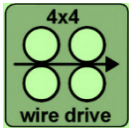


OXFORD MULTIMIG 2Pulse Synergic welding power source



One power source does everything!

Compact MIG + Pulse MIG + MMA + Lift TIG Add 4X MIG wire feeder = SWF MIG



MULTIMIG 2Pulse Synergic models are simple to use, rugged & reliable industrial machines. Providing the same performance advantages as our popular MULTIMIG CS models but with additional pulse & double pulse welding functions. Superb spatter free pulse MIG of Aluminium alloys, stainless steels, mild steel, hardox plate etc.

Key features

- ✓ One power source for compact or SWF MIG with true CC/CV multiprocess capability.
- ✓ Pulse MIG, double pulse MIG, MIG/MAG, Lift TIG & MMA.
- ✓ Ready to plug in our OXFORD 4X wire feeder to make into a separate wire feed machine.
- ✓ Use with the 4X feeder allows set up of 2 different wires such as ALU in power source & steel on feeder.
- ✓ Ready to plug in our OXFORD spool guns.
- ✓ Ready to plug in a TIG torch with switch & gas control with adjustable post flow.
- ✓ Infinitely variable weld power from 20A to max power with precision to 1A & 0.1V.
- ✓ Digital display show set values prior to welding & precise values when welding.
- ✓ Super smooth low spatter MIG welding with perfect welds & instant arc starts without popping.
- ✓ Unique ARC TUNE control allows operator full control over welding characteristics from CV through to CC.
- ✓ Unique ARC TUNE control - variable inductance - fine tune the arc precisely, dial out that spatter etc.
- ✓ Reversible polarity, 2T/4T function, 4Tlo function, adjustable burnback, adjustable gas post flow (ideal for TIG).
- ✓ Auto compensation for extension cables up to 100M & unstable or poor mains input supply.
- ✓ Generator friendly with built in protection from over & under voltage, over temp, over current, etc.
- ✓ High efficiency design & 12-20W standby power reduces running costs & helps the environment.
- ✓ High duty cycles to keep you welding all day long.
- ✓ Rugged case design with galvanised chassis, gas bottle carrier & large wheels.
- ✓ Cooling chamber keeps any dirty airflow away from electronic parts.
- ✓ Low weight & compact size for great portability.
- ✓ Genuinely Industrial machines built to work hard for 25+ years.



Our 'no nonsense' design makes these the easiest pulse MIG on the market to use.

PTO for more information.



OXFORD MULTIMIG 2Pulse Synergic welding power source

MIG - With pulse switched off operation is the same as a standard MULTIMIG CS but with additional synergic function. **True one knob control with superb smooth MIG welding – just like our popular MULTIMIG CS!**

Pulse - turn on & set pulse power to match the welding wire & pulse MIG is in operation. Pulse MIG welding brings maximum benefits when welding aluminium & stainless steel. And for all materials pulse MIG results in spatter free welding. Fantastic for high production welding of aluminium truck bodies, trailers, ali frames, chequer plate etc.

2Pulse - set the 2Pulse control to give double pulse, the frequency can be adjusted to suit your application. 2Pulse controls the heat input to the weldpool, perfect for TIG like welds with a 'stack of cards' appearance but done at the speed of MIG. Also great for very thin materials or any positional welding.

Synergic operation – automatically synchronises the wire feed speed to the welding power to maintain arc length & condition at different welding power settings. For all MIG/MAG processes the synergic wire speed is normally set only once to suit the wire & gas. However, this can be adjusted to change the arc length if needed.

Output power - starts as low as 20A even on pulse MIG, this allows welding right down to 22G (0.75mm) thick material. A digital display is fitted which shows set welding power prior to welding, with exact values shown during welding.

2T-4T operation - MIG, Pulse MIG & TIG all default to 2T operation at switch on. Operation - press the switch to weld – release to stop. Select 4T for torch trigger latching with additional **4Tlo function**. Operation - press & hold the switch to start welding at 4Tlo value (approx. 1/3 of set value), release switch to achieve full set power, press & hold to reduce to 4Tlo value, release to stop weld. This function gives the operator more control at weld starts & allows for crater filling & perfect finishes.

TIG - Plug in our switched TIG torch for DC lift TIG operation, the electrode should be in contact with the material, press the torch switch to start gas & lift the electrode a little to draw an arc. Release the switch to stop. If you require longer gas post flow it can be adjusted – see instruction manual. The pulser control also operates in TIG allowing pulsed DC TIG operation. Electrode polarity is normally negative, for steel/SS etc. However you can swap this to + for TIG welding thin aluminium.

MMA - MMA electrode welding is superb, hot start circuit ensures the rod ignites easily. ARC TUNE control allows adjustable arc force. Super smooth arc welding with either polarity.

Other - Despite the simplicity we have included features to give you superb welding characteristics, with low spatter, instant arc starting (no popping or delays) & full control over the output inductance & arc characteristics. 4 roll drive wire feed on all models ensures consistent hour after hour reliable welding.

Build quality & design – We design & build all our own PCBs, transformers, coils, power assemblies etc. We use NO microprocessors or programmable technology. Built using our rugged 2 IGBT power module technology & simple electronics – **minimum parts & maximum reliability!** Our reliability is the very best, no matter if welding all day in production or storing in a barn for years for occasional jobs.

From a serviceability point our inverter machines are simple, no need for an Electronic degree! We include diagnostic LEDs & test points, all OXFORD machines can be maintained by any competent Technician anywhere in the world.

Basic specs Oxford MULTIMIG 2Pulse Synergic models

Model	Input Voltage	Amps range	Duty cycle @40C - MIG	Rec fuse (D type)	Efficiency & idle power	OCV – no load	Welding wire sizes	Weight approx.
271	230V 1ph	20-270A	270A@35%, 205A@60%	16/25A	84%, 12W	70V DC	0.6-1.0mm	48kg
331	230V 1ph	20-330A	330A@40%, 260A@60%	25/32A	84%, 16W	70V DC	0.6-1.2mm	52kg
411	230V 1ph	20-410A	410A@45%, 355A@60%	32/45A	84%, 16W	72V DC	0.6-1.2mm	55kg
273	400V 3ph	20-270A	270A@35%, 205A@60%	16A	85%, 16W	70V DC	0.6-1.0mm	47kg
333	400V 3ph	20-330A	330A@40%, 260A@60%	16A	85%, 16W	70V DC	0.6-1.2mm	51kg
413	400V 3ph	20-410A	410A@45%, 355A@60%	16/25A	86%, 20W	72V DC	0.6-1.2mm	54kg
513	400V 3ph	30-510A	510A@45%, 450A@60%	25/32A	86%, 20W	72V DC	0.6-1.6mm	60kg

Power source case size 330Wx550Hx620L, with wheels & gas bottle tray fitted overall 460Wx650Hx840L (680H for 411/413 & 513).

Output amps range on MMA & TIG is the same as MIG, MMA duty cycle is reduced by 2% for the 513 up to 6% on the 271/273.

Compliance with BS IEC60974-1, WEE/HD0071UZ, EU2019/1784. Protection - IP23S (suitable for use outside with cover).

MULTIMIG 4X wire feeder - a rugged, ultra-compact feeder built on a tough steel chassis.

4 roll all geared drive for precise feeding of welding wire, fitted with a wire spool cover as standard.

Like our earlier Oxford wire feeders, no electronics or controls are fitted in the 4X feeder – min parts & max reliability.

Just select an interconnecting cable 5M-20M & plug in wire feeder in less than 2 minutes.

Feeder case size 180Wx230Hx420L + extra height for feet + carry handle + extra at rear for wire spool cover, weight 9.8kg.



Options available at time of order.

Water cooling – built in design with torch flow protection. Low noise design, pump only runs as needed with adjustable post run time & option to switch off water cooling.	Internal wire feed system <u>not</u> fitted into power source. For use only with the 4X wire feeder = 5% reduction in power source price.	Socket for remote control of welding power, with option to add control of weld power to 4X wire feeder.	Adjustable 4Tlo power.	Adjustable hot start for MIG/Pulse MIG
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Accessories available to plug in or upgrade at any time after purchase.

MULTIMIG 4X wire feeder fitted with wire spool cover.	Interconnection cables up to 20M to connect power source to 4X feeder	Wire feeder swivel kit, includes all parts to fit power source & feeder.	Wire feeder overhead boom hanging kit (insulated).
Spool on gun torches – Plug directly into front socket.	TIG torches, air cooled or water cooled with full switched control.	MIG welding torches up to 5M.	MMA electrode leads.

Investing in an Oxford welder has been your guarantee of a quality product with the best back up.

Our long term back up is the best in the industry. 2 year warranty all items, 5 year main transformer warranty (the heart of the machine), 20 year minimum guarantee of spares availability.

Further info at www.oxfordwelders.co.uk