

FLEX 330/400/500 XMA (MIG)  
FLEX 400/500 XMA (MMA)

Technical data

POWER SOURCE	FLEX 330 XMA	FLEX 400 XMA	FLEX 500 XMA
Mains voltage	3 x 400	3 x 400	3 x 400
Fuse	16 A	20 A	35 A
Open circuit consumption	35 Watt	35 Watt	35 Watt
Maximum current	19.8 A	25.7 A	44.9 A
Efficiency	0.99	0.99	0.99
Open circuit voltage MMA	80 - 85 V	80 - 85 V	90 - 95 V
Duty cycle, 100% at 40°	250 A	300 A	400 A
Duty cycle, 100% at 20°	270 A	330 A	500 A
Duty cycle, 60% at 40°	280 A	350 A	450 A
Duty cycle, 60% at 20°	300 A	400 A	-
Current range DC	40 - 330 A	40 - 400 A	40 - 400 A
Application class	S	S	S
Protection class	IP 23	IP 23	IP 23
Norm	EN/IEC60974-1 EN/IEC60974-10	EN/IEC60974-1 EN/IEC60974-10	EN/IEC60974-1 EN/IEC60974-10
Dimensions L x W x H	72 x 28 x 54 cm	72 x 28 x 54 cm	72 x 28 x 54 cm
Weight (incl. supply cable)	58 kg	58 kg	59 kg

WIRE FEED UNITS	MWF 11	MWF 21	MPF 10 (intermediary station)
Connection voltage	42 VAC +/- 15%	42 VAC +/- 15%	0 - 40 VDC
Connection power	175 W	175 W	
Duty cycle, 60%	550 A	550 A	550 A
Wire feed speed	1 - 24 m/min.	1 - 24 m/min.	1 - 24 m/min.
Wire reel diameter	300 mm	300 mm	
Wire diameter	0.6 - 2.4 mm	0.6 - 2.4 mm	0.6 - 2.4 mm
Protection class	IP 23	IP 23	IP 23
Dimensions L x W x H	68 x 22 x 49 cm	37 x 27.5 x 23.5 cm	53 x 28 x 19.5 cm
Weight	22 kg	12.7 kg	11.6 kg

COOLING UNIT	MCU 1250
Connection voltage	400 V +/- 15 %
Max. open circuit consumption	5 W
Cooling power	1250 W
Tank volume	4 l
Flow at 1.2 bar/60° C	1.75 l/min.
Max. pressure	2.5 - 3.0 bar
Norm	EN/IEC60974-2
Dimension H x W x L	70 x 30 x 22 cm
Weight (excl. cooling liquid)	16 kg

We reserve the right to make changes.

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MIGATRONIC

FLEX 330/400/500 XMA  
MULTI-MACHINE WITH  
REVOLUTIONARILY  
SIMPLE CONTROL



“Switch on,  
press and  
weld” - it is as  
simple as that

FLEX XMA  
MIG for MIG  
and MMA  
welding

FLEX XMA  
MMA for all  
types of  
electrodes

Control from  
wire feed unit  
or torch

Option:  
connection on  
the wire feed  
unit for MMA  
welding

FLEX XMA  
MIG welds  
all materials  
including  
stainless steel  
and aluminium

Adjustable  
hotstart,  
built-in anti-  
freeze and  
Arc Power

The FLEX XMA MIG/MAG with MWF 11 wire feed unit, cooling unit and 3 m MV 450 torch.



# MIG or MMA welding machines with future- safeguarded options

## Makes quality welding simple and flexible

The Migatron FLEX 330/400/500 range sets new standards for quality and flexibility and makes it easy to make the right choice of welding machine for a company's individual types of welding operations. Competitive power and quality are important parameters - along with the Migatron vision "Switch on, press and weld".



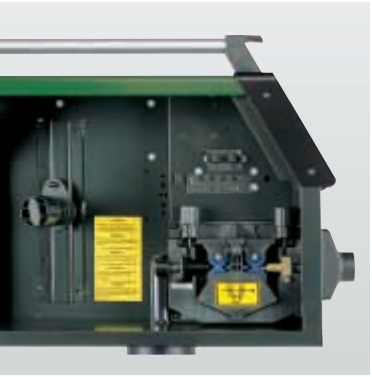
MMA welding in open V-joint with FLEX 330 MMA.



MIG welding with FLEX 330 XMA (MIG).



The FLEX XMA control panel for choice and reading of MMA current or MIG/MAG characteristics.



Migatron's compact and digital MWF 21 wire feed unit and a segment of the closed MWF 11 with synergy kit.

The FLEX XMA has manual, stepless adjustment of the power inverter and control is revolutionarily simple. The FLEX XMA can be used both as a MIG/MAG and a MMA welding machine with 330 A/400 A/500 A respectively at 45% duty cycle and as a multi-process MMA power source with 400 or 500 A.

Common to the three FLEX versions with XMA standard control is the high arc voltage reserve and control from the advanced position on the compact or closed wire feed unit. The desired volt/ampere output is controlled electronically and monitored by only one control unit in the inverter.

### FLEX 330/400/500 XMA MIG

Used by companies that make heavy demands on MIG/MAG welding quality. A synergy kit with 11 steps can be built into the wire feed unit. If used along with the Migatron Dialog torch it creates fine synergy from dip transfer to spray transfer welding.

The FLEX XMA is suitable for welding with all types of coated electrodes, including cellulose and basic electrodes. The machine is also available in a water-cooled version with separate intermediary cable for welding with both solid and flux cored wires.

A standby function makes the cooling system stop after a few minutes idling which reduces noise and current consumption and prolongs life of the machine.

The FLEX 400 with digital MWF 11 wire feed unit.

### FLEX 400/500 XMA MMA

Strong MMA welding machine for welding mild and stainless steel with ordinary or high-yield electrodes. Adjustable hotstart and built-in antifreeze for control of the arc.

As occasion requires the flexible MMA machine can be rebuilt into a versatile MIG industrial welding machine.

### SPECIALS

- "Switch on, press and weld"
- Stepless adjustment of power inverter
- Large arc voltage reserve
- Control from the wire feed unit

