

Robotic Interface
digital and I/O available for
all XM Series



TECHNICAL SPECIFICATIONS

Input Voltage
Mains Voltage Tolerance
Minimum Welding Current
Maximum Welding Current
MIG Duty Cycle, 40°C
TIG Duty Cycle, 40°C
MMA Duty Cycle, 40°C
Open – Circuit Voltage
Factory Delivered Roller
Weight
Standard Accessories

Dimensions (W, L, H)
Certification

XM600 W
Pulse



400 V
- 10 % / + 15 %
10 A
600 A
600 A %60, 500 A %100
600 A %60, 500 A %100
600 A %60, 500 A %100
63 V - 82 V
1.2 + 1.6 mm / Steel
Liquid Cooled 107 kg
5 m Power Cable (4 x 6 mm²)
5 m Earth Clamp (95 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1270mm
CE

XM500 W
Pulse



400 V
- 10 % / + 15 %
10 A
500 A
500 A %40, 430 A %60, 360 A %100
500 A %40, 430 A %60, 360 A %100
500 A %40, 430 A %60, 360 A %100
63 V - 82 V
1.0 + 1.2 mm / Steel
Liquid Cooled 107 kg
5 m Power Cable (4 x 6 mm²)
5 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1270mm
CE

XM400 W

Pulse



400 V
- 10 % / + 15 %
10 A
400 A
400 A %40, 360 A %60, 400 A %100
400 A %40, 360 A %60, 400 A %100
400 A %40, 360 A %60, 400 A %100
68 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 94 kg
5 m Power Cable (4 x 4 mm²)
5 m Earth Clamp (70 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1178mm
CE

XM350 W

Pulse



400 V
- 10 % / + 15 %
10 A
350 A
350 A %60, 300 A %100
350 A %60, 300 A %100
350 A %60, 300 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 94 kg
5 m Power Cable (4 x 4 mm²)
5 m Earth Clamp (50 mm²)
Interconnection H.P (5 m)
MX50 Remote Controlled Torch
532mm x 974mm x 1178mm
CE

XM320 CW

Pulse



400 V
- 10 % / + 15 %
10 A
320 A
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 88 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
MX50 Remote Controlled Torch
532mm x 860mm x 974mm
CE

XM320 C

Pulse



400 V
- 10 % / + 15 %
10 A
320 A
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
320 A %40, 260 A %60, 240 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Liquid Cooled 74 kg
4 m Power Cable (4 x 2.5 mm²)
5 m Earth Clamp (50 mm²)
Gas Hose (1.5 m)
MX50 Remote Controlled Torch
532mm x 624mm x 974mm
CE

XM270 CW

Pulse



400 V
- 10 % / + 15 %
10 A
270 A
270 A %40, 220 A %60, 190 A %100
270 A %40, 220 A %60, 190 A %100
270 A %40, 220 A %60, 190 A %100
63 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled 34 kg
4 m Power Cable (3 x 2.5 mm²)
5 m Earth Clamp (35 mm²)
Gas Hose (1.5 m)
MX25 Remote Controlled Torch
260mm x 650mm x 450mm
CE

XM220 C

Pulse



230 V
- 10 % / + 15 %
10 A
220 A
210 A %30, 170 A %60, 150 A %100
230 A %35, 200 A %60, 170 A %100
180 A %25, 150 A %60, 130 A %100
68 V - 82 V
0.8 + 1.0 mm / Steel
Air Cooled , 34 kg
4 m Power Cable (3 x 2.5 mm²)
5 m Earth Clamp (25 mm²)
Interconnection H.P (5 m)
MX27 Remote Controlled Torch
260mm x 650mm x 450 mm
CE

It's Manual Or Robotic.
Experience 406* welding programs



Pulse

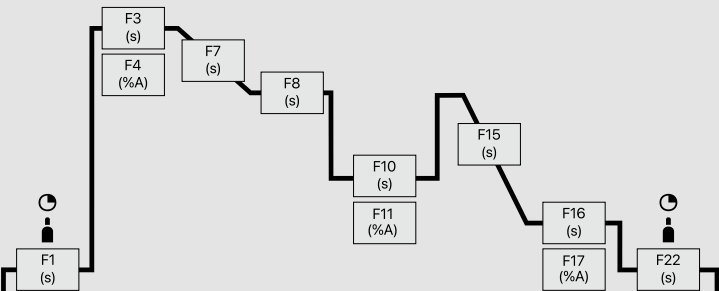
Intuitive User Interface

*Welding jobs for 1.6 Wires are just available for 500 and 600 models.

Standard-Pulse		0.8 1.0 1.2 1.6					
SG2 / SG3 G3Si1 / G4Si1		Ar+18%CO ₂		8	10	12	16
		Ar+10%CO ₂		18	20	22	26
		CO ₂ 100%		28	30	32	36
CrNi	318 / 1.4576	Ar+2.5%CO ₂		38	40	42	46
	316 / 1.4430			68	70	72	76
	310 / 1.4842			520 522			
	309 / 1.4332			538	540	542	546
	308 / 1.4316			58	60	62	66
	307 / 1.4370			48	50	52	56
	Duplex 2209 1.4462			78	80	82	86
			Ar+20%He+2%CO ₂		88	90	92
CuSi	Ar100%		178	180	182	186	
	Ar+2.5%CO ₂		558	560	562	566	
CuAl	Ar100%		188	190	192	196	
	Ar100%		198	200	202	206	
CuSi Brazing	Ar+2.5%CO ₂		208	210	212	216	
CuAl Brazing	Ar100%		218	220	222	226	
	Ar+2.5%CO ₂		228	230	232	236	
	Ar100%		118	120	122	126	
AlMg4.5 Mn	Ar+30%He		128	130	132	136	
AlMg3	Ar100%		530	532	536		
	Ar100%		138	140	142	146	
AlSi	Ar+30%He		148	150	152	156	
	Ar100%		158	160	162	166	
Al99	Ar+30%He		168	170	172	176	
Flux Cored Wire			0.8 1.0 1.2 1.6				
Steel / FluxCore Metal			Ar+18%CO ₂	238	240	242	246
Steel / FluxCore Rutil			Ar+18%CO ₂	248	250	252	256
			CO ₂ 100%				262 266
Steel / FluxCore Basic			Ar+18%CO ₂				602
CrNi / FluxCore Metal			Ar+2.5%CO ₂				272 276
CrNi / FluxCore Rutil			Ar+18%CO ₂				282 286
CrNi / FluxCore Rutil			CO ₂ 100%				292 296
Steel FluxCore High Str.			Ar+18%CO ₂				592
Steel / FluxCore Rutil			Self Shielded	720	722		

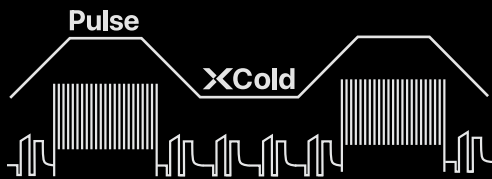
Application	
MIG/MAG Manual	4
TIG (Lift Arc)	5
MMA	6
Gouging	7

XDeep - Pulse		0.8 1.0 1.2 1.6					
CrNi	SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	298	300	302	306	
		Ar+10%CO ₂	308	310	312	316	
	318 / 1.4576	Ar+2.5%CO ₂			620	622	626
	316 / 1.4430				640	642	646
	310 / 1.4842				660	662	
	309 / 1.4332				670	672	676
	308 / 1.4316				320	322	326
	307 / 1.4370				632	636	
	Duplex 2209 1.4462				650	652	656
	AlMg4,5 Mn	Ar100%			332	336	
AlSi	Ar100%			342	346		
Al99	Ar100%			352	356		
CrNi / FluxCore Metal	Ar+18%CO ₂	608	610	612	616		
XRoot - Pulse		0.8 1.0 1.2 1.6					
SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂				360	362	
		CO ₂ 100%			370	372	
		Ar+10%CO ₂			500	502	
XCold - Pulse		0.8 1.0 1.2 1.6					
CrNi	SG2 / SG3 G3Si1 / G4Si1	Ar+18%CO ₂	378	380	382	386	
		CO ₂ 100%	388	390	392		
		Ar+10%CO ₂			510	512	
	318 / 1.4576	Ar+2.5%CO ₂	678	680	682		
	316 / 1.4430		698	700	702		
	308 / 1.4316		398	400	402		
	307 / 1.4370		688	690	692		
	Duplex 2209 1.4462		708	710	712		
	AlMg4,5 Mn	Ar100%	410	412			
	AlSi	Ar100%	420	422			
Al99	Ar100%	430	432				
CuSi Brazing	Ar100%	438	440	442			
CuAl Brazing	Ar100%	448	450	452			
AlSi Brazing	Ar100%	460	462				
ZnAl Brazing	Ar100%	470	472				
ZnAl (St to Al Welding)	Ar100%	490	492				
Mg / Mg	Ar+30%He			572	576		
Cladding		0.8 1.0 1.2 1.6					
NiCr-6625 / 2.4831	Ar+30%He		100	102	106		
		Ar+20%He+2%CO ₂	110	112	116		
NiCr-6617 / 2.4627		Ar+30%CO ₂			552	556	
CrNi / 309-2312 / 1.4332		Ar+2.5%CO ₂			542	546	
Co - Based		Ar100%			532	536	

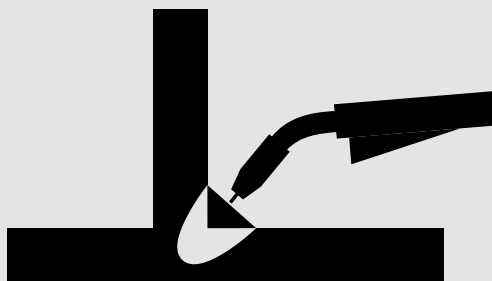


	Function	Description	Min	Max
MIG/MAG	F1	Gas pre-flow (s)	0	10
	F2	Start wire speed (m/min)	1	11
	F3	Start time (s)	0	10
	F4	Start current (%)	1	200
	F5	Start arc correction (V)	-9.9	+9.9
	F7	Start slope (s)	0	5
	F15	End down slope (s)	0.05	10
	F16	End time (s)	0	10
	F17	End current (%)	1	200
	F18	End arc correction (V)	-9.9	+9.9
	F20	End burn back (-)	10	200
	F21	End wire cut mode (-)	0	2
	F22	Gas post-flow (s)	0	10
	F23	Smart trigger (-)	0	1
	F24	Penetration stabilizer (m/min)	0	5
TIG	F31	TIG V stop limit (V)	10	30
	F32	TIG comfort stop sensitivity (V)	-2	+2

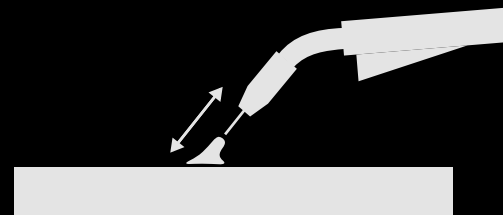
	Function	Description	Min	Max
MMA	F25	Hot start time (s)	0	10
	F26	Hot start current (%)	1	200
	F27	Arc force (-)	-50	+50
	F28	Antistick (s)	0	2
	F29	VRD function (-)	0	1
OTHERS	F34	Tack/stitch mode (-)	0	2
	F35	Cooling mode (-)	0	4
	F36	Motor current (A)	0	-
	F37	Motor current limit (A)	0.7	7
	F38	Auto load default values (-)	0	1
	F39	Motor control firmware (-)	-	-
	F40	Power control firmware (-)	-	-
	F41	Arc on time (h)	0	-
	F42	Machine on time (h)	0	-
	F45	Wire speed correction (m/min)	-2	+2
OTHERS	F49	Working mode	1	8
	F50	RL cable calibration (mOhm)	0	30



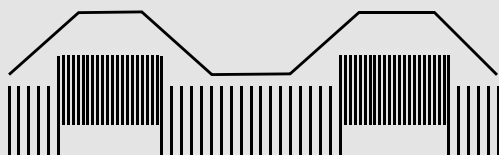
Position



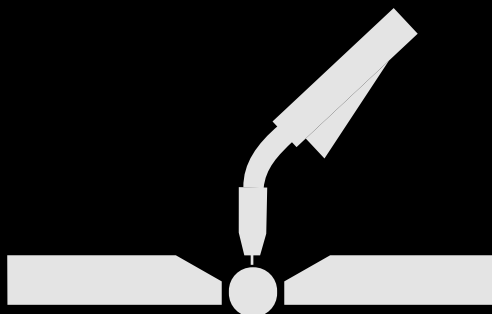
XCDeep



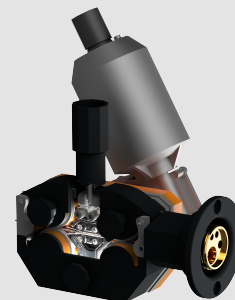
XCStabil



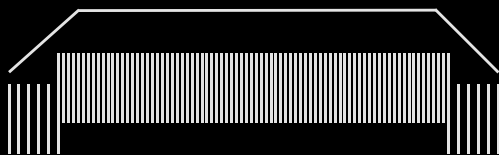
Duo Pulse



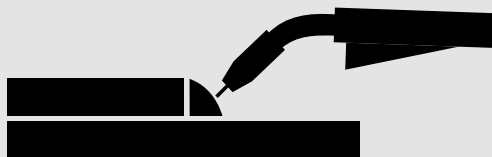
XCRoot



**4x4 4 Rollers
Wire Drive**



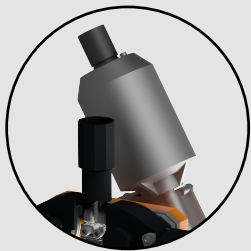
Pulse



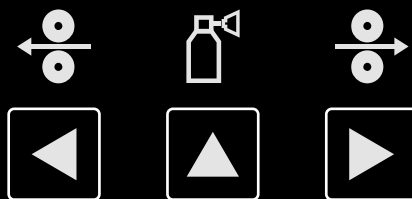
XC Cold



**Remote
Controlled Torch**



**256 PPR
(A-B-Index)
Optical Encoder**



**Wire Push
Pull-Back
Gas Testing**



**Spool Cover
With Wire
View**

99

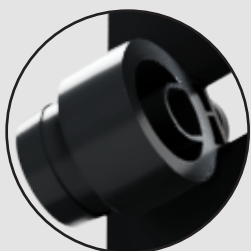
**Program
Memory**



**Intelligent
Cooling**

RL

**Torch and Cable
Calibration**



**HP
Support**



**Military
Connector**

CAN-FD

**High Speed
Communication**

Gun Holder

Compact Wire Feeder

Modular IP23 Design

Touch Sense Ignition

Wire Cut, touch ignition

Wire Speed Correction

Wire Feeder Cabinet Lighting

Wire Feeder MMA Connection

Gas Saving System

Gas Filter

Liquid Filter

Extension Cable Rack

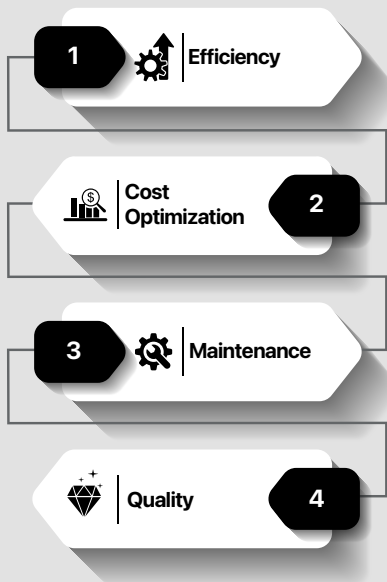
External Changable Couplings

Plug, Double Setscrew

Socket, Brass-Nut

Industrial Wheels

Optional Wire Feeder Wheels



KOLARC
.CLOUD

LoRaWAN



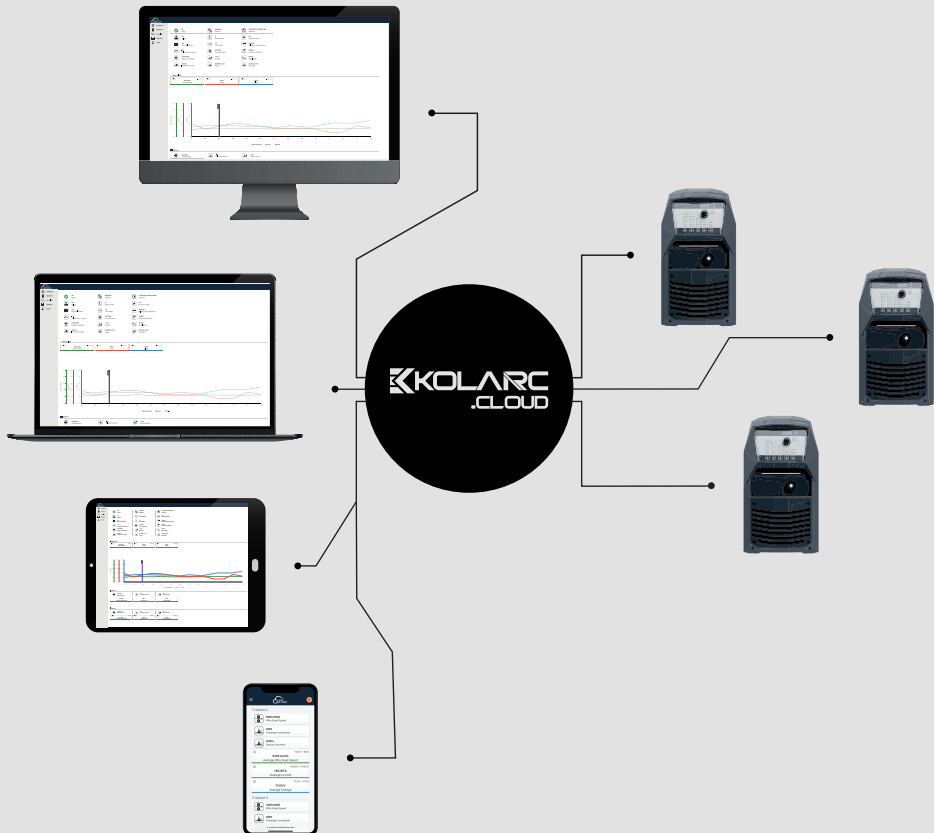
Bluetooth



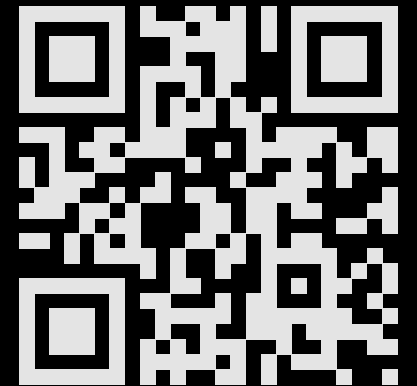
RS 485



CAN-FD



KOLARC



www.kolarc.com