

KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Others



DeviceNet

EtherNet/IP

CANopen



PROFINET

EtherCAT



XM600 W

Pulse



TECHNICAL SPECIFICATIONS

Input Voltage	400 V
Mains Voltage Tolerance	- 10 % / + 15 %
Minimum Welding Current	10 A
Maximum Welding Current	600 A
MIG Duty Cycle, 40°C	600 A %60, 500 A %100
TIG Duty Cycle, 40°C	600 A %60, 500 A %100
MMA Duty Cycle, 40°C	600 A %60, 500 A %100
Open – Circuit Voltage	63 V - 82 V
Factory Delivered Roller	1.2 + 1.6 mm / Steel
Weight	Liquid Cooled 107 kg
Standard Accessories	5 m Power Cable (4 x 6 mm ²) 5 m Earth Clamp (95 mm ²) Interconnection H.P (5 m) MX50 Remote Controlled Torch
Dimensions (W, L, H)	532mm x 974mm x 1270mm
Certification	CE

XM500 W

Pulse



Input Voltage	400 V
Mains Voltage Tolerance	- 10 % / + 15 %
Minimum Welding Current	10 A
Maximum Welding Current	500 A
MIG Duty Cycle, 40°C	500 A %40, 430 A %60, 360 A %100
TIG Duty Cycle, 40°C	500 A %40, 430 A %60, 360 A %100
MMA Duty Cycle, 40°C	500 A %40, 430 A %60, 360 A %100
Open – Circuit Voltage	63 V - 82 V
Factory Delivered Roller	1.0 + 1.2 mm / Steel
Weight	Liquid Cooled 107 kg
Standard Accessories	5 m Power Cable (4 x 6 mm ²) 5 m Earth Clamp (70 mm ²) Interconnection H.P (5 m) MX50 Remote Controlled Torch
Dimensions (W, L, H)	532mm x 974mm x 1270mm
Certification	CE

XM400 W

Pulse



400 V
- 10 % / + 15 %
10 A
400 A
400 A %40, 360 A %60, 320 A %100
400 A %40, 360 A %60, 320 A %100
400 A %40, 360 A %60, 320 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 94 kg
5 m Power Cable (4 x 4 mm²)
5 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1178mm
CE

XM350 W

Pulse



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
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 94 kg
5 m Power Cable (4 x 4 mm²)
5 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1178mm
CE

XM320 CW

Pulse



400 V
- 10 % / + 15 %
10 A
320 A
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 88 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
MX50 Remote Controlled Torch
532mm x 860mm x 974mm
CE

XM320 C

Pulse



400 V
- 10 % / + 15 %
10 A
320 A
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 74 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
MX36 Remote Controlled Torch
532mm x 624mm x 974mm
CE

XM270 CW

Pulse



400 V
- 10 % / + 15 %
10 A
270 A
270 A %30, 215 A %60, 185 A %100
270 A %30, 230 A %60, 190 A %100
270 A %35, 220 A %60, 190 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled 34 kg
4 m Power Cable (3 x 2.5 mm²)
5 m Earth Clamp (35 mm²)
Gas Hose (1.5 m)
MX25 Remote Controlled Torch
260mm x 650mm x 450mm
CE

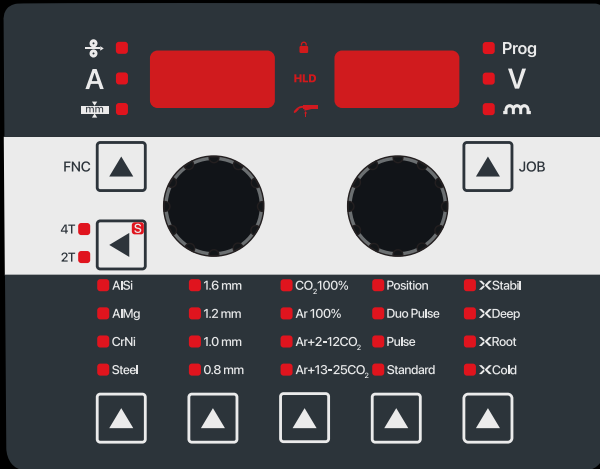
XM220 C

Pulse



230 V
- 10 % / + 15 %
10 A
220 A
210 A %30, 170 A %60, 150 A %100
230 A %35, 200 A %60, 170 A %100
180 A %25, 150 A %60, 130 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled , 34 kg
4 m Power Cable (3 x 2.5 mm²)
5 m Earth Clamp (25 mm²)
Gas Hose (1.5 m)
MX25 Remote Controlled Torch
260mm x 650mm x 450 mm
CE

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



Pulse

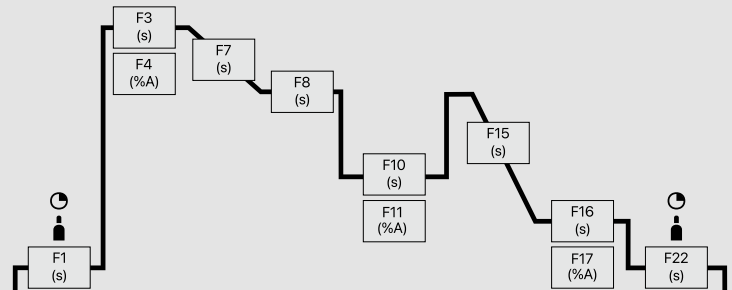
Intuitive User Interface

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

Standard-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
	CO ₂ 100%	28	30	32	36
CrNi	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
CuSi	Ar100%	178	180	182	186
	Ar+2.5%CO ₂	558	560	562	566
CuAl	Ar100%	188	190	192	196
	Ar100%	198	200	202	206
CuSi Brazing	Ar+2.5%CO ₂	208	210	212	216
	Ar100%	218	220	222	226
CuAl Brazing	Ar+2.5%CO ₂	228	230	232	236
	Ar100%	118	120	122	126
AlMg4,5 Mn	Ar+30%He	128	130	132	136
	Ar100%		530	532	536
AlMg3	Ar100%	138	140	142	146
	Ar+30%He	148	150	152	156
AlSi	Ar100%	158	160	162	166
	Ar+30%He	168	170	172	176
Al99	Ar100%				
	Ar+30%He				
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
	CO ₂ 100%			262	266
Steel / FluxCore Rutil	Ar+18%CO ₂			602	
Steel / FluxCore Basic	Ar+18%CO ₂			272	276
CrNi / FluxCore Metal	Ar+2.5%CO ₂			282	286
CrNi / FluxCore Rutil	Ar+18%CO ₂			292	296
CrNi / FluxCore Rutil	CO ₂ 100%			592	
Steel FluxCore High Str.	Ar+18%CO ₂			720	722
Steel / FluxCore Rutil	Self Shielded				

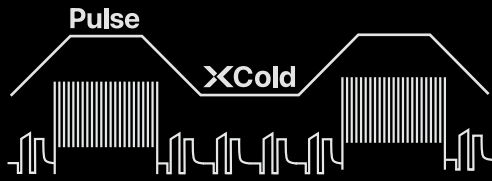
Application		
MIG/MAG Manual		4
TIG (Lift Arc)		5
MMA		6
Gouging		7

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
	CO ₂ 100%			620	622
CrNi	318 / 1.4576			640	642
	316 / 1.4430			660	662
	310 / 1.4842			670	672
	309 / 1.4332			320	322
	308 / 1.4316			632	636
	307 / 1.4370			650	652
	Duplex 2209 1.4462			332	336
	Ar+2.5%CO ₂			342	346
AlMg4,5 Mn	Ar100%			352	356
	Ar100%			360	362
Al99	Ar100%			370	372
	Ar100%			500	502
XRoot - Pulse		0.8	1.0	1.2	1.6
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	608	610	612	616
	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
CrNi	318 / 1.4576			678	680
	316 / 1.4430			698	700
	308 / 1.4316			398	400
	307 / 1.4370			688	690
	Duplex 2209 1.4462			708	710
	Ar+2.5%CO ₂			410	412
	Ar100%			420	422
	Ar100%			430	432
AlMg4,5 Mn	Ar100%			438	440
	Ar100%			448	450
Al99	Ar100%			460	462
	Ar100%			470	472
ZnAl (St to Al Welding)	Ar100%			490	492
	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
	Ar+2.5%CO ₂			542	546
CrNi / 309-2312 / 1.4332	Ar100%			532	536
	Ar100%				

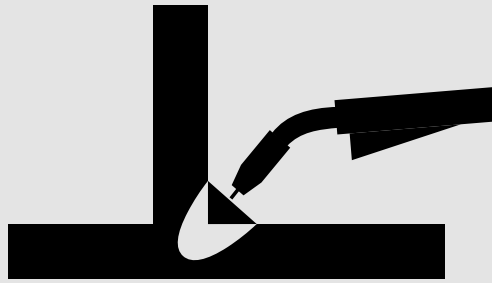


Function	Description	Min	Max
F1	Gas pre-flow (s)	0	10
F2	Start wire speed (m/min)	1	11
F3	Start time (s)	0	10
F4	Start current (%)	1	200
F5	Start arc correction(V)	-9.9	+9.9
F7	Start slope (s)	0	5
F8	Duo peak time (s)	0.05	10
F10	Duo base time (s)	0.05	10
F11	Duo base amper (%)	1	100
F12	Duo base arc correction (v)	-9.9	+9.9
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

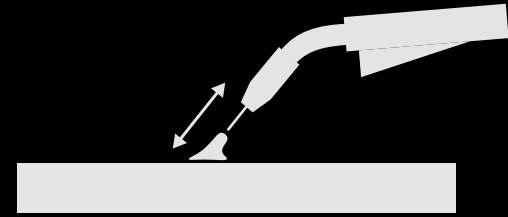
Function	Description	Min	Max
F25	Hot start time (s)	0	10
F26	Hot start current (%)	1	200
F27	Arc force (-)	-50	+50
F28	Antistick (s)	0	2
F29	VRD function (-)	0	1
F34	Tack/stich mode (-)	0	2
F35	Cooling mode (-)	0	4
F36	Motor current (A)	0	-
F37	Motor current limit (A)	0.7	7
F38	Auto load default values (-)	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
F31	TIG V stop limit (V)	10	30
F32	TIG comfort stop sensitivity (V)	-2	+2



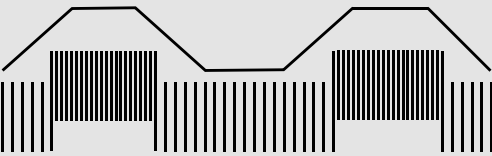
Position



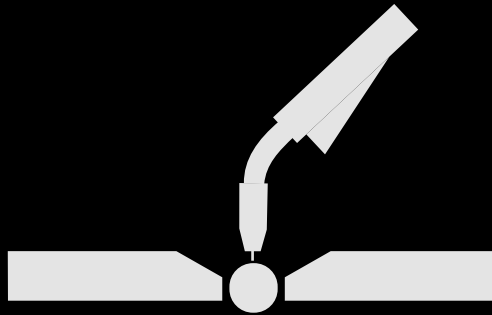
XCDeep



XStabil



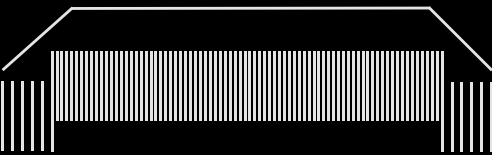
Duo Pulse



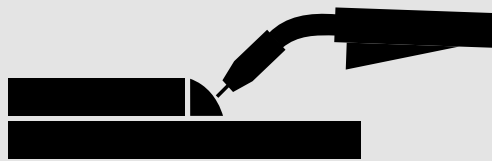
XRoot



**4x4 Rollers
Wire Drive**



Pulse



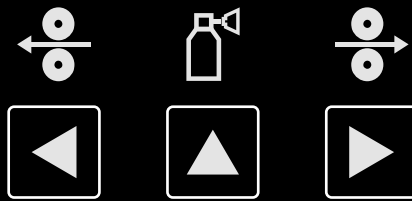
XCold



**Remote
Controlled Torch**



**25000
Times Per Second
Wire Speed Control**



**Wire Push
Pull-Back
Gas Testing**



**Spool Cover
With Wire
View**

99

**Program
Memory**



**Intelligent
Cooling**

RL

**Torch and Cable
Calibration**



**Hose Pack
Support**

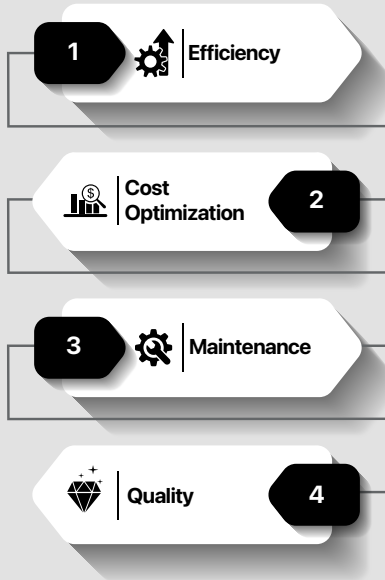


**Military
Connector**

**Ergonomic
Robust
Modular
Design**

KOLARC .CLOUD

KOLARC



LoRaWAN



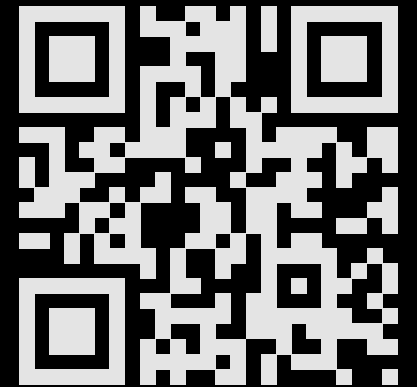
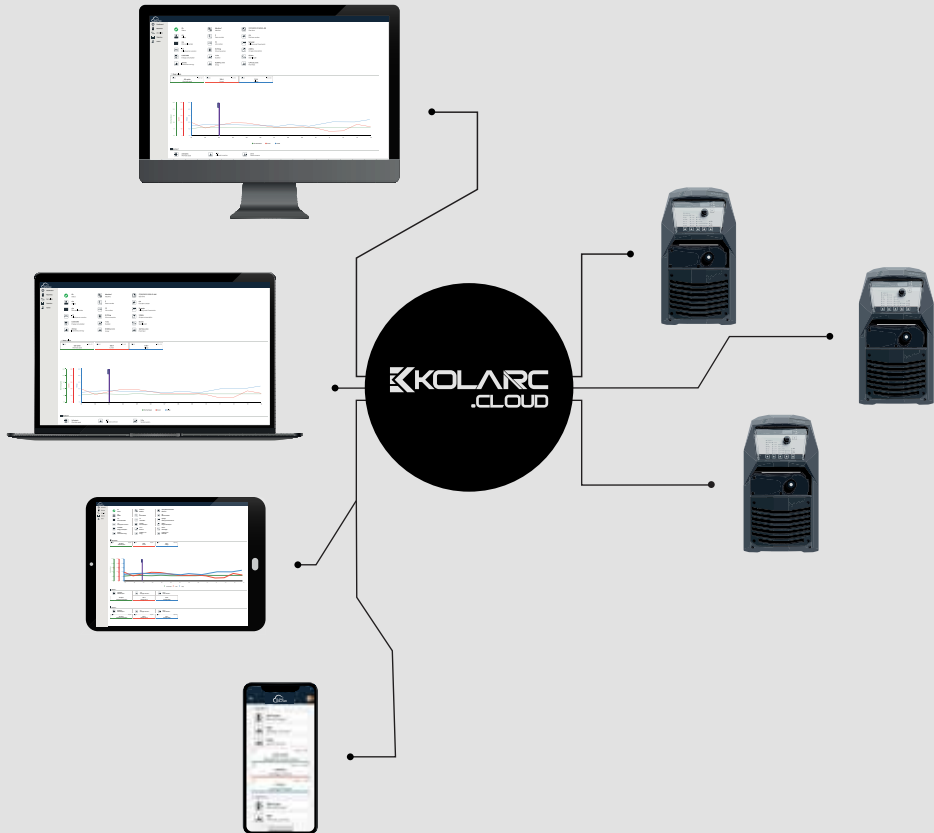
Bluetooth



RS 485



CAN-FD



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