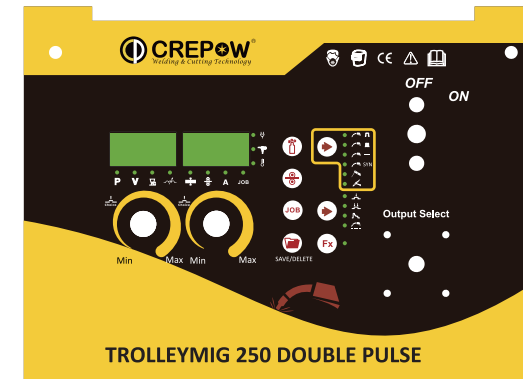
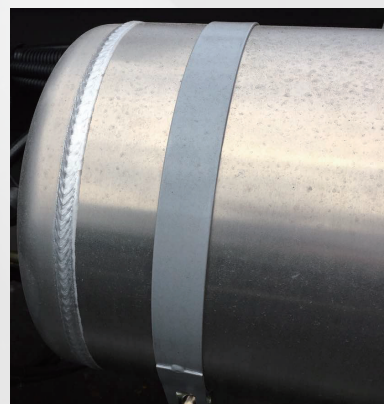
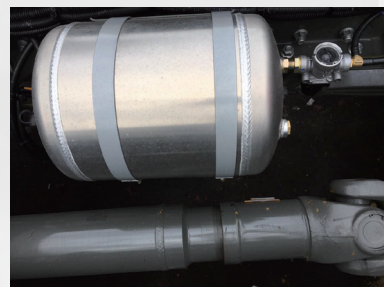


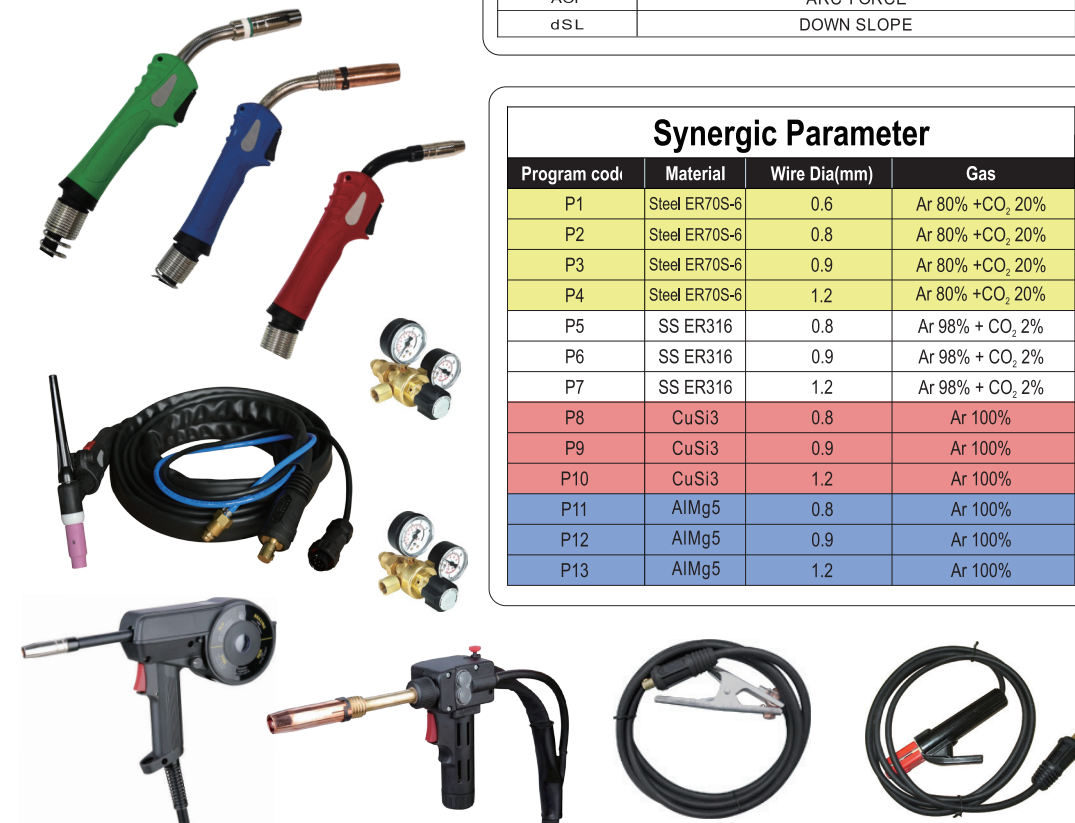
## TROLLEYMIG 250i DOUBLE PULSE with multiprocesses

- TROLLEYMIG 250i DOUBLE PULSE offers four MIG welding modes of Manual, Synergic, Single Pulse and Double Pulse to make quick and easy work on special aluminum and high strength steel alloy applications.
- MIG/MAG with Pulse Synergic, Double Pulse Synergic and Manual programs for aluminum, mild steel, stainless steel and silicone bronze.
- JOB mode can save and call 100 job records.
- Dual Shield gas cylinder supports and gas regulators.
- Single-phase power allows great flexibility for all arc welding requirements around the shop.
- Three internal 4 rolls, gear drive wire feeders
- Three Euro connector outputs for steel, aluminum, silicone bronze.
- Spool gun connector allows controlled feeding of smallest diameter wire for thin panels.
- Push Pull torch is optional.
- DC TIG with thumb-wheel output control, 2T/4T, adjustable up/down slope and pre/post flow.
- 250Amps stick electrode connection with hot start and arc force adjustment.
- Built-in Protection circuit of over temperature and over voltage and over current for better reliability
- PFC technology makes power factor more than 0.99 and energy saving.



| Pulse Parameter |               |              |                             |
|-----------------|---------------|--------------|-----------------------------|
| Program code    | Material      | Wire Dia(mm) | Gas                         |
| P1              | AlMg5         | 0.8          | Ar 100%                     |
| P2              | AlMg5         | 0.9          | Ar 100%                     |
| P3              | AlSi5         | 0.8          | Ar 100%                     |
| P4              | AlMg5         | 1.2          | Ar 100%                     |
| P5              | AlSi5         | 0.9          | Ar 100%                     |
| P6              | AlSi5         | 1.2          | Ar 100%                     |
| P7              | Al99.5        | 1.2          | Ar 100%                     |
| P8              | Steel ER70S-6 | 0.6          | Ar 80% +CO <sub>2</sub> 20% |
| P9              | Steel ER70S-6 | 0.8          | Ar 80% +CO <sub>2</sub> 20% |
| P10             | Steel ER70S-6 | 0.9          | Ar 80% +CO <sub>2</sub> 20% |
| P11             | Steel ER70S-6 | 1.2          | Ar 80% +CO <sub>2</sub> 20% |
| P12             | SS ER316      | 0.8          | Ar 98% + CO <sub>2</sub> 2% |
| P13             | SS ER316      | 0.9          | Ar 98% + CO <sub>2</sub> 2% |
| P14             | CuSi3         | 0.8          | Ar 100%                     |
| P15             | CuSi3         | 0.9          | Ar 100%                     |
| P16             | CuSi3         | 1.2          | Ar 100%                     |

| Display for Function |                                      |
|----------------------|--------------------------------------|
| Display Code         | Function                             |
| PrG                  | Pre Gas                              |
| PoG                  | Post Gas                             |
| SfT                  | Slow Feed Time                       |
| bub                  | Burn Back                            |
| SPT                  | Spot Weld Time                       |
| dPC                  | Delta Pulse Current                  |
| FdP                  | Double Pulse Frequency               |
| dut                  | Double Pulse Duty                    |
| bAL                  | Double Pulse Base Current Arc Length |
| SCP                  | Start Current Percent                |
| SAL                  | Start Current Arc Length             |
| ECP                  | End Current Percent                  |
| EAL                  | End Current Arc Length               |
| SPG                  | Spool Gun                            |
| HSt                  | HOT START                            |
| ACF                  | ARC FORCE                            |
| dSL                  | DOWN SLOPE                           |



| Synergic Parameter |               |              |                             |
|--------------------|---------------|--------------|-----------------------------|
| Program code       | Material      | Wire Dia(mm) | Gas                         |
| P1                 | Steel ER70S-6 | 0.6          | Ar 80% +CO <sub>2</sub> 20% |
| P2                 | Steel ER70S-6 | 0.8          | Ar 80% +CO <sub>2</sub> 20% |
| P3                 | Steel ER70S-6 | 0.9          | Ar 80% +CO <sub>2</sub> 20% |
| P4                 | Steel ER70S-6 | 1.2          | Ar 80% +CO <sub>2</sub> 20% |
| P5                 | SS ER316      | 0.8          | Ar 98% + CO <sub>2</sub> 2% |
| P6                 | SS ER316      | 0.9          | Ar 98% + CO <sub>2</sub> 2% |
| P7                 | SS ER316      | 1.2          | Ar 98% + CO <sub>2</sub> 2% |
| P8                 | CuSi3         | 0.8          | Ar 100%                     |
| P9                 | CuSi3         | 0.9          | Ar 100%                     |
| P10                | CuSi3         | 1.2          | Ar 100%                     |
| P11                | AlMg5         | 0.8          | Ar 100%                     |
| P12                | AlMg5         | 0.9          | Ar 100%                     |
| P13                | AlMg5         | 1.2          | Ar 100%                     |

Industrial

- Processes**
- MIG(GMAW)
  - MIG-P(GMAW-P)
  - FLUX CORED(FCAW)
  - STICK(SMAW)
  - LIFT TIG

### Optional Accessories

- Earth cable and clamp
- Welding cable and holder
- Argon flow meter #00.3173
- Spool Gun-6m #00.2483
- Push Pull Torch(24,26,36) #00.2554
- 15AK-3m #00.2548.05
- 25AK-3m #00.0604.02
- 26AK-3m #00.0609.02
- TIG17C-3m #00.0036.07

| Model  | Effective Input Amps       | KW                            | Welding Current Range (A)              | Welding Voltage Range (V) | Rated Output at 40°C | No-load Volts | Dimension  | Wire Diameter(mm)  | Net weight     | Protection Class |
|--|----------------------------|-------------------------------|--|---------------------------|----------------------|---------------|--|--|----------------|------------------|
| TROLLEYMIG 250i DOUBLE PULSE<br>90-275VAC<br>Single phase<br>50/60Hz | MIG:20<br>TIG:16<br>MMA:21 | MIG:8.0<br>TIG:6.3<br>MMA:9.0 | MIG:40-250<br>TIG:10-250<br>MMA:10-250 | 16-26.5(MIG)              | 250A@30%             | 94            | L:950mm(37.4in.)<br>W:640mm(25.2in.)<br>H:925mm(36.4in.) | Fe:0.6/0.8/0.9/1.0/1.2<br>SS:0.8/0.9/1.0/1.2<br>Flux-cored:0.8/0.9/1.0/1.2<br>Al:0.8/0.9/1.0/1.2 | 78kg(171.9lb.) | IP23             |