

**MMA Connection on Wire Feeder**

**Gas Saving System**

**Gas Filter**

**Coolant Liquid Filter**

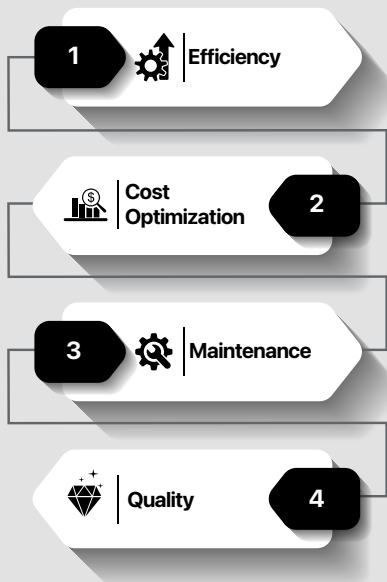
**Extension Cable Holder**

**External Changable Couplings**

**Double Setscrew Plugs**

**Brass-Nut Sockets**

**\* Optional**

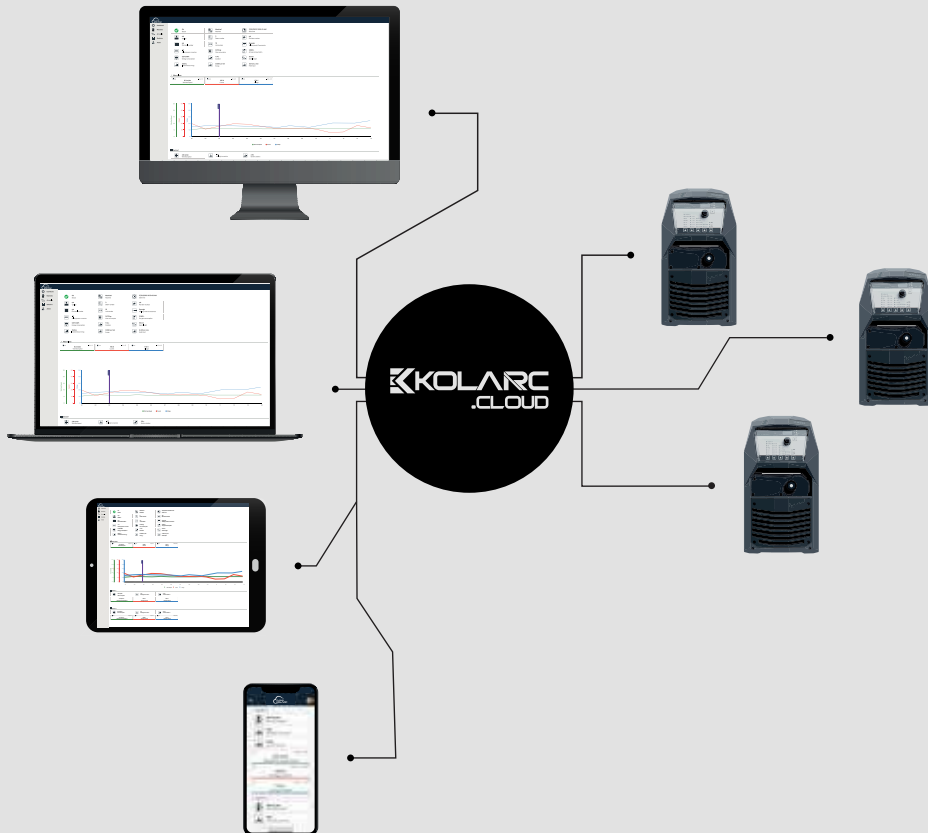


**KOLARC**  
.CLOUD

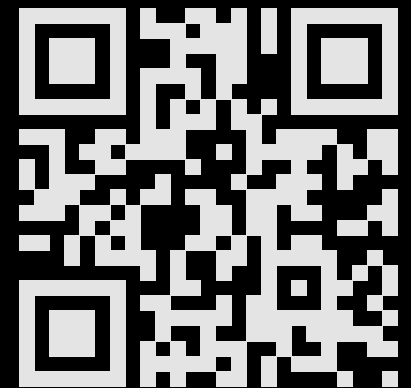
WiFi Bluetooth

LoRaWAN N

Ethernet  
USB Type-C



**KOLARC**



[www.kolarc.com](http://www.kolarc.com)