

MPI 180

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



Quick Specs



Industrial Applications

Light Fabrication
Maintenance and Repair
Auto Body
Farm/Home

Processes

MIG (GMAW)
Stick (SMAW)
TIG (GTAW)
Flux Cored (FCAW)

Input Power Rated Output

230 VAC, 50/60 Hz, Single-Phase
MIG: 90 Amps at 18.5 VDC, 100% Duty Cycle
Stick: 80 Amps at 23.2 VDC, 100% Duty Cycle
TIG: 90 Amps at 13.6 VDC, 100% Duty Cycle

Amp/Volt Range

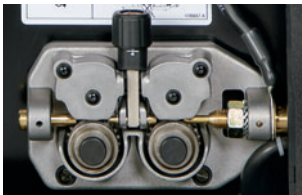
MIG: 30–180 A, 15.5–23 V
Stick: 5–175 A, 20.2–27 V
TIG: 5–175 A, 10.2–17 V

The Power of Blue.®

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.

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

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



Durable cast aluminum feedhead incorporates dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make set up easier and faster.

Thermal overload protection shuts down unit and activates **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.



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

Synergic welding mode 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.
Note: Complete material library to select from for the targeted market segment.

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.

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

Selectable trigger configuration allows the operator to choose standard or 2T trigger method.

Excellent arc characteristics! The MPI 220P offers positive arc starts and an extremely stable arc with minimal spatter on both mixed gases and straight CO₂.



Warranted for 3 years, parts and labour.



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Specifications (Subject to change without notice.)



| Model | Input Power | Welding Mode | Rated Output (Duty Cycle) | | | Max. Open-Circuit Voltage | Amperage/Voltage Range DC | IP Rating | Dimensions | Weight |
|----------|---------------------------------|--------------|---------------------------|-----------------|-----------------|---------------------------|---------------------------|-----------|---|------------------|
| | | | 100% | 60% | 35% | | | | | |
| MPi 220P | 230 VAC, 50/60 Hz, Single-phase | MIG | 110 A 17.5 V | 140 A 21.0 V | 180 A 23.0 V | 35 V | 2–200 A 15–24 V | IP22S | L: 548 mm (21.6 in) W: 237 mm (9.3 in) H: 365 mm (14.4 in) | 16 kg (35 lb) |
| | | Stick | 100 A 24.0 V | 130 A 25.2 V | 170 A 26.8 V | 65 V | 5–200 A 20.2–28 V | | | |
| | | TIG | 100 A 14.0 V | 130 A 15.2 V | 180 A 17.2 V | 65 V | 5–200 A 10–18 V | | | |

Drive Roll Kits

Drive Roll and Wire Guide Kits for MPi 220P

Base selection of drive rolls upon the following recommended usages:

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

| Wire Size | Drive Roll | Type | Wire Guide Inlet |
|-----------------------------|-------------|------|------------------|
| 0.6/0.8 mm (.023/.030 in)* | 156 053 051 | V | 156 090 026 |
| 0.8/1.0 mm (.030/.035 in)* | 156 053 109 | V | 156 090 026 |
| 1.0/1.2 mm (.035/.045 in)* | 156 053 052 | V | 156 090 026 |
| 0.8/1.0 mm (.030/.035 in)** | 156 053 053 | U | 156 090 026 |
| 1.2/1.6 mm (.045/.065 in)** | 156 053 054 | U | 156 090 026 |
| 1.0/1.2 mm (.035/.045 in)* | 156 053 110 | V-K | 156 090 026 |

*Available in steel, 30 mm diameter. **Available in nylon, 30 mm diameter.

Ordering Information

| Power Source and Options | Stock No. | Description | Qty. | Price |
|--------------------------|----------------------------|--|------|-------|
| MPi 220P | #059 016 014 | 230 VAC, 50/60 Hz, single-phase. Includes work clamp | | |
| Accessories | | | | |
| TIG Torch | WTC9AA4AG CS130AGA4CG-I | 125 Amps DC, 100 Amps AC, 60% duty cycle 130 Amps DC, 100 Amps AC, 60% duty cycle | | |
| MIG/MAG Torch | Q2010A08DE | 200 Amp Q-Gun with 3 m (10 ft) cable | | |

Date: Total Quoted Price:



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