

## Industrial Semi-Automatic Welding Inverter Machine FANMIG 522i Pulse



Among all devices from MOST there is now a completely new power source for MIG/MAG, Lift-TIG DC and MMA coated electrode welding – the Fanmig 522i Pulse.

Fanmig 522i Pulse is an industrial purpose designed device. Welding current of 500 A/40% for MIG/MAG and MMA coated electrode MMA welding methods is suitable for all users. Ability for MIG/MAG pulse current welding allows achieving welds quality level unattainable in a normal short arc. MIG/MAG pulse current is particularly useful for spineless steel and aluminium welding. The device can also be used for air electric gauging. TIG DC welding is available in two options: regular and pulse. TIG arc ignition is performed by rubbing the tungsten electrode with LiftTIG material.

Fanmig 522i Pulse has a modular construction. The power source is mounted on the cooler with running gear attached. A separate wire feeder is connected to the power source with a 5 m intermediate cable as standard. Different length of intermediate cables is available on request.

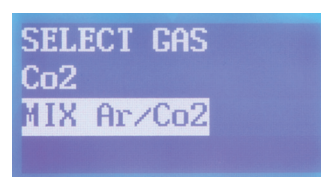
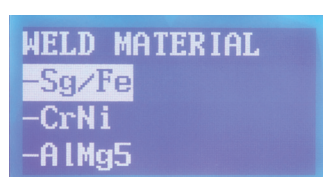
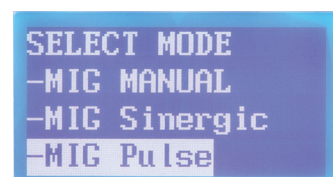
Fanmig 522i Pulse is a digitally controlled synergy device. When selecting synergy mode and the corresponding program, a change to one parameter adjusts all other parameters required for proper welding. The following welding programs are available for MIG/MAG welding with short-circuit and pulsating arc:

Material type and diameter	Program
Carbon steel 0.8 mix 82/18	SG2 0,8 short arc and pulse
Carbon steel 0.9 mix 82/18	SG2 0,9
Carbon steel 1.0 mix 82/18	SG2 1,0 short arc and pulse
Carbon steel 1.2 mix 82/18	SG2 1,2 short arc and pulse
Carbon steel 1.6 mix 82/18	SG2 1,6
Carbon steel 0.8 CO <sub>2</sub>	SG2 0,8 CO <sub>2</sub>
Carbon steel 0.9 CO <sub>2</sub>	SG2 0,9 CO <sub>2</sub>
Carbon steel 1.0 CO <sub>2</sub>	SG2 1,0 CO <sub>2</sub>
Carbon steel 1.2 CO <sub>2</sub>	SG2 1,2 CO <sub>2</sub>
Carbon steel 1.6 CO <sub>2</sub>	SG2 1,6 CO <sub>2</sub>
Stainless steel 0.8	SST 0,8 short arc and pulse
Stainless steel 0.9	SST 0,9
Stainless steel 1.0	SST 1,0 short arc and pulse
Stainless steel 1.2	SST 1,2 short arc and pulse
Stainless steel 1.6	SST 1,6
Magnesium aluminium 1.0	ALMG 1,0
Magnesium aluminium 1.2	ALMG 1,2 short arc and pulse
Magnesium aluminium 1.6	ALMG 1,6
Silicon aluminium 1.0	ALSI 1,0
Silicon aluminium 1.2	ALSI 1,2 short arc and pulse
Silicon aluminium 1.6	ALSI 1,6
Brazing AlBz 0.8	ALBZ 0,8
Powder wire 1.2	FLUX 1,2
Brazing CUSI 0.8	CUSI 0,8
Brazing CUSI 0.9	CUSI 0,9
Brazing CUSI 1.0	CUSI 1,0
Brazing CUSI 1.2	CUSI 1,2



MIG/MAG Pulse = welding without spatter.

Cutting edge control panel with display located in the feeder.



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MMA electrode welding can also be performed after selecting the desired program for various diameters or electrode types. What is important when electrode welding is to equip the device with the VRD function (with the possibility of shutting down), which reduces the open circuit voltage to approx. 20 V for safety purposes.

Synergy may be switched off in order to proceed with manual set point for MIG/MAG, MMA and TIG method.

Device controls are simple and modern. The control panel and parameter displays are located both on the wire feeder and power source. In the power source you only chose the welding method. The actual settings or corrections are being made through feeder device located closer to work spot. For the setting of welding current and arc length there are two gouges located at the feeder front side. Cutting edge panel in the middle of the feeder enables to choose welding programs and functions required for correct operation.

In case of coolant leak none of the current parts or electronics is damaged as the cooling system is located at the bottom of the device. Coolant circuit includes a flow sensor effectively protecting welding torch against a lack of coolant flow.

The device ergonomics was also taken care of. Feeder spins freely being mounted on a spindle, based on the power source. The device is also fitted with wheels to move across the floor freely. Feeder shape provides a short and slim profile helping to fit in tight spaces of welded constructions. At the power source side there is an additional shelf/hanger for intermediate cables or tools. Thanks to special connectors, intermediate cables are secured against being pulled out of feeder or power source sockets.

Technical Specifications	
Power [V]	3x400 V, 50/60 Hz
Power consumption I1 max. [A]	38
Current I1 ef. [A]	24
Power factor	0,95
Open circuit voltage MMA U <sub>0</sub> [V]	72
Welding current range [A]	20-500 (MIG)
	20 – 500 (MMA)
	5-500 (TIG)
Work cycle	MIG:
	500 A/40 V /40%
	316/29,8 V /100%
	MMA:
	500 A/40 V/40%
	316 A/32,6 V/100%
	TIG:
	500 A//30 V/40%
	316 A/22,6 V/100%
Welding current set point	Infinitely smooth
Protection rating	IP 23S wire
feed speed [m/min]	1-20 m
Multifill wire feeder	4-roll
Wire diameter [mm]:	
Steel	0,8-0,9-1,0-1,2-1,6
Aluminium	1,0-1,2
Brazing	0,8-0,9-1,0-1,2
Wire spool [kg]	15
Weight and dimensions:	
Power source:	520x310x500 mm, 36 kg
Power source, cooler and cart:	520x940x900 mm, 70 kg
Power source, cooler, cart, feder and intermediate cables:	520x940x1320 mm, 92 kg



The power source and wire feeder with cable for self-connection are supplied in two separate packages. The liquid cooler device is filled with liquid and the power cord ends with the 32A CEE plug. Ground cable with clamp, gas hose and additional rollers are also delivered. Catalogue no: 51 00 023945

- Accessories:
- Welding torch – recommended MOST M501 SGRIP 3; 4 or 5 m.
  - Feed rolls fi 40 mm – see table in Catalogue RYWAL-RHC
  - Water hose assembly 10 m: 51 00 024010
  - Water hose assembly 15 m: 51 00 024015

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