

KOLARC

BUILDING THE FUTURE



Robotic Interfaces

Ethernet

Others



DeviceNet

EtherNet/IP

CANopen



EtherCAT



XM320 CW
Pulse



XM320 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

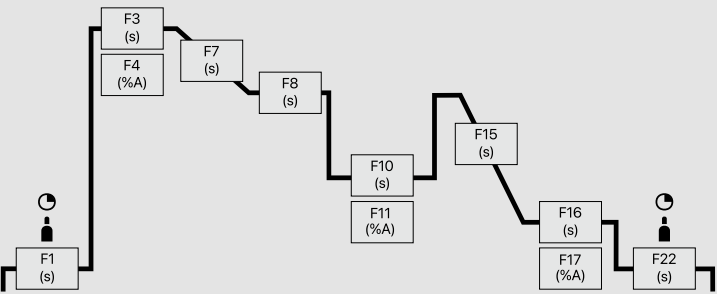
400 V
- 10 % / + 15 %
10 A
320 A
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
68 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 88 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
XM50 Remote Controlled Torch
532mm x 860mm x 974mm
CE

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
68 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled , 86 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
MX36 Remote Controlled Torch
532mm x 624mm x 974mm
CE

It's Manual Or Robotic.

Experience 406* welding programs

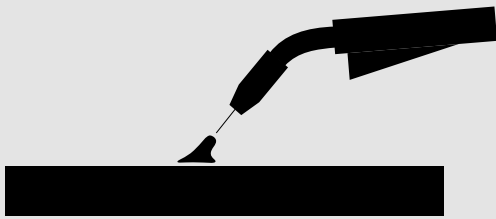
Standard-Pulse			0.8	1.0	1.2	1.6	XDeep - Pulse			0.8	1.0	1.2	1.6
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	8	10	12	16	SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	298	300	302	306		
	Ar+10%CO ₂	18	20	22	26		Ar+10%CO ₂	308	310	312	316		
	CO ₂ 100%	28	30	32	36								
CrNi	318 / 1.4576	Ar+2.5%CO ₂	38	40	42	46	318 / 1.4576	Ar+2.5%CO ₂	620	622	626		
	316 / 1.4430		68	70	72	76	316 / 1.4430		640	642	646		
	310 / 1.4842		520	522			310 / 1.4842		660	662			
	309 / 1.4332		538	540	542	546	309 / 1.4332		670	672	676		
	308 / 1.4316		58	60	62	66	308 / 1.4316		320	322	326		
	307 / 1.4370		48	50	52	56	307 / 1.4370			632	636		
	Duplex 2209 1.4462		78	80	82	86	Duplex 2209 1.4462			650	652	656	
CrNi / FluxCore Metal	Ar+20%He+2%CO ₂	88	90	92	96	AlMg4,5 Mn	Ar100%			332	336		
	Ar100%	178	180	182	186	AlSi	Ar100%			342	346		
	Ar+2.5%CO ₂	558	560	562	566	Al99	Ar100%			352	356		
CuSi	Ar100%	188	190	192	196	CrNi / FluxCore Metal	Ar+18%CO ₂	608	610	612	616		
	Ar100%	198	200	202	206								
CuSi Brazing	Ar100%	208	210	212	216	XRoot - Pulse			0.8 <th>1.0</th> <th>1.2</th> <th>1.6</th>	1.0	1.2	1.6	
	Ar+2.5%CO ₂	218	220	222	226	SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂			360	362		
CuAl Brazing	Ar100%	228	230	232	236		CO ₂ 100%			370	372		
	Ar+2.5%CO ₂	238	240	242	246		Ar+10%CO ₂			500	502		
AlMg4,5 Mn	Ar100%	118	120	122	126	XCold - Pulse			0.8 <th>1.0</th> <th>1.2</th> <th>1.6</th>	1.0	1.2	1.6	
	Ar+30%He	128	130	132	136	SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	378	380	382	386		
AlMg3	Ar100%	530	532	536			CO ₂ 100%	388	390	392			
	Ar100%	138	140	142	146		Ar+10%CO ₂	510	512				
AlSi	Ar100%	148	150	152	156	CrNi	318 / 1.4576	Ar+2.5%CO ₂	678	680	682		
	Ar+30%He	158	160	162	166		316 / 1.4430		698	700	702		
Ar100%	168	170	172	176	310 / 1.4842		398		400	402			
Ar100%	178	180	182	186	309 / 1.4332		688		690	692			
Ar100%	188	190	192	196	308 / 1.4316		708		710	712			
Al99	Ar100%	198	200	202	206	Duplex 2209 1.4462							
	Ar+30%He	208	210	212	216								
Flux Cored Wire			0.8 <th>1.0</th> <th>1.2</th> <th>1.6</th> <td>AlMg4,5 Mn</td> <td>Ar100%</td> <td>410</td> <td>412</td> <td></td>	1.0	1.2	1.6	AlMg4,5 Mn	Ar100%	410	412			
Steel / FluxCore Metal	Ar+18%CO ₂	238	240	242	246	AlSi	Ar100%	420	422				
Steel / FluxCore Rutil	Ar+18%CO ₂	248	250	252	256	Al99	Ar100%	430	432				
Steel / FluxCore Basic	Ar+18%CO ₂				602	CuSi Brazing	Ar100%	438	440	442			
CrNi / FluxCore Metal	Ar+2.5%CO ₂				272	CuAl Brazing	Ar100%	448	450	452			
CrNi / FluxCore Rutil	Ar+18%CO ₂				282	AlSi Brazing	Ar100%		460	462			
CrNi / FluxCore Rutil	CO ₂ 100%				292	ZnAl Brazing	Ar100%		470	472			
Steel FluxCore High Str.	Ar+18%CO ₂				592	ZnAl (St to Al Welding)	Ar100%		490	492			
Steel / FluxCore Rutil	Self Shielded	720	722			Mg / Mg	Ar+30%He		572	576			
Application							Cladding			0.8 <th>1.0</th> <th>1.2</th> <th>1.6</th>	1.0	1.2	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 ₂	110	112	116		
MMA			6				NiCr-6617 / 2.4627	Ar+30%He		552	556		
Gouging			7				CrNi / 309-2312 / 1.4332	Ar+2.5%CO ₂	542	546			
							Co - Based	Ar100%		532	536		



MIG/MAG	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
MMA	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
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
	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

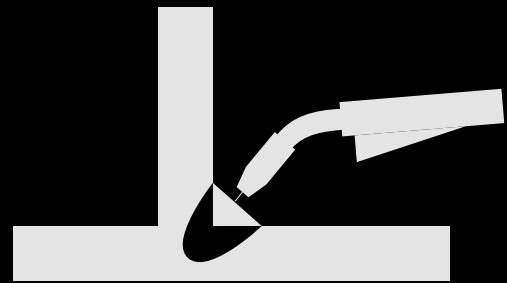
Intuitive User Interface

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



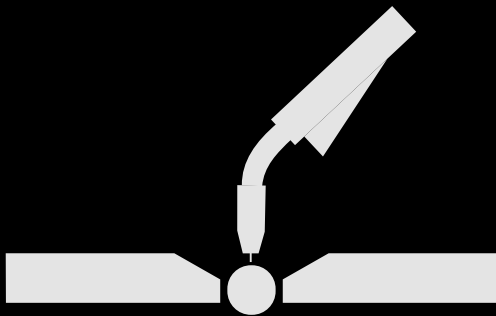
XStabil

If the free wire length is high, the reference current drops, reducing penetration. XStabil increases wire speed to maintain the reference current and constant penetration.



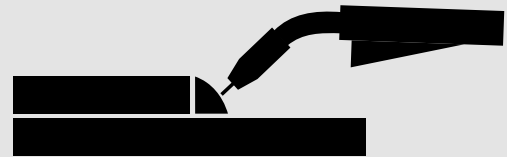
XDeep

XDeep operates in the spray arc area, using high-frequency, low-amplitude current pulses to provide high feed rate and low heat input for steel and stainless steel welding in the PA and PB positions, effectively reducing labor time and welding costs.



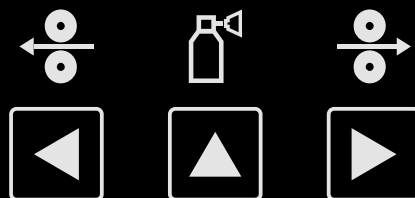
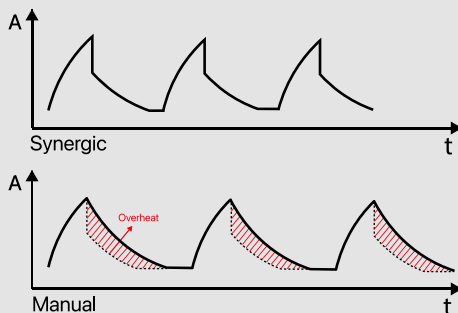
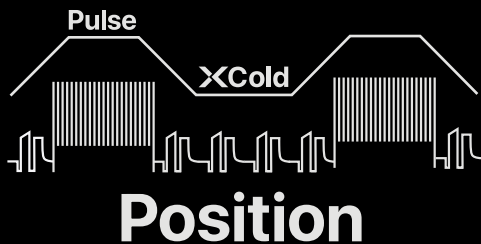
XRoot

XRoot, performing short circuits at a low current level, provides excellent root penetration with high arc pressure for gap bridging in all positions.

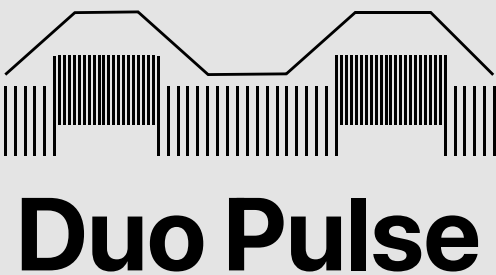


XCold

XCold, performing short circuits at a low current level, enables high melting power and quality weld seams with low heat input.



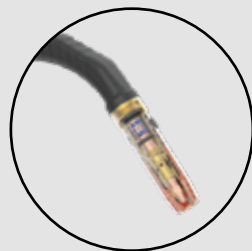
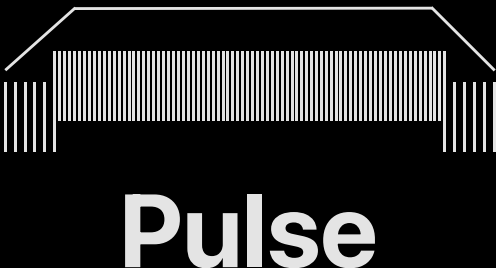
**Wire Push
Pull-Back
Gas Testing**



**25000
Times Per Second
Wire Speed Control**



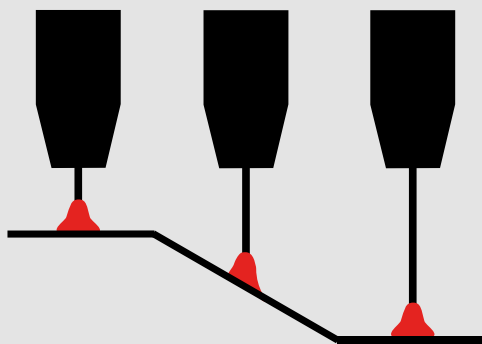
**4x4 Rollers
Wire Drive**



**Dual Liquid
Cooling System**



**Remote
Controlled Torch**



**Adaptive Arc
Control**

IP23

Modular Design



**Spool Cover
With Wire
View**

99

**Program
Memory**



**Intelligent
Cooling**

RL

**Torch and Cable
Calibration**



**Hose Pack
Support**



**Military
Connector**

**Ergonomic
Robust
Modular
Design**

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

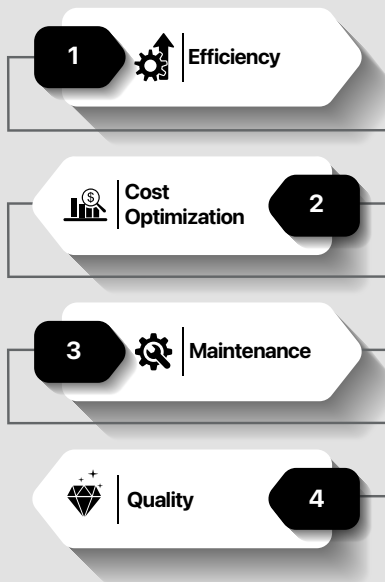
External Changable Couplings

Plug Double Setscrew

Socket Brass-Nut

Industrial Wheels

Optional Wire Feeder Wheels



KOLARC
.CLOUD

LoRaWAN



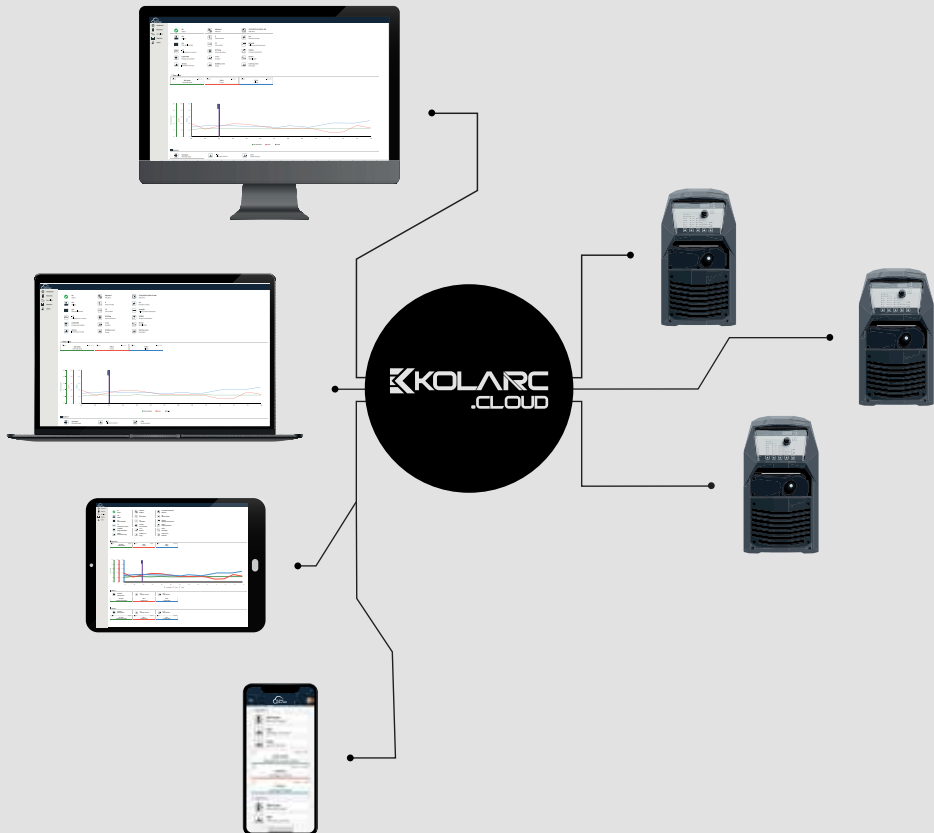
Bluetooth



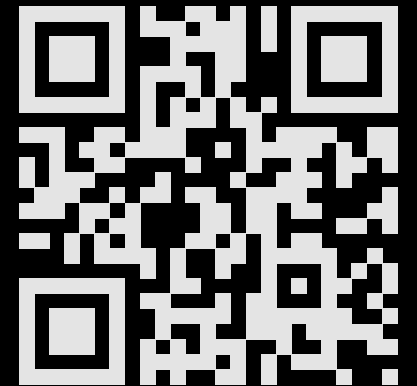
RS 485



CAN-FD



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