

ST-24[®]

Constant-Speed Wire Feeder 

Quick Specs



Industrial Applications

Heavy- or light-duty fabrication shops
Trailer manufacturers
Furniture manufacturers
Automotive products
Educational institutions

Processes

MIG (GMAW)
Flux-cored (FCAW)
(gas- and self-shielded)

Input Power 24 VAC, 4 A, 50/60 Hz

Wire Feed Speed 1.3–20 mpm (51–790 ipm)

Wire Diameter Capacity 0.6–1.6 mm (.023–1/16 in.)

Net Weight 16.6 kg (36.5 lb.)



Industrial, four-roll gear-driven, cast aluminum drive system with heavy-duty motor. Provides exceptional feed performance, reliability and wire speeds ranging from 1.3–20 meters per minute.

“No tools required” quick-change, dual-groove, reversible drive rolls. Large diameter design (43 mm) provides smooth, positive and accurate wire feeding with long uninterrupted service life.



Adjustable run-in and burnback controls allow the operator to set the optimum arc starts and stops, reducing wire stubbing, arc flaring or wire burning back.



Euro-style or US-style torch connections ensure exceptional performance and reliability for various style torches.

Wire jog feature enables the operator to thread the MIG wire through the torch, without the wire being live.

2T/4T latching torch trigger. Allows the operator to weld for extended periods without having to maintain pressure on the torch trigger.

Optional Features

Dual digital meters display clear, precise readings of arc voltage, wire feed speed and/or amperage. Can be set to hold last reading.

Remote voltage control. Enables precise remote operation of the welding power source arc voltage.

Quick-connect coolant fittings provide easy hook up for water-cooled torches, no tools required!



Warranted for three years, parts and labour.



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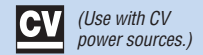
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Specifications (Subject to change without notice.)



Input Power	IP Rating	Wire Feed Speed	Electrode Wire Diameter Capacity	Max. Spool Size Capacity	Dimensions	Net Weight
24 VAC, 4 A, 50/60 Hz	IP23	1.3–20 mpm (51–790 ipm)	0.6–1.6 mm (.023–1/16 in.)	305 mm (12 in.), 15 kg (33 lb.)	H: 279 mm (11 in.) W: 273 mm (10.75 in.) D: 597 mm (23.5 in.)	16.6 kg (36.5 lb.)

Drive Rolls and Wire Guides

Drive roll kits include four drive rolls and necessary guides.

Wire Size	V-Grooved Kit	V-Knurled Kit	V-Grooved Drive Roll Only	Wire Guides		U-Grooved Kit	U-Cogged Kit	Nylon Wire Guides	
				Inlet	Intermediate			Inlet	Intermediate
0.6 mm (.023/.025 in.)	087132	—	—	056192	056206	—	—	—	—
0.8 mm (.030 in.)	046780	—	—	056192	056206	—	—	—	—
0.8/1.0 mm (.030/.040 in.)	—	—	203526	056193	056207	—	—	—	—
0.9 mm (.035 in.)	046781	046792	—	056193	056207	044750	—	058854	058853
1.0 mm (.040 in.)	191917	—	—	056193	056207	—	—	—	—
1.0/1.2 mm (.040/.045 in.)	—	—	189285*	056193*	056207*	—	—	—	—
1.2 mm (.045 in.)	046782	046793	—	056193	056207	046785	083319	058854	058853
1.3/1.4 mm (.052 in.)	046783	046794	—	056195	056209	046786	083320	058836	058837
1.6 mm (1/16 in.)	046784	046795	—	056195	056209	046787	046800	058836	058837

*Supplied with ST-24 models.

Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. V-Knurled rolls for hard-shelled cored wires.
3. U-Grooved rolls for soft and soft-shelled cored wires.
4. U-Cogged rolls for extremely soft-shelled wires (usually hard surfacing types).

Ordering Information

Wire Feeder and Options	Stock No.	Description	Qty.	Price
ST®-24	029007395	Base model		
	029007396	Same as base model plus remote voltage control and quick-connect coolant fittings		
	029007397	Same as 029007396 plus digital meters		
Digital Meter Kit	028066276	Field		
Remote Voltage Control Kit	028066274	Field		
Water Connection Kit	028066275	Field		
MIG Torches and Consumables		Contact factory		
Power Sources				
XPS 350/450 Series		See literature DCM/42.0		
Deltaweld® Series		See literature DC/16.2		
XMT® 350 Series and XMT 425 Series		See literature DCM/43.0 and DCM/44.0		
Dimension™ 650		See literature DCM/40.0		
Accessories				
Drive Roll Kit		See chart above		
Spool Cover	057607			
Turntable Assembly	146236			
Wheel Kit	028041046			
Air-Cooled Interconnecting Cables	058019028	2.5 m (8.2 ft.)		
	058019044	5 m (16.4 ft.)		
	058190039	10 m (32.8 ft.)		
Water-Cooled Interconnecting Cables	058019032	2.5 m (8.2 ft.). Requires optional coolant system		
	058019033	5 m (16.4 ft.). Requires optional coolant system		
	058190046	10 m (32.8 ft.). Requires optional coolant system		

Date: Total Quoted Price:

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