

Fanmig 322 Pulse MOST Semi-Automatic Welding Inverter



Fanmig 322 Pulse is a cutting edge semi-automatic welding inverter machine designed for MIG/MAG welding and MMA coated electrode welding. Apart from the short arc welding, Fanmig enables users to weld with MIG/MAG pulse current. Fanmig 322 Pulse is a compact sized device including: electrical power supply and wire feeder are located inside a single housing.

Main advantages of MIG/MAG puls:

- non or minimal spatters,
- smooth face of the seam and seam high aesthetics,
- essential for welding stainless steel and aluminium,
- end crater filling.

The device operates in synergic or manual mode and includes a wide range of programmes for steel, stainless steel and aluminium pulse and short arc welding methods. Thanks to its simplicity in use it is recommended as a first semi-automatic „MIG plus” welding device in your workshop.

The device is powered from a three-phase 400 V. The 4-rolls wire feeder enables wire welding with 5 or 15 kg reels. Recommended steel wire diameters are 0.8 - 1.0 mm and 1.0 mm for aluminium. The inner cell of the wire feeder illuminated with a diode for easy wire installation, roll changing, etc. Device is also fitted with a button for ad hoc wire feed from the new reel.

Main applications:

- light and medium-intensity production or renovation works,
- non-ferrous metal welding,
- crafting, production of light steel structures,
- production of advertisements, racks, furniture. etc.



Simple and modern design of control panel. Parameters setup is performed by means of two multifunctional knobs. LCD shows parameter values during setting adjustments and real-time values during work performance. The LEDs next to the LCD informs which parameter is presented and what is the used unit: A, V or s. It is possible to save up to 6 personalized programmes entered to memory with buttons from 1 to 6.

Technical parameters

Parameter	Fanmig 322 Pulse	
Welding method	MIG/MAG	MMA
Electrical power supply [V]	3x400/ 50/60 Hz	
Fuse [A]	16 (slow)	
Max. current drawn from the network I_L	23,9	22,9
Effective current I	13,3	12,8
Welding current range [A/V]	20 A/15,0 V – 315 A/29,8 V	10 A/20,4 V – 300 A/32,0 V
Open circuit voltage U_0 [V]	63,0	
Welding current [A] at:		
•100% duty cycle	210 A / 24,5 V	190 A / 27,6 V
•60% duty cycle	250 A / 26,5 V	230 A / 29,2 V
•duty cycle for max. current	25% / 315 A / 29,8 V	20% / 300 A / 32,0 V
Welding current set point	Stepless	
Wire feeder	4-rolls	
Wire feeding speed [m/min]	1 – 20	X
Welding torch cooling	Air	
Welding Torch (gas)	See options	
Weight [kg]	47,6	
Protection class	IP 23S	
Insulation class	H	
Dimensions [mm] height x length x width	670 x 911 x 474	

Device is delivered in cardboard box with power plug included (CEE 16 A). The equipment includes a ground cable, gas hose and user manual. the wire feeder has rollers for 0.8-1.0 mm steel wire welding.

Catalogue no. for Fanmig 322 Pulse 51 00 023910

Additional welding guns/holders and accessories (optional):

Welding torch M24 SGRIP 3 m	55 08 302430
Welding torch M24 SGRIP 4 m	55 08 302440
Welding torch M24 SGRIP 5 m	55 08 302450
Welding torch M38 SGRIP 3 m	55 08 303830
Welding torch M38 SGRIP 4 m	55 08 303840
Welding torch M38 SGRIP 5 m	55 08 303850
Welding torch Digimig 355 with UP/DOWN and display 3 m	55 08 308003
Welding torch Digimig 355 with UP/DOWN and display 4 m	55 08 308004
Welding torch Digimig 355 with UP/DOWN and display 5 m	55 08 308005

Roll 0.8-1.0 51 13 007808 (supplied)

Roll 0.6-0.8 51 13 007793

Roll 1.0-1.2 51 13 007865

Accessories for aluminium welding and brazing (recommended wire diameter 1.0 mm):

Roll 1.0AL-1.2AL 51 13 007809

Graphite-teflon liners for welding torch: 55 13 013010 (3 m); 55 13 013020 (4 m); 55 13 013030 (5 m)

Brass tube for EURO connection: 51 13 008011.

Note: while welding with pulsating current welding torch heating increases (by approx. 30%). Please apply welding work cycles provided by manufacturer welding torch devices. Solution to this issue is an application of cooling for welding torch liquid eg. by connecting Fancool 601-WA as additional cooling unit (cat no. 50 03 003805).

Warranty: 24 months

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