

CITOMAG

MIG / MAG welding equipment
for universal use.
Productivity and flexibility.



CITOMAG range



Three soft current MIG-MAG welding installations, with separated four roller wire feed units, to weld unalloyed steel, stainless steel and light alloys, using solid wire and cored wire. OERLIKON expertise is automatically available to the welders and therefore the installations are straight forward to use.



Arc striking:

- Variable striking voltage.
- Arc extension system ensuring better restriking.
- Anti balling system. No need to cut the wire before restarting.
- **Synergic** or manual adjustment with the CITO system.
- **Arc stability:** continuous adjustment (thyristors) and regulation of the welding parameters (voltage, wire feed rate).
- **A.N.D.** (Arc Non Disruption) eliminates disruption of the arc for uniform melting with minimum spatter.
- **Fan:** disconnectable.
- **Configured** for automated applications.

Productivity:

- Maximum power at 60 % duty cycle (40 °C).
- Rapid access to the correct welding parameters.
- Complete welding cycle with Hot Start and crater filler.
- Optional water cooled configuration.
- Easy to use with fast parameter changes using the CITO system.





Easy to use:

A clear and accurate control panel on the front plate gives immediate verification of the selected parameters at a glance, at all times. Digital display of parameter settings.

Easy to adjust: CITO system

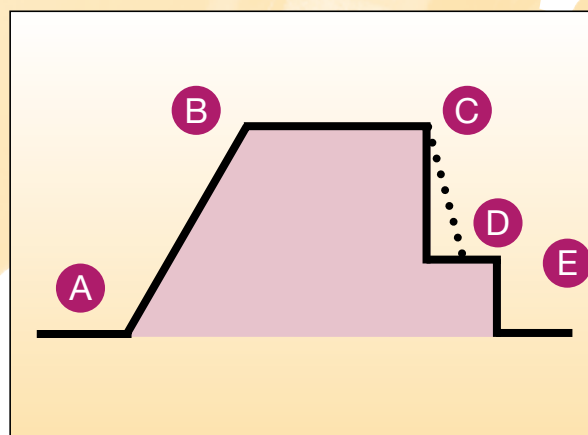
This system adapts and optimizes all parameters to suit the intended application from arc striking to arc extinction.



- 1** 2T/4T welding cycle
- 2** Crater filler cycle
- 3** Gas selection
- 4** Solid or cored wire selection
- 5** Display for :
 - current
 - thickness
 - wire speed
- 6** Display for voltage
- 7** Selection for the display 5
- 8** Material selection
- 9** Wire diameter selection
- 10** On and warning lamps
- 11** On/off switch

Complete welding cycle: Hot Start and crater filler:

- A** Pre-gas: 0 to 10 sec.
- B** Striking phase:
Soft speed 1 m/min.
Striking voltage: -4 to $+6$ V.
- C** Crater filler:
the welding voltage remains the same,
the wire speed is reduced depending
on the synergy used.
- D** Post-retract: welding voltage during 200 ms.
- E** Post-gas: 0 to 10 sec.



Technical specifications



2009-514

	CITOMAG 400 S (W)	CITOMAG 400 S (W) MV	CITOMAG 500 S (W)
Primary			
Power supply - 3 phases	230 / 400 V	220 / 230 / 240 / 380 / 400 / 415 / 400 V	220 / 230 / 240 / 380 / 400 / 415 / 440 V
Frequency	50 - 60 Hz		
Maximum primary consumption	51 / 29 A	53 / 48 / 31 / 29 / 28 / 26 A	81 / 78 / 74 / 47 / 45 / 43 / 41 A
Secondary			
Open circuit voltage max.	48 V	48 V	61 A
Adjustment range	50 - 400 A	50 - 400 A	40 - 520 A
Duty cycle at 40 °C	at 40 %	400 A	-
	at 60 %	350 A	520 A
	at 100 %	270 A	370 A
General			
Standard	EN 60974-1		
Protection index	IP 23		
Insulation class	H		
Air cooling	Controlled fan		
Dimensions (H x W x D) with feeder	1 300 x 530 x 1 015 mm	1 300 x 530 x 1 015 mm	1 300 x 710 x 1 120 mm
Weight	137 kg	143 kg	185 kg
Wire feeder			
Welding wires	Steel, Stainless steel	0.8 to 1.6 mm	
	Flux-cored	1.0 to 2.4 mm	
	Aluminium	1.0 to 2.4 mm	
Wire feed rate	1 to 20 m/min.		
Number of rollers	4		
Dimensions (H x W x D)	510 x 330 x 610 mm		
Weight	5 m	27 kg air - 29 kg water	
	10 m	34 kg air - 38 kg water	
	15 m	41 kg air - 47 kg water	
Cooler unit			
Power supply - 1 ph	230 V - 50/60 Hz		
Max. pressure	4 bars		
Max. flow	4 l/min.		
Dimensions (H x W x D)	195 x 440 x 700 mm		
Weight	19 kg		

Ordering information



2002-379



		Cat no.	
Power source			
The power source is delivered with: <ul style="list-style-type: none"> • a primary cable 5 m • an earth cable 5 m with clamp • a gas hose 3 m 			
CITOMAG 400 S (W) MV		W 000 261 978	
CITOMAG 400 S (W)		W 000 261 979	
CITOMAG 400 S pack		Consult us	
CITOMAG 400 S W pack		Consult us	
CITOMAG 500 S (W)		W 000 261 980	
CITOMAG 500 S W pack		Consult us	
Cooling units			
1 COOLER II		W 000 305 009	
FREEZCOOL		W 000 010 167	
Wire feeder with harness			
The wire feeder is delivered with: <ul style="list-style-type: none"> • rollers and wire guides for 1.0 - 1.2 mm for steel and stainless steel using • wire feeder trolley with spool cover 			
2 DV44i - D37	5 m	W 000 268 844	
	10 m	W 000 268 845	
	15 m	W 000 268 846	
2 DV44i - D37 (W)	5 m	W 000 268 847	
	10 m	W 000 268 848	
	15 m	W 000 268 849	
Options			
3 Remote control unit		W 000 305 112	
OPTOBOX 100		W 000 305 109	
4 Pivot support		W 000 305 010	
5 Slinging arm		W 000 305 061	
Torches			
	3 m	4 m	5 m
CITORCH M 341	W 000 345 091	W 000 345 092	W 000 345 093
CITORCH M 341 W	W 000 345 094	W 000 345 095	W 000 345 096
CITORCH M 441	W 000 345 097	W 000 345 098	W 000 345 099
CITORCH M 441 W	W 000 345 100	W 000 345 101	W 000 345 102



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