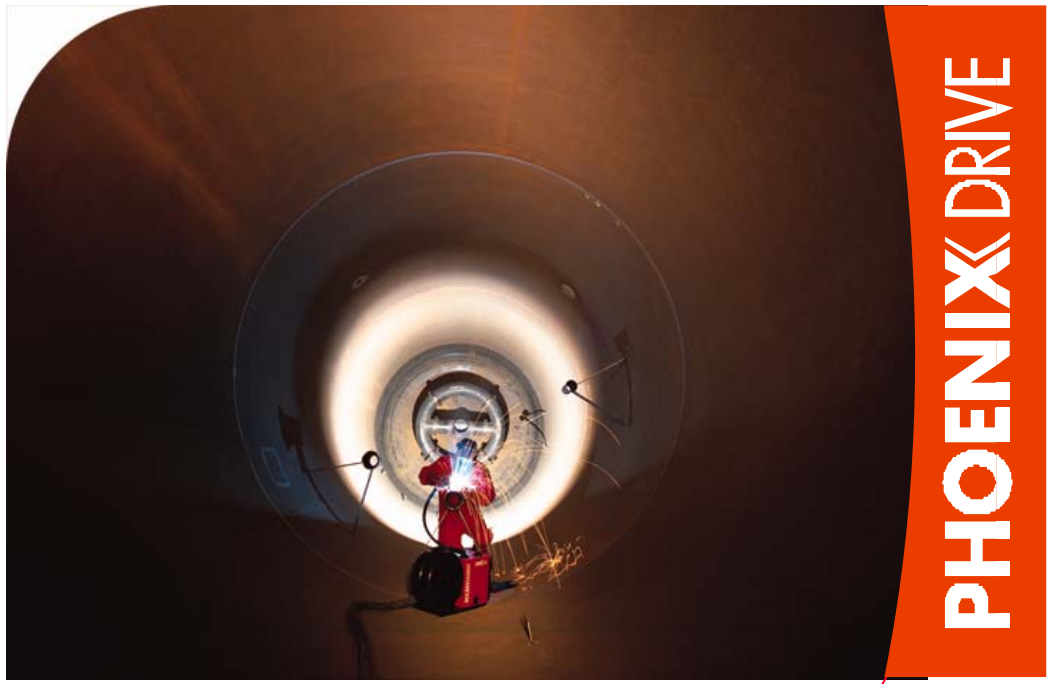
PRODUCT PRESENTATION

Contents



HIGHLIGHTS

Area of Application

M300 Control

Technical Data

HIGHLIGHTS

EVOLUTION

PHOENIX DRIVE 4L

- Lightweight, compact machine for easy transportation
- Easy changing of the wire spool thanks to the open construction
- Can be used with a crane

PHOENIX DRIVE 4

- Robust, enclosed machine for tough industrial usage

- **Main areas of use**
  - Building site, assembly and workshop use
  - Repair and production work

HIGHLIGHTS

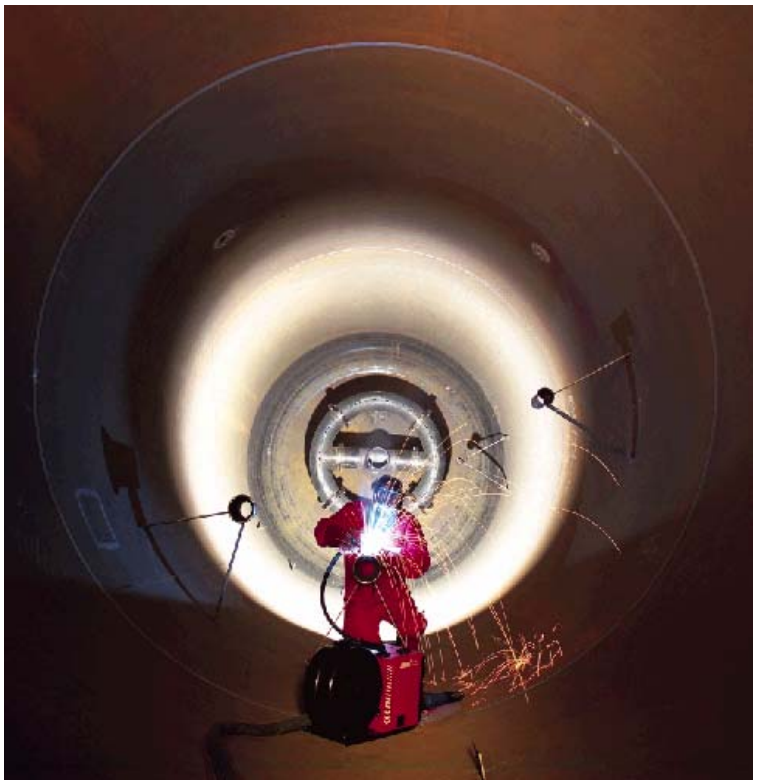
Compact with excellent wire feed

- **Durable, robust and stable metal casing**
- Excellent, constant wire feed even with difficult welding wires thanks to the 4-roller drive, large 37mm rollers and metal construction
- **Easy to service and maintain** - no tools required to change drive rollers, and thanks to plug-in intermediate hose assembly with strain relief

- **Universal, connection options for**
  - ⇨ Binzel , Dinse or compatible torches
  - ⇨ Push/pull torch
  - ⇨ R10 manual remote control
  - ⇨ R40 manual remove control program
  - ⇨ RINT X10 robot interface
  - ⇨ Intermediate drive unit

EVOLUTION X

Area of Application



- **Reliable wire feed over long distances and welding even in inaccessible places** thanks to pre-sets for intermediate drive and push-pull operation as standard
- **Unalloyed, low- and high-alloy steels, aluminium alloys, 0.8 -2.4mm solid and core wire electrodes**
- **Connection options to:**
  - ⇨ Phoenix 360, 500

EVOLUTION XXXXXXXX

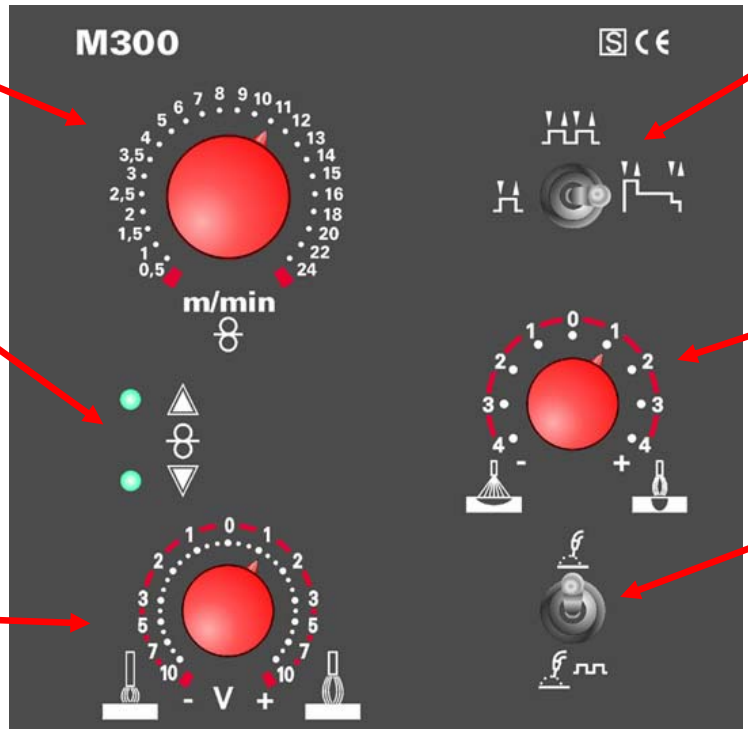
M300 Control

Better results, faster

Selecting WF speed

Setting aid
- indicator for moving outside the optimum characteristics range

Selection of welding voltage correction



Operating mode selection
- non latched / latched
- special, latched: continuous welding with end-crater fill

Rotary dial for setting the welding characteristics in 9 stages:
- driving, hard to soft arc

Welding process selection
- pulse arc MIG/MAG welding
- standard MIG/MAG welding

- **Operating elements in wire feed**
  - Key button for gas test
  - Key button for wire inching (speed can be set via WF potentiometer)
  - Welding torch configuration: Up/Down or program operation
  - Gas post-flow time
  - Wire burn-back time

M300 Control

MIG torch designs, operating variants

Operating elements	Plug	functions
Welding on/off with MIG-standard torch		
1 torch trigger		welding on/off
Retrieval and display of 10 welding programs with special MIG-program torch		
1 torch trigger 1 rocker button 7 segment display	19-pole	welding on/off Retrieval of 10 welding programs and corresponding display of programm number
Infinitely adjustable operating point (Up/Down function) with special MIG-Up/Down torch		
1 torch trigger 2 rocker buttons	19-pole	welding on/off Up-/Down-function (infinitely adjustment of welding voltage and wire feed speed)

TECHNICAL DATA

EVOLUTION

	PHOENIX DRIVE 4	PHOENIX DRIVE 4L
Supply voltage	42VAC	
Max. welding current at 60%ED	500A	
Wire feed speed	0.5m/min to 24m/min	
Standard WF roller fitting	1.0 + 1.2 mm (for steel wire)	
Ambient temperature	-10°C to +40°C	
Torch connection, either option	either Euro-central or Dinse-central	
Drive	4-roller (37mm)	
Dimensions (LxWxH) in mm	680 x 460 x 265	690 x 300 x 410
Weight without accessories	approx. 24kg	approx. 20.5kg
Constructed conforming to standards	EN 60974 / IEC 60974 / VDE 0544 EN 50199 / VDE 0544 Part 206 S symbol / CE / IP23	