



Mobile – flexible – powerful: The MMA specialists for pipe construction



inverter STICK 350 CEL

inverter STICK 350 CEL PWS



MMA welding

HIGHLIGHTS

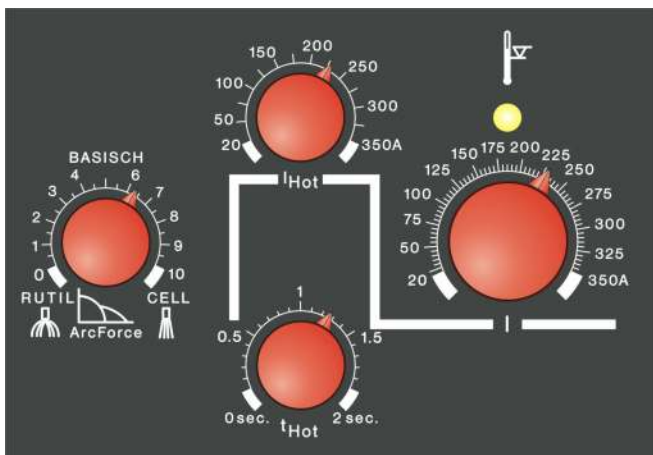
- Ideal for construction sites - optimised for tough assembly work due to the optimised casing design, safe operation on generators and on long mains supply leads
- 100 % dropped seam-proof when welding with cellulose electrodes, particularly also in the lower power range
- CEL PWS - choose the polarity anytime, anywhere via pole reversal on the machine or via the remote control directly on the workstation
- Reproducible, safe ignition - automatic management depending on the electrode being used, high open circuit voltage and infinitely adjustable hotstart current and time
- Excellent welding properties - innovative inverter technology with dynamic control for a stable arc, easy-to-master weld pool, improved and problem-free welding of critical electrodes and adjustment option of the welding characteristic (arcforcing) to all electrode types
- Safe and reliable - integrated temperature monitor for protection against overload, location of the electronics in a low-dust environment and durable metal casing

AREA OF APPLICATION

- Repair and production of machines, plants, construction and agricultural machines, rail cars, ships, chemical plants, boilers, closed containers, equipment construction, pipelines, pipe construction, cast components and more
- Coated electrodes (rutile, rutile/basic, basic, rutile/cellulose, cellulose)
- Unalloyed, low-alloy and high-alloy steels, nickel-based and copper alloys



SIMPLEST POSSIBLE OPERATION WITH MAXIMUM EASE-OF-USE



- Self-explanatory operating interface
- Practical operation - direct access to all welding parameters
- Standard remote control connection for setting the welding current directly on the workstation

FUNCTIONS TO PERFECT MMA WELDING



HOTSTART

Advantage: Safe ignition and reignition of the electrode to avoid bonding errors (cool points), best quality at the start of the seam and at the start of seams (no reinforcement).



ANTISTICK

Advantage: No annealing of the electrode. If the electrode sticks, e.g. because the welding current is too low, the current is reduced to the minimum.



ARCFORCE

Advantage: Optimum welding properties for all electrode types, avoids short circuits in electrodes with large-drip material transfer.



PWS Pole reversing switch
(STICK 350 CEL PWS only)

Advantage: Flexible change of polarity without having to stop work.

TECHNICAL DATA



Welding machine	inverter STICK 350 CEL	inverter STICK 350 CEL PWS
Setting range Welding current	20A - 350A	20A - 350A
Duty cycle (dc) at 40°C ambient temperature		
30 % dc	350 A	350 A
60 % dc	250 A	250 A
100 % dc	190 A	190 A
Open circuit voltage	92V	92V
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %) 3 x 415 V (-25 % - +15 %)	3 x 400 V (-25 % - +20 %) 3 x 415 V (-25 % - +15 %)
Mains frequency	50/60 Hz	50/60 Hz
Mains fuse (slow-blow safety fuse)	3 x 25A	3 x 25A
Max. connected load	17,8 kVA	17,8 kVA
Recommended generator rating	23,7 kVA	23,7 kVA
Dimensions L x W x H [mm]	690 x 230 x 460	690 x 230 x 460
Weight approx.	35,5 kg	37,5 kg