PullMig/PullMig JobMaster hose packs

Gascooled/Watercooled

Fronius

PERFECT WELDING

# HIGH-PERFORMANCE TORCHES FOR ALUMINIUM, STEEL AND STAINLESS STEEL WELDING WIRES

OVERALL DESIGN OF PULLMIG TORCHES

The flanged-on gear motor, the pressure lever plus pressure roller and the torch-neck coupling are all fitted on a milled aluminium block. The spring-loaded pressure roller must be set to one of 3 pressure settings - 3, 6 or 10 kg (6.61, 13.22 or 22.05 lb). The max. pressure force is limited to 10 kg (22.05 lb) so as to prevent any overloading of the PullMig motor bearing.

This drive unit - together with its integrated correction potentiometer, the torch trigger and the strain-relief device for the hosepack - is protected by a tough, hard plastic shell.

HOW PULLMIG TORCHES WORK

The motor in Fronius PullMig torches is designed so that most of the work of feeding the wire is done by the torch motor.
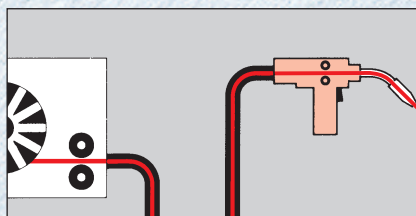
This runs slightly faster than the rear "pusher" motor. In this way, sustained tension (wire-pull) is assured. The feed-roller contact pressure of the pusher motor is set to a very low level. This allows the rollers to slip in the event of a malfunction.

A transparent sliding window makes access to the drive unit very easy. The gas or water-cooled hosepack is made using high-grade materials and is designed for the rough-and-tumble of everyday use.

ROTATABLE TORCH NECK
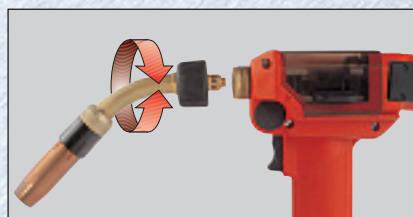
This version has been specially developed to help with difficult jobs in the container or pipeline construction fields.

On the water-cooled torch neck, the water circuit is sealed by O-rings. The neck is designed in such a way that if the cooling unit is accidentally switched on at the same time as the torch neck is unscrewed, the water will seep out to the outside first. The nut can be loosened by up to 3 mm (0.12 in.) and the seal will still be effective towards the inside (i.e. towards the wire electrode).

Special accessories:
For this application, we recommend installing a cooling-unit cut-out in the welding machine.

STANDARD EQUIPMENT

PullMig hose pack
PullMig JobMaster hose pack
Graphite inner liner Ø 2,5 mm (0.1 in.) for Al- and CrNi wires
Pressure and drive roller for wire diameter 0.8 - 1.2 mm (0.03 - 0.05 in.)
Bronze inner liner diameter 2.0 mm (0.08 in.) for ML torch neck Interchangeable torch bodies, torch neck rotates through 360°
Powerful gear-motor unit
Toothed drive and pressure rollers
Spatter protection, with high thermal stability
Contact tube, CuCrZr alloy
Forced, contacting arrangement for welding-wire
Swivel-mounted wirefeed/protective hose
Coaxial cable (on gas-cooled torches)
Rubber anti-kink feature at machine and torch end

PullMig hose pack
Continuously adjustable power

PullMig JobMaster hose pack
Integral remote control
Frequency parameter recall
Parameter correction mode
Recall function for operating points and jobs
Digital parameter display

Torch neck Multilock	Welding current at CO$_2$	Ar/CO$_2$	d.c.	wire Ø mm	wire Ø inch
AL 2300	230 A	200 A	40 %	0.6 - 1.0	0.02 - 0.04
AL 3000	300 A	250 A	40 %	0.8 - 1.2	0.03 - 0.05
AL 4000	400 A	350 A	40 %	1.0 - 1.6	0.04 - 0.06
AL 5000	500 A	400 A	40 %	0.8 - 1.6	0.03 - 0.06
AW 2500	250 A	220 A	100 %	0.6 - 1.2	0.02 - 0.05
AW 4000	400 A	350 A	100 %	0.8 - 1.2	0.03 - 0.05
AW 5000	500 A	400 A	100 %	1.0 - 1.6	0.04 - 0.06
AW 7000	700 A	550 A	100 %	1.0 - 1.6	0.04 - 0.06

PullMig hose pack	Welding current at CO$_2$	Ar/CO$_2$	d.c.	wire Ø mm	wire Ø inch
gascooled	400 A	350 A	40 %	0.8 - 1.6	0.03 - 0.05
watercooled	500 A	400 A	100 %	0.8 - 1.6	0.03 - 0.05
hose pack length	m	6 x 8 x 10			
	ft.	19.7 x 26.2 x 32.8			