

# MPI 220P

## MIG/Stick/TIG (Multiprocess) Arc Welding Power Source



### Quick Specs



#### Industrial Applications

Light fabrication  
Maintenance and repair  
Auto body  
Farm/home

#### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
Stick (SMAW)  
TIG (GTAW)  
Flux-cored (FCAW)

**Input Power** 230 V, single-phase, 50/60 Hz

**Amp/Volt Range** MIG: 20–200 A, 15–24 V  
Stick: 5–200 A, 20.2–28 V  
TIG: 5–200 A, 10–18 V

**Rated Output** MIG: 110 A at 17.5 VDC, 100% duty cycle  
Stick: 100 A at 24 VDC, 100% duty cycle  
TIG: 100 A at 14 VDC, 100% duty cycle

**Portability is number one** when you have to go to the job — because it can't come to you. The MPI 220P contains all you need to MIG weld in one small lightweight package. With the flip of a switch, all processes are available to meet the application at hand.

**Full weld process capability.** MIG/MAG, pulse, stick and TIG are available to meet the demand of current applications.

**Synergic welding library** offers the simplicity of single knob control. The machine will select the correct voltage and amperage based on the wire feed speed (WFS) set by the operator.

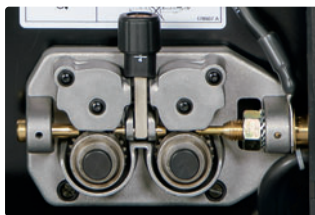
**Large graphical display** guides user through process and parameter setup with ease and high visibility.



**WELD READY**

#### Weld Ready package includes:

- Power source
- 3 m (10 ft.) work cable with clamp
- 0.8/1.0 mm (.030/.040 in.) dual-groove quick-change drive roll
- 3 m (10 ft.) Bernard™ Q2010TE3DEQ MIG gun and cable assembly
- 3 m (10 ft.) gas hose
- Two 1.0 mm (.040 in.) contact tips



**Cast aluminum drive system** incorporates a dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make setup easier and faster.

**Adjustable Hot Start™** for stick arc starts. Adjust the optimal start current for the application. The current automatically increases the output amperage at the start of a weld.

**Built-in upslope/downslope function for TIG** helps provide better arc starts and reduces craters.

**Built-in run-in/crater/burnback function for MIG** helps provide better arc starts and reduces craters.

Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

**Excellent arc characteristics!** The MPI 220P offers positive arc starts and an extremely stable arc with minimal spatter on both mixed gases and straight CO<sub>2</sub>.

**Adjustable preflow and postflow** gives operator better control of the gas parameters affecting weld zone.



Warranted for three years, parts and labour.



#### ITW Welding – BV

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# Specifications (Subject to change without notice.)



Input Power	Welding Mode	Amperage/ Voltage Ranges	Rated Output (Duty Cycle)			Max. Open-Circuit Voltage	IP Rating	Dimensions	Net Weight
			100%	60%	35%				
230 V, 1-phase, 50/60 Hz	MIG	2–200 A 15–24 V	110 A 17.5 V	140 A 21.0 V	180 A 23.0 V	35 V	IP22S  H: 365 mm (14.4 in.) W: 237 mm (9.3 in.) D: 548 mm (21.6 in.)	16 kg (35 lb.)	
	Stick	5–200 A 20.2–28 V	100 A 24.0 V	130 A 25.2 V	170 A 26.8 V	65 V			
	TIG	5–200 A 10–18 V	100 A 14.0 V	130 A 15.2 V	180 A 17.2 V	65 V			

**CE** All CE models conform to the applicable parts of the IEC 60974 series of standards.

## Drive Rolls and Wire Guides

Select drive rolls from chart below according to type and wire size being used.

Wire Size	“V” Groove Drive Roll for hard wire	“U” Groove Drive Roll for soft wire or soft-shelled cored wires	“V” Knurled Drive Roll for hard-shelled cored wires	Pressure Roll	Wire Inlet Guide
0.6/0.8 mm (.023/.030 in.)	<b>156053051</b>	—	—	<b>156053112*</b>	<b>156090026*</b>
0.8/1.0 mm (.030/.040 in.)	<b>156053109*</b>	<b>156053053</b>	—		
1.0/1.2 mm (.040/.045 in.)	<b>156053052</b>	<b>156053054</b>	<b>156053110</b>		

\*Included with MPi 220P.

## Ordering Information

Power Source	Stock No.	Description	Qty.	Price
<b>MPi 220P Weld Ready Package</b>	<b>Q29083114</b>	230 V, single-phase, 50/60 Hz		
<b>Accessories</b>				
Drive Rolls and Wire Guides		See chart above		
Weldcraft™ TIG Torch	<b>WP-17VS4BXEY3GL</b>	130 amps DC, 100 amps AC, 60% duty cycle		
Bernard™ MIG Gun	<b>Q2010TE3DEQ</b>	Air-cooled, 200 A, 3 m (10 ft.). TOUGH LOCK™ consumables		

Date: Total Quoted Price:

Distributed by:

