

cod. 6961300000

19

WELDING DIVISION

GENERAL CATALOGUE 2019

STEL

GENERAL CATALOGUE

19



40 years



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Italian creations
the only way to forward





**Italian creations
the only way to forward**

INDEX

- Company Profile

- STICK (SMAW) Section

Sky 161

- MAX 161 DGT
- MAX 191 PFC
- MAX dp 201C
- MAX 223C Pipeline
- MAX 403
- MAX 403S
- MAX 453
- MAX 603

- TIG (GTAW) Section

TIG dp 181H DC

- TIG uP 273H DC
- TIG uP 403H DC
- TIG dp 221HPA AC-DC
- TIG uP 293H AC-DC
- TIG uP 403H AC-DC
- TIG uP 453H AC-DC

- MIG (GMAW) Section

Miggy 171

- Iron-Mig 201
- Iron-Mig 221-221P
- Iron-Mig 303-303P
- Iron-Mig 303S-303S P
- MAX 403 + TOP 504 SM
- MAX 403 + TOP 504 XM
- MAX 403S + TOP 504 SM
- MAX 403S + TOP 504 XM
- MAX 453 + TOP 504 XXM
- MAX 603 + TOP 504 XXM
- Industry 4.0 Welding Network
- Sky-Mig 353K
- Sky-Mig 453K
- Sky-Mig 353S
- Sky-Mig 453S
- Sky-Mig 553S

- PLASMA Section

Thor 41K PFC

- Thor 73
- Thor 123
- PLASMA Consumables

- MultiProcess Section

- Marine (Off-Shore) Section

- Mining Section

- Torches & Accessories

- GENERAL SALES CONDITIONS

page. 2-4

page. 5-8

page. 9-10

page. 11-12

page. 13-14

page. 15-16

page. 17-18

page. 19-20

page. 21-22

page. 23-24

page. 25-26

page. 27-30

page. 31-32

page. 33-34

page. 35-36

page. 37-38

page. 39-40

page. 41-42

page. 43-44

page. 45-48

page. 49-50

page. 51-52

page. 53-58

page. 59-62

page. 63-66

page. 67-68

page. 69-70

page. 71-72

page. 73-74

page. 75-76

page. 77-78

page. 79-80

page. 81-82

page. 83-84

page. 85-86

page. 87-88

page. 89-90

page. 91-92

page. 93-94

page. 95-96

page. 97-98

page. 99-100

page. 101-104

page. 105-108

page. 109-112

page. 113-128

page. 129-130



STEL.

40 years of passion

We have always been driven by a very simple idea. Satisfy our customer.

Barocco Ermanno, born on 25/02/1939 in Vicenza, begins his long career in the welding industry in 1954 at the company S.I.E.V. (FRO subsidiary) at the young age of 15 as a construction worker.

In 1964 he obtained the Diploma of Electrical Engineering at the then prestigious Rossi Institute of Vicenza and in the same year he became project manager at the S.I.E.V.

In 1978 **he founded WEMI ITALIA s.p.a.** that after having established itself as a leading company in the Italian market, it was acquired in 1984 by the American company HOBART BROTHERS Co.

From 1984 to 1993 he held the role of General Manager of WEMI-HOBART.

In 1993 he decided to embark on a new adventure with STEL, of which he is still Chairman of the Board of Directors.

Mazzucco Annamaria, born 03/03/1944 in Arcugnano (VI). She began her career in 1958 at the FAVRETTO s.p.a. as a worker at the young age of 14. In 1961 she moved to IMMIGRATI as a sales manager. In 1970 she was hired by BOSCHIERO as purchasing manager until 1977. Finally **in 1979 she founded STEL** where she still plays a major role and remains the point of reference for the company.

STEL in Castegnero.

Where tradition and innovation are welded together.

The positive mix, of Italian tradition and technological innovation was born in Stel in the year 1979 in Castegnero, a few kilometers from Vicenza. Here the green hills, the architecture Renaissance and the beauty of the landscapes have blended into the environment, which is corporate to the Barocco family.

These company founders continue to direct STEL forward in advanced technology, in the production of Inverter Welding and Plasma Cutting Machines.

A streamlined and dynamic reality, through which we put at your disposal our know-how, production and testing facilities, which are immediately recognizable for their quality including the aesthetic impact, ergonomic and attractive design.



Customer respect



Technical requirements, business needs and conditions of sale are scrupulously met to the minimum detail.

Each contract with us is an absolute guarantee, Stel does not only offer the most sophisticated technologies on the market, but Stel is respectfully synonymous to all mandatory agreements.

Environmental compliance.



Our production facilities, assemblies and processes satisfy rigorous global environmental protection. To ensure that this essential form of respect towards the world we live in, STEL continuously perform rigorous internal controls in parallel to that carried out by the relevant authorities.

Machines equipped with a PFC Multi-Link™ system reinforces our commitment towards energy saving. We never tire of reminding STEL personnel to be aware of the STEL environmental 'foot-print' STEL continue to provide our customers with products that have a positive environmental impact.

Regulatory compliance.



We are one of the few manufacturers in the world to submit their machines to rigorous examination of the strongest Testing Institute around the world.

Furthermore, our production is approved by CSA International (based on ISO / IEC 17025: 2005) for export to North America. While our technical office has been Certified ISO / IEC 17025: 2005. Therefore, from the compliance of these regulations is determined reliability, safety with newest operational functions and Features that distinguish STEL in the global market.



Technologies

Approved to exceed the limits!



Reliability and performance are our obsession. The pursuit of perfection is extreme in every detail, from the production to the calibration has brought STEL machines to meet the highest international criteria of resistance and functionality, being recognized as exclusive products suitable for extreme use.

Every year we reinvest 10% of our turnover to develop product performance and make more environmentally efficient.

International market.

STEL experience has no geographical limits.



Our reliability is recognized worldwide. Our products are present on all continents, thanks to a global professional network of established partners. The continued international expansion has led us to open offices in Germany, Poland and Turkey.

Application areas.

Whatever your needs, wherever you operate, STEL recognise the world as our field of application.

From the daily engagements with our domestic and international customer base this opens up to STEL each individual need and challenges. This results with STEL having developed the perfect machine for your market sector required for operating in a specific professional welding environment.

STICK (SMAW)





INVERTER RANGE
INVERTER PFC RANGE

SPECIAL FEATURES STICK STEL



V.R.D.

V.R.D.: Also called VOLTAGE REDUCTION DEVICE is a device that reduces the output voltage of the welding machine to a safety level for the operator below 20V. This allows you to avoid any Accidental Electric Shock.



ROD PULSE

ROD PULSE: Normally you know the pulse welding in TIG and MIG, but not pulse in the Stick. STEL was the first company to develop this welding process.

Today, this process has been studied and appreciated in all European welding universities.

The advantages of aesthetics and arc control are unmatched, particularly with the welding of cellulose electrodes. **(MAX® dp 201C, MAX® 403/403S/503 from Remote Control or WireFeeder TOP 504 SM/XM).**



HOT START

HOT START: It is a feature that increases the welding current with respect to the value set during the solder trigger phase. This increase allows for better starting and avoiding the annoying glue of the electrode.



ARC FORCE

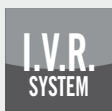
ARC FORCE: It is a feature that increases the welding current with respect to the value set during the start. This increase allows to avoid the annoying sticking of the electrode during welding and the possibility of “pushing” the electrode to increase penetration.



PFC

PFC: In order to manufacture in respect of reducing harmonic distortion as per the limitations of European Standards December 2010 (EN 61000-3-12) Stel has developed an inovated PFC. (Power Factor Correction).

The PFC Multi-Link is able to operate from any input voltage all over the world. This sophisticated device automatically links the primary Voltage supplied from any world plug without manually linking primary voltage terminals. No switching or internal link-up is required by the operator. **(MAX® 191 PFC, MAX® 403S).**



I.V.R.

I.V.R. System: In any case of wrong connection 1 o 3 Phase there is no damage to the machine because PFC and I.V.R. systems blocks wrong input and prevent operator mistakes. **(MAX® 403S).**



TWIN FAN

TWIN FAN: Ventilation of all STEL welders is called “TWIN FAN” as it has two fans in its interior. A fan pushes the air inside the welding machine while the other pulls the hot air out. This type of ventilation avoids any turbulence that could cause the deposition of ferrous material inside the welding machine.



TIG LIFT

TIG LIFT: With our MMA products you can weld to TIG with LIFT trigger. This type of welding is without high frequency and provides an initial contact situation between the tungsten electrode of the torch and the material. As soon as the torch is removed from the contact, the welder passes from 0 to the set solder value. The gas is supplied by a special valve mounted on the torch.

(MAX® 161 DGT, MAX® dp 201C, MAX® 223C, MAX® 403, MAX® 403S, MAX® 453, MAX® 603).



DOW CORNING: All the electronic boards produced by STEL are protected by DOW CORNING painting. This procedure guarantees:

- Existence of different climatic factors (UV, ozone, oxidation),
- Moisture protection, contaminants, short circuits and increased board life.

ROD PULSE STEL

- Better stability of the electric arc (especially at low welding currents);
- Possibility to use larger diameter electrodes when welding thin plates;
- Reduce the burning through when welding thin plates (low current densities);
- A better control of drop transfer through the arc; friendly with the welding operator;
- Obtain exterior surfaces of weld with regular scales (finer or coarser depending on the pulse frequency) similar to TIG welding; especially in "high" frequency welding, 4 -5 Hz.

IDEAL FOR PIPE WELDING

- Assures a better and more sure link in the case of gaps having variable or out of the ax openings (see the orbital welding of large diameter pipes);
- Sure penetration and easier to make in the case of one side penetrated butt welding;
- Adequate (ideal) in vertical down welding of pipes using cellulosic electrodes;

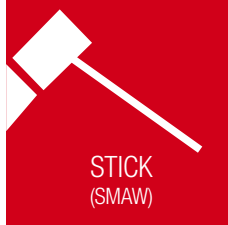
Fig.A Appearance of deposits made with titanic electrode



Fig.B Appearance of deposits made with cellulosic electrode



SKY 161



Inverter 1Phase



Made in ITALY

Technical Data SKY 161

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (25%)	13,5 A
Real Power (25%)	3 KVA
Power Factor	0,7
Efficiency	80 %
No Load Voltage	74 V
Current Range	5-135 A
Welding Current 25% (25°C)	130 A
Welding Current 60% (25°C)	95 A
Welding Current 100% (25°C)	80 A
Welding Current 30% (25°C)	130 A
Welding Current 60% (25°C)	85 A
Welding Current 100% (25°C)	70 A

Features SKY 161

Earth Clamp - Cable/E.Holder	25 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	330x135x270
Weight (601426000L Version)	6 Kg

The data is measured at an environment temperature of 25 °C

Materials

- Mild Steels
- Stainless Steels
- Castings

Welding Process

- Electrode Welding
- TIG Scratch Start Welding

Environments

- Light Fabrications
- Special Maintenance
- Ordinary Maintenance
- Auto repair
- Building and plumbing
- Electricians and installers
- Workshops

Main Features

- Inverter Technology
- 3,25Ø Electrode
- Ease of operation
- Portable
- Fireproof plastic

Main Accessories



- KIT SKY 161 DELUXE**
- SKY 161
 - Bag STEL
 - Earth Clamp with 2m 16mm² rubber cable
 - Elect. Holder with 3m 16mm² rubber cable
 - Hand Welding Screen
 - Wire Brush/Chipping Hammer



- TIG TORCH 17V**
Tig Torch with valve.
- Tig Torch 17V 4m Air Cod. 642830000L
 - Tig Torch 17V 8m Air Cod. 642840000L

Complete Combo

Code	Description	
601612000L	Sky 161	(Included with the Complete Combo)
-	Earth Clamp with 1,6m 10mm ² rubber cable	(Included with the Complete Combo)
-	Elect. Holder with 2,8m 10mm ² rubber cable	(Included with the Complete Combo)
-	Hand Welding Screen	(Included with the Complete Combo)

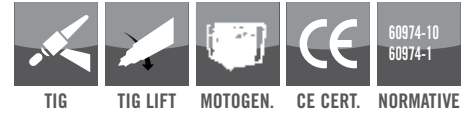
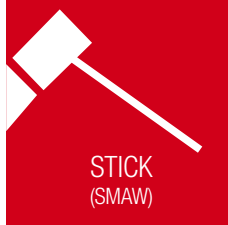
DELUXE Combo

Code	Description	
601613000L	Sky 161	(Included with the DELUXE Combo)
-	Bag STEL	(Included with the DELUXE Combo)
-	Earth Clamp with 2m 16mm ² rubber cable	(Included with the DELUXE Combo)
-	Elect. Holder with 3m 16mm ² rubber cable	(Included with the DELUXE Combo)
-	Hand Welding Screen	(Included with the DELUXE Combo)
-	Wire Brush/Chipping Hammer	(Included with the DELUXE Combo)

Accessories

Code	Description	
608360001L	Welding KIT 16mm ² Dinse 25	(Included with the DELUXE Combo)
601039000L	Cables KIT 16mm ² Dinse 25	
6011410000	Bag STEL	(Included with the DELUXE Combo)
642830000L	Tig Torch TTS 17V 4m Air Dinse 25	
642840000L	Tig Torch TTS 17V 8m Air Dinse 25	
6604480000	Shoulder Strap	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	

MAX[®] 161 DGT



Inverter 1Phase

**DIGITAL
DISPLAY**



Technical Data MAX[®] 161 DGT

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (30%)	16 A
Real Power (30%)	3,8 KVA
Power Factor	0,8
Efficiency	85 %
No Load Voltage	85 V
Current Range	5-150 A
Welding Current 45% (25°C)	150 A
Welding Current 100% (25°C)	100 A
Welding Current 30% (40°C)	150 A
Welding Current 60% (40°C)	100 A
Welding Current 100% (40°C)	95 A

Features MAX[®] 161 DGT

Earth Clamp - Cable/E.Holder	16 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	330x135x270
Weight (600378000L/607880000L Version)	5,7 Kg
The date is measured at an environment temperature of 40 °C	



The MAX[®] Series of Welding Inverters, developed from STEL INVERTER TECHNOLOGY, concentrates a high excellence of welding performance in a portable lightweight compact structure.

With an operator-friendly easy to read front panel design, the selection of the correct parameter for each electrode diameter is immediate and uncomplicated.

The MAX[®] is also available with Bag Kit for transport everywhere.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings 	<ul style="list-style-type: none"> Electrode Welding TIG Scratch Start Welding 	<ul style="list-style-type: none"> Light Fabrications Special Maintenance Ordinary Maintenance Auto repair Building and plumbing Electricians and installers Workshops 	<ul style="list-style-type: none"> Digital Display TIG LIFT Inverter Technology Ease of operation Bag KIT Portable Fireproof plastic

Main Accessories



Bag KIT MAX[®] 161 DGT
 - MAX[®] 161 DGT
 - Bag STEL
 - Earth Clamp with 2m 16mm² rubber cable
 - Elect. Holder with 3m 16mm² rubber cable



TIG TORCH 17V
 Tig Torch with valve.
 - Tig Torch 17V 4m Air Cod. 642830000L
 - Tig Torch 17V 8m Air Cod. 642840000L



Welding KIT 16mm²
 Cod. 608360001L
 - Earth Clamp with 2m 16mm² rubber cable
 - Elect. Holder with 3m 16mm² rubber cable
 - Hand Welding Screen
 - Wire Brush/Chipping Hammer

Only Power Source

Code	Description
601608000L	MAX [®] 161 DGT

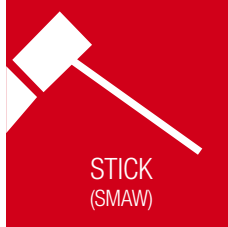
Bag KIT MAX[®] 161 DGT

Code	Description	
601611000L	MAX [®] 161 DGT	(incluso nel KIT Borsa)
-	KIT Cavi 16mm ² Dinse 25	(incluso nel KIT Borsa)
-	Borsa STEL	(incluso nel KIT Borsa)

Accessories

Code	Description	
608360001L	Welding KIT 16mm ² Dinse 25	
601039000L	Cables KIT 16mm ² Dinse 25	(Included with the bag KIT)
6011410000	Bag STEL	(Included with the bag KIT)
642830000L	Tig Torch TTS 17V 4m Air Dinse 25	
642840000L	Tig Torch TTS 17V 8m Air Dinse 25	
6604480000	Shoulder Strap	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	

MAX[®] 191 PFC



Inverter 1Phase PFC



Made in ITALY

PFC
Multi-Link™

Technical Data MAX[®] 191 PFC

Voltage Range	150 V → 290 V
Main Voltage	230 V
Phase	1
Frequency	50/60 Hz
Real Current (30%)	13,5 A
Real Power (30%)	2,9 KVA
Power Factor	0,99
Efficiency	81 %
No Load Voltage	90 V
Current Range	5-160 A
Welding Current 35% (25°C)	160 A
Welding Current 100% (25°C)	110 A
Welding Current 30% (40°C)	160 A
Welding Current 60% (40°C)	115 A
Welding Current 100% (40°C)	100 A

Features MAX[®] 191 PFC

Earth Clamp - Cable/E.Holder	25 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	440x160x300
Weight (601279000L Version)	8,5 Kg

The data is measured at an environment temperature of 40 °C

The Inverter Welding Power Source MAX[®] 191 PFC developed by STEL with INVERTER technology, concentrates high welding performance in a compact structure. Ideal for 3,25Ø electrode and other type like 4,0Ø electrode.

Power Factor Correction regulating wave form distortion from Input Voltage and Current supply, providing a constant Voltage to the Inverter.

In respect of stringent EN Standards for Harmonic Distortion (EN 61000-3-12) and the energy efficiency ERP. Energy savings of 30% compared to a normal Inverter and up to 50% to an SCR.

Control of PFC regulation through DSP technology.



MAX[®] 191 PFC is able to weld **4mm** electrode from a **16 AMP.** fuse.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings 	<ul style="list-style-type: none"> Electrode Welding TIG Scratch Start Welding 	<ul style="list-style-type: none"> Light Fabrications Special Maintenance Ordinary Maintenance Auto repair Building and plumbing Electricians and installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Ease of operation PFC Robust Reliability 4,0Ø Electrode Fireproof plastic

Main Accessories



Bag KIT MAX® 191 PFC
 - MAX® 191 PFC
 - Bag STEL
 - Earth Clamp with 3m 25mm² rubber cable
 - Elect. Holder with 4m 25mm² rubber cable



Cables KIT
 Cod. 602060000L
 - Earth Clamp with 3m 25mm² rubber cable
 - Elect. Holder with 4m 25mm² rubber cable



TIG TORCH 26V
 Tig Torch with valve.
 - Tig Torch 26V 4m Air Cod. 642850000L
 - Tig Torch 26V 8m Air Cod. 600971000L

Only Power Source

Code	Description
601279000L	MAX® 191 PFC

Bag KIT MAX® 191 PFC

Code	Description	
601311000L	MAX® 191 PFC	(Included with the bag KIT)
-	Cables KIT 25mm ² Dinse 50	(Included with the bag KIT)
-	Bag STEL	(Included with the bag KIT)

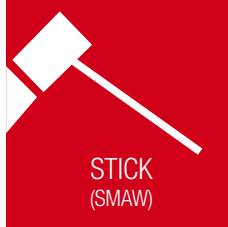
STICK Combo-TIG Scratch

Code	Description
601279000L	MAX® 191 PFC
6006610010	Welding KIT 25mm ² Dinse 50
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

Accessories

Code	Description	
6013070000	Bag STEL	(Included with the bag KIT)
602060000L	Cables KIT 25mm ² Dinse 50	(Included with the bag KIT)
6006610010	Welding KIT 25mm ² Dinse 50	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	
642850000L	Tig Torch TTS 26V 4m Air Dinse 50	
600971000L	Tig Torch TTS 26V 8m Air Dinse 50	

MAX[®] dp 201C



Inverter 1Phase

ROD-PULSE™



Made in ITALY

Technical Data MAX[®] dp 201C

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (30%)	19 A
Real Power (30%)	4,4 KVA
Power Factor	0,8
Efficiency	86 %
No Load Voltage	25-100 V
Current Range	4-200 A
Welding Current 30% (25°C)	200 A
Welding Current 100% (25°C)	160 A
Welding Current 20% (40°C)	200 A
Welding Current 60% (40°C)	160 A
Welding Current 100% (40°C)	140 A

Features MAX[®] dp 201C

Earth Clamp - Cable/E.Holder	25 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	330x135x270
Weight (607830000L Version)	7,2 Kg

The date is measured at an environment temperature of 40 °C

The Inverter Welding Power Source MAX[®] dp 201C developed by STEL concentrates high performance for MMA and Tig welding with the most stringent safety requirements for the work place. Advanced Technology owing to the use of the DSP (Digital Signal Processor) that controls all the inverter signals. V.R.D., TIG lift and variable slope down Features, satisfy the requirements of every work place.

With pulsing in TIG (up to 999 Hz) and in Electrode (innovative ARC PULSING - from 0,4 to 5 Hz) makes the MAX[®] dp 201C a really unique product.

The MAX[®] dp is also available with Bag Kit for transport everywhere.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes TIG Lift Start Welding 	<ul style="list-style-type: none"> Light Fabrications Ship-Building Auto repair Building and plumbing Electricians and installers Workshops 	<ul style="list-style-type: none"> Inverter Technology V.R.D. D.S.P. Arc Pulsing Elect. and Tig Bag STEL Digital Display Tig Lift Slope Down Tig Fireproof plastic

Main Accessories



Bag KIT MAX[®] dp 201C
 - MAX[®] dp 201C
 - Bag STEL
 - Earth Clamp with 3m 25mm² rubber cable
 - Elect. Holder with 4m 25mm² rubber cable



Cables KIT
 Cod. 602060000L
 - Earth Clamp with 3m 25mm² rubber cable
 - Elect. Holder with 4m 25mm² rubber cable



TIG TORCH 26V
 Tig Torch with valve.
 - Tig Torch 26V 4m Air Cod. 642850000L
 - Tig Torch 26V 8m Air Cod. 600967000L



Remote Control Cad Cad RCCS
 Remote Control with Rod Pulse (Arc Pulsing).
 Cod. 600571000L Remote
 Cod. 600572000L Extension 10m

Only Power Source

Code	Description
607830000L	MAX [®] dp 201C

Bag KIT MAX[®] dp 201C

Code	Description	
601263000L	MAX [®] dp 201C	(Included with the bag KIT)
-	Cables KIT 25mm ² Dinse 50	(Included with the bag KIT)
-	Bag STEL	(Included with the bag KIT)

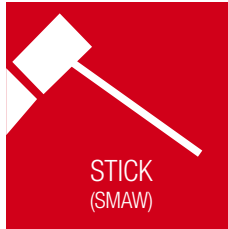
STICK-TIG Lift Combo

Code	Description
607830000L	MAX [®] dp 201C
6006610010	Welding KIT 25mm ² Dinse 50
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

Accessories

Code	Description	
602060000L	Cables KIT 25mm ² Dinse 50	(Included with the bag KIT)
6006610010	Welding KIT 25mm ² Dinse 50	
6011410000	Bag STEL	(Included with the bag KIT)
607140000L	Tig Torch TTS 17V 4m Air Dinse 50	
600967000L	Tig Torch TTS 17V 8m Air Dinse 50	
642850000L	Tig Torch TTS 26V 4m Air Dinse 50	
600971000L	Tig Torch TTS 26V 8m Air Dinse 50	
6604480000	Shoulder Strap	
600571000L	Remote Control RC1	
600572000L	Cable for Remote Control RC1 10m	
600573000L	Cable for Remote Control RC1 20m	
600574000L	Cable for Remote Control RC1 30m	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	

MAX[®] 223C



Inverter 3Phase



Made in ITALY

Technical Data MAX[®] 223C Pipeline

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (40%)	10 A
Real Power (40%)	11 KVA
Power Factor	0,7
Efficiency	80 %
No Load Voltage	90 V
Current Range	4-220 A
Welding Current 50% (25°C)	220 A
Welding Current 100% (25°C)	180 A
Welding Current 40% (40°C)	220 A
Welding Current 60% (40°C)	180 A
Welding Current 100% (40°C)	165 A

Features MAX[®] 223C Pipeline

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x185x400
Weight (600857000L Version)	24 Kg

The date is measured at an environment temperature of 40 °C

The Inverter Welding Power Source MAX[®]223C, has been designed for mainly welding on Pipeline work.

Its principal characteristics are: Robust, portable and reliability.

Variable Slope Down (0-10 seconds) to end current for a perfect crater filler.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes TIG Lift Start Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Special Maintenance Petro-chemical Ship-Building Installatori Maintenance 	<ul style="list-style-type: none"> Inverter Technology Fireproof plastic Weight and reduced dimensions Remote Control Arc-Force Variable Tig DC Lift Start Welding V.R.D. Hot Start Variable

Main Accessories



Remote Control Cad Cad RC1
Cod. 600571000L
- Cod. 600098000L Cable 10m
- Cod. 600099000L Cable 20m
- Cod. 600101000L Cable 30m



Cables KIT
Cod. 602060000L
- Earth Clamp with 3m 25mm² rubber cable
- Elect. Holder with 4m 25mm² rubber cable



TIG TORCH 26V
Tig Torch with valve.
- Tig Torch 26V 4m Air Cod. 600718000L
- Tig Torch 26V 8m Air Cod. 600719000L

Only Power Source

Code	Description
600857000L	MAX® 223C Pipeline

STICK Combo

Code	Description
600857000L	MAX® 223C Pipeline
602020000L	Cables KIT 50mm ² Dinse 50

STICK-TIG Lift Combo

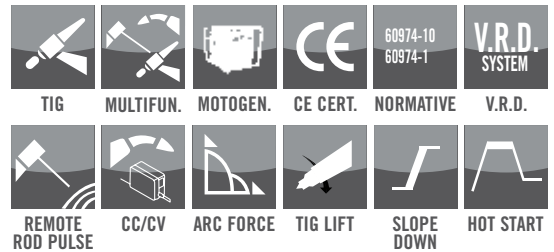
Code	Description
600857000L	MAX® 223C Pipeline
602020000L	Cables KIT 50mm ² Dinse 50
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)
600718000L	Tig Torch TTS 26V 4m Air Dinse 50

Accessories

Code	Description
602020000L	Cables KIT 50mm ² Dinse 50
600514000L	Trolley MPL
600718000L	Tig Torch TTS 26V 4m Air Dinse 50
600719000L	Tig Torch TTS 26V 8m Air Dinse 50
600571000L	Remote Control RC1
600098000L	Cable for Remote Control RC1 10m
600099000L	Cable for Remote Control RC1 20m
600101000L	Cable for Remote Control RC1 30m
600102000L	Remote FOOT Control Cad 4,5m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

MAX[®] 403

STICK
(SMAW)



Inverter 3Phase

ROD-PULSE™



Made in ITALY

Technical Data MAX[®] 403

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	19 A
Real Power (35%)	11,2 KVA
Power Factor	0,85
Efficiency	86 %
No Load Voltage	70 V
Current Range	4-400 A
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A

Features MAX[®] 403

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	600x250x460
Weight (600243000L Version)	34 Kg

The data is measured at an environment temperature of 40 °C

Slope Down variable (0-10 sec.), Smooth descent for a perfect Crater-fill.

Arc Force variable (0-500%) a continuous arc for perfect fusion and penetration, no arc snuffing.

Hot Start variable (0-50%) for a precise arc ignition, eliminating electrode sticking.

Digital Amp/Volt Display

Tig Lift with ramp-down time (0-10sec.)

V.R.D. Safety System

MMA electrode Pulsing (only with Remote Control RCCS).

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes (No Citoflex) TIG Lift Start Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Special Maintenance Petro-chemical Ship-Building Installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Weight and reduced dimensions Arc-Force Variable Tig DC Lift Start Welding V.R.D. Hot Start Variable Arc Pulsing (with Remote) CC-CV

Main Accessories



Cables KIT
Cod. 602020000L
- Earth Clamp with 3m 50mm² rubber cable
- Elect. Holder with 4m 50mm² rubber cable



TIG TORCH 26V
Tig Torch with valve.
- Tig Torch 26V 4m Air Cod. 642850000L
- Tig Torch 26V 8m Air Cod. 600971000L



Remote Control Cad Cad RCCS
Remote Control with Rod Pulse (Arc Pulsing).
Cod. 600015000L Remote
Cod. 600026000L Extension 10m



TROLLEY KIT MMA XP
Cod. 6003640000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source

Code	Description
600243000L	MAX [®] 403

STICK Combo

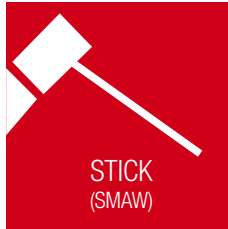
Code	Description
600243000L	MAX [®] 403
6941800000	Warranty Extension Pack 3&5 Years
600364000L	Trolley MMA XP
602020000L	Cables KIT 50mm ² Dinse 50

* Check on Page 104 the complete list of MAX[®] 403 Accessories.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
602020000L	Cables KIT 50mm ² Dinse 50
600364000L	Trolley MMA XP
600343000L	Trolley MIG/TIG
601471000L	Water Cooler AWC MPS
607010001L	Earth Cable 70mm ² 3m with Clamp
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
600971000L	Tig Torch TTS 26V 8m Air Dinse 50
600015000L	Remote Control Cad RCCS
600026000L	Remote Control Cable Cad RCCS 10m
600027000L	Remote Control Cable Cad RCCS 20m
600028000L	Remote Control Cable Cad RCCS 30m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

MAX[®] 403S



Inverter Multivoltage PFC

ROD-PULSE™



Made in ITALY

PFC
Multi-Link™

Technical Data MAX[®] 403S

Voltage Range	200 V → 575 V
Main Voltage	230-400-460-500 V
Phase	1/3
Frequency	50/60 Hz
Real Current (35%)	24,5-12,5 A (16,5 - 400V)
Real Power (35%)	9,7 KVA (400V)
Power Factor	0,98
Efficiency	87 %
No Load Voltage	70 V
Current Range	4-400 A (4-300A 1F)
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A (300A 1F)

Features MAX[®] 403S

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	600x250x460
Weight (601282000L Version)	40,5 Kg
The date is measured at an environment temperature of 40 °C	

For optimum flexibility STEL has developed a new and sophisticated PFC Multi-Link™ which perfects the automatic connection (without any manual operation) of the power source to any input plug in the World from 200V 1 phase to 575V 3 phase.

This new technology requires a lower power consumption by the power source which will pull less Amps.

The PFC technology of the MAX[®] 403S version, requires less electrical input to the Inverter power source by utilizing the total current available from the input supply. This results in more than 30% savings from avoiding any energy loss.

The unique PFC flexibility further increases the many advantages to the operator such as, providing opportunity to use welding cables up to 500m long, motor-generator friendly, V.R.D..

I.V.R. SYSTEM: In any case of wrong connection 1 o 3 Phase there is no damage to the machine because PFC and I.V.R. systems blocks wrong input and prevent operator mistakes.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes (No Citoflex) TIG Lift Start Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Special Maintenance Petro-chemical Ship-Building Installers Workshops 	<ul style="list-style-type: none"> Inverter Technology PFC Multi-Link™ Arc-Force & Hot Start Variable I.V.R. & V.R.D System Arc Pulsing (with Remote) Tig DC with Slop Down Variable Tig DC Lift Start Welding CC-CV

Main Accessories



Cables KIT
Cod. 60202000L
- Earth Clamp with 3m 50mm² rubber cable
- Elect. Holder with 4m 50mm² rubber cable



TIG TORCH 26V
Tig Torch with valve.
- Tig Torch 26V 4m Air Cod. 64285000L
- Tig Torch 26V 8m Air Cod. 600971000L



Remote Control Cad Cad RCCS
Remote Control with Rod Pulse (Arc Pulsing).
Cod. 600015000L Remote
Cod. 600026000L Extension 10m



TROLLEY KIT MMA XP
Cod. 600364000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source

Code	Description
601282000L	MAX [®] 403S

STICK Combo

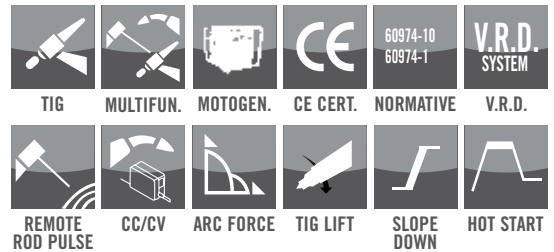
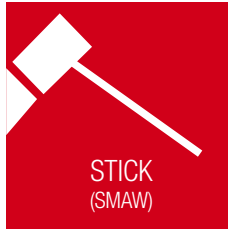
Code	Description
601282000L	MAX [®] 403S
6941800000	Warranty Extension Pack 3&5 Years
600364000L	Trolley MMA XP
602020000L	Cables KIT 50mm ² Dinse 50

* Check on Page 104 the complete list of MAX[®] 403S Accessories.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
602020000L	Cables KIT 50mm ² Dinse 50
600364000L	Trolley MMA XP
600343000L	Trolley MIG/TIG
601471000L	Water Cooler AWC MPS
607010001L	Earth Cable 70mm ² 3m with Clamp
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
600971000L	Tig Torch TTS 26V 8m Air Dinse 50
600015000L	Remote Control Cad RCCS
600026000L	Remote Control Cable Cad RCCS 10m
600027000L	Remote Control Cable Cad RCCS 20m
600028000L	Remote Control Cable Cad RCCS 30m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

MAX[®] 453



Inverter 3Phase

ROD-PULSE™



Made in ITALY

NEW
COMING IN 2019

Technical Data MAX[®] 453

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	19 A
Real Power (35%)	12,4 KVA
Power Factor	0,85
Efficiency	87 %
No Load Voltage	80 V
Current Range	4-450 A
Welding Current 60% (25°C)	450 A
Welding Current 100% (25°C)	370 A
Welding Current 35% (40°C)	450 A
Welding Current 60% (40°C)	430 A
Welding Current 100% (40°C)	350 A

Features MAX[®] 453

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	680x300x435
Weight (601507000L Version)	50 Kg

The data is measured at an environment temperature of 40 °C

Slope Down variable (0-10 sec.), Smooth descent for a perfect Crater-fill.

Arc Force variable (0-500%) a continuous arc for perfect fusion and penetration, no arc snuffing.

Hot Start variable (0-50%) for a precise arc ignition, eliminating electrode sticking.

Digital Amp/Volt Display

Tig Lift with ramp-down time (0-10sec.)

V.R.D. Safety System

MMA electrode Pulsing (only with Remote Control RCCS).

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes TIG Lift Start Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Special Maintenance Petro-chemical Ship-Building Installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Multiprocess Digital Display V.R.D. Remote Control Arc-Force Variable Hot Start Variable Arc Pulsing (with Remote)

Main Accessories



Tig Torch 26V
Tig Torch with valve.
- Tig Torch 26V 4m Air Cod. 64285000L
- Tig Torch 26V 8m Air Cod. 600971000L



Remote Control Cad Cad RCCS
Remote Control with Rod Pulse (Arc Pulsing).
Cod. 600015000L Remote
Cod. 600026000L Extension 10m



TROLLEY KIT MMA XP
Cod. 600364000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source

Code	Description
601507000L	MAX® 453

STICK Combo

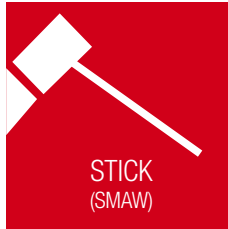
Code	Description
601507000L	MAX® 453
6941800000	Warranty Extension Pack 3&5 Years
600364000L	Trolley MMA XP

* Check on Page 104 the complete list of MAX® 453-603 Accessories.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
600343000L	Trolley MIG/TIG
600364000L	Trolley MMA XP
601473000L	Water Cooler AWC MPX
607010001L	Earth Cable 70mm ² 3m with Clamp
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
600971000L	Tig Torch TTS 26V 8m Air Dinse 50
600015000L	Remote Control Cad RCCS
600026000L	Remote Control Cable Cad RCCS 10m
600027000L	Remote Control Cable Cad RCCS 20m
600028000L	Remote Control Cable Cad RCCS 30m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

MAX[®] 603



Inverter 3Phase

ROD-PULSE™



Made in ITALY

NEW
COMING IN 2019

Technical Data MAX[®] 603

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	26 A
Real Power (35%)	18 KVA
Power Factor	0,85
Efficiency	87 %
No Load Voltage	80 V
Current Range	4-550 A
Welding Current 45% (25°C)	550 A
Welding Current 60% (25°C)	520 A
Welding Current 100% (25°C)	430 A
Welding Current 35% (40°C)	550 A
Welding Current 60% (40°C)	500 A
Welding Current 100% (40°C)	400 A

Features MAX[®] 603

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	680x300x435
Weight (601476000L Version)	50 Kg

The data is measured at an environment temperature of 40 °C

Slope Down variable (0-10 sec.), Smooth descent for a perfect Crater-fill.

Arc Force variable (0-500%) a continuous arc for perfect fusion and penetration, no arc snuffing.

Hot Start variable (0-50%) for a precise arc ignition, eliminating electrode sticking.

Digital Amp/Volt Display

Tig Lift with ramp-down time (0-10sec.)

V.R.D. Safety System

MMA electrode Pulsing (only with Remote Control RCCS).

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys 	<ul style="list-style-type: none"> Electrode Welding Cellulosic Electrodes TIG Lift Start Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Special Maintenance Petro-chemical Ship-Building Installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Multiprocess Digital Display V.R.D. Remote Control Arc-Force Variable Hot Start Variable Arc Pulsing (with Remote)

Main Accessories



Tig Torch 26V
Tig Torch with valve.
- Tig Torch 26V 4m Air Cod. 64285000L
- Tig Torch 26V 8m Air Cod. 600971000L



Remote Control Cad Cad RCCS
Remote Control with Rod Pulse (Arc Pulsing).
Cod. 600015000L Remote
Cod. 600026000L Extension 10m



TROLLEY KIT MMA XP
Cod. 600364000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source

Code	Description
601476000L	MAX®603

STICK Combo

Code	Description
601476000L	MAX®603
6941800000	Warranty Extension Pack 3&5 Years
600364000L	Trolley MMA XP

* Check on Page 104 the complete list of MAX® 453-603 Accessories.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
600343000L	Trolley MIG/TIG
600364000L	Trolley MMA XP
601473000L	Water Cooler AWC MPX
607010001L	Earth Cable 70mm ² 3m with Clamp
642850000L	Tig Torch TTS 26V 4m Air Dinse 50
600971000L	Tig Torch TTS 26V 8m Air Dinse 50
600015000L	Remote Control Cad RCCS
600026000L	Remote Control Cable Cad RCCS 10m
600027000L	Remote Control Cable Cad RCCS 20m
600028000L	Remote Control Cable Cad RCCS 30m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

TIG (GTAW)





INVERTER DC & AC RANGE
INVERTER PFC DC & AC RANGE

SPECIAL FEATURES TIG STEL



HF

HF: To avoid tungsten inclusions in welding, HF (High Frequency) technology has been created that allows the start of welding with distance between the electrode and the welding part. When the torch button is pressed, the generator creates a small arc between the torch and the piece.



AC-DC

AC/DC: Thanks to the AC function it is possible to weld in alternating current which allows the aluminum TIG welding with exceptional results. STEL offers the ability to adjust the BALANCE and FREQUENCY to optimize AC welding to the maximum levels achievable.



TIG PULSE

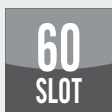
TIG PULSE: The Pulse TIG function is suitable for welding very thin pieces so that by pulsating with adjustable frequency it is possible to avoid the workpiece distortion for heat input.



TIG LIFT

TIG LIFT: With our MMA products you can weld to TIG with LIFT trigger. This type of welding is without high frequency and provides an initial contact situation between the tungsten electrode of the torch and the material.

As soon as the torch is removed from the contact, the welder passes from 0 to the set solder value. The gas is supplied by a special valve mounted on the torch.



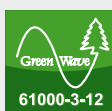
MEMORY

MEMORY: There are 60 memory slots available to save your favorite programs. The feature is then easily recalled via the front panel.



SLOPE DOWN

SLOPE UP/ DOWN: Through the front panel of the TIG stel, the time of the ramp up and down of the welding current can be easily adjusted.



PFC

PFC: In order to manufacture in respect of reducing harmonic distortion as per the limitations of European Standards December 2010 (EN 61000-3-12) Stel has developed an inovated PFC. (Power Factor Correction). The PFC Multi-Link is able to operate from any input voltage all over the world. This sophisticated device automatically links the primary Voltage supplied from any world plug without manually linking primary voltage terminals. No switching or internal link-up is required by the operator. **(TIG dp 221Hpa).**



TWIN FAN

TWIN FAN: Ventilation of all STEL welders is called "TWIN FAN" as it has two fans in its interior. A fan pushes the air inside the welding machine while the other pulls the hot air out. This type of ventilation avoids any turbulence that could cause the deposition of ferrous material inside the welding machine.



DOW CORNING: All the electronic boards produced by STEL are protected by DOW CORNING painting. This procedure guarantees:

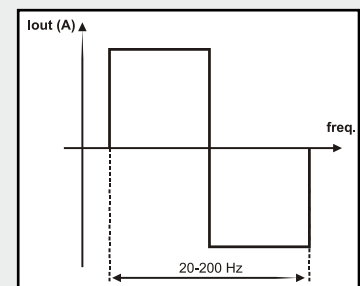
- Existence of different climatic factors (UV, ozone, oxidation),
- Moisture protection, contaminants, short circuits and increased board li

ASYMMETRIC STEL ADJUSTMENT

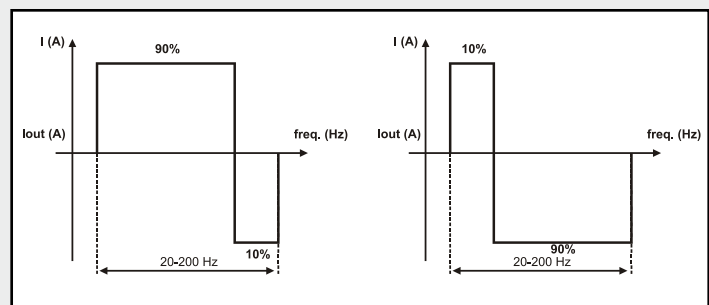
Optimizing TIG welding in AC AC requires remarkable practice but thanks to STEL technology it has been able to simplify it and make it accessible to everyone.

AC mode generates a square wave welding curve that can be fully adjusted to achieve maximum cleaning or penetration. To do this you can use the features of:

FREQUENZA: It increases or decreases the concentration of the weld arc depending on the different welding requirements. Possibility to adjust from 20 to a maximum of 200Hz.



BALANCE: Allows you to reduce the amount of current for cleaning to the advantage of that for welding (just think that generators normally use 50% of the power for cleaning and 50% for welding); in welders the ratio is 35% -65%.

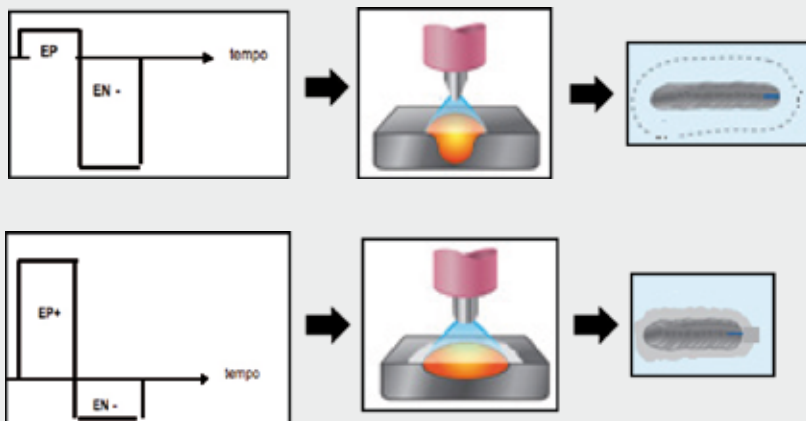


Another adjustment in the next generation TIG AC / DC is the independent current control called ASIMMETRIC.

In a fully symmetrical waveform EN (Negative Electrode) and EP (Positive Electrode) have the same value of current and time, so each wave is equal. If current and time value are different, the waveform is called ASIMMETRICS.

This function allows you to set the EN and EP current independently.

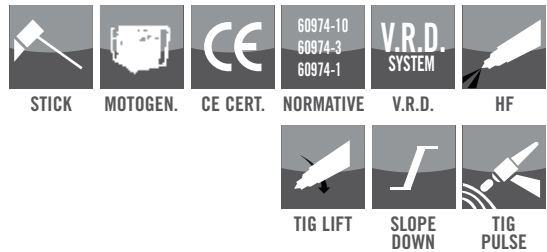
More current in EN produces deeper penetration, faster speed rate but with minimal cleaning action and also provides less heat to tungsten.



- A narrow arc cone
- Increased thermal input
- Greater penetration
- Increases speed rate
- Narrow welding
- Minor Cleaning

- Wider arc cone
- Minor thermal input
- Little penetration
- Wider welding
- More Cleaning

TIG dp 181H



DC TIG Inverter 1Phase



Made in ITALY

Technical Data TIG dp 181H

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (20%)	13,5 A
Real Power (20%)	3 KVA
Power Factor	0,7
Efficiency	83 %
No Load Voltage	95 V
Current Range	4-180 A
Welding Current 30% (25°C)	180 A
Welding Current 100% (25°C)	120 A
Welding Current 20% (40°C)	180 A
Welding Current 60% (40°C)	115 A
Welding Current 100% (40°C)	105 A

Features TIG dp 181H

Earth Cable	25 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	440x160x300
Weight (600186000L Version)	11,5 Kg

The date is measured at an environment temperature of 40 °C

The Inverter Welding Power Source TIG dp 181H developed by STEL concentrates excellent weld performance in both DC TIG welding with high frequency ignition, and Stick-electrode welding. The newly engineered design has resulted in a portable lightweight DC TIG machine of compact dimensions.

The advanced technology of the powerful microprocessor results in a perfect arc ignition every time.

Its principal characteristics are: TIG DC welding (2T, 4T), Pulsing, pre-gas and post-gas time adjustment, variable slope up and down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch with potentiometer.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Nickel Steels and Alloys Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig HF Start Welding Tig DC Lift start Welding Electrode Welding 	<ul style="list-style-type: none"> Light Fabrications Ship-Building Motocycle Industries Nuclear Plant Building and plumbing Ordinary Maintenance Special Maintenance 	<ul style="list-style-type: none"> Inverter Technology V.R.D. Tig HF Start Slope UP / DOWN Pre / Post gas Tig 2 T / 4 T DC Pulsing Digital Display

Main Accessories



Bag KIT TIG[®] dp 181H
 - TIG[®] dp 181H
 - Bag STEL
 - Earth Clamp with 3m 25mm² rubber cable
 - Tig Torch TTS 17 4m Air + 7 Ways Plug



GAS REGULATOR WITH FLOWMETER
 Cod. 6056100000
 Gas Regulator with Flow Meter for a perfect and safe gas regulation (Italian gas connection).



TIG TORCH
 Tig Torch with a professional and robust Torch trigger.
 - Tig Torch 17 4m Air Cod. 609910000L
 - Tig Torch 17 8m Air Cod. 600972000L
 - Tig Torch 26 4m Air Cod. 609920000L
 - Tig Torch 26 8m Air Cod. 600973000L



Shoulder Strap
 Cod. 600376000L
 Practical shoulder-strap, designed for comfortable carrying of the welding inverter.

Only Power Source

Code	Description
600186000L	TIG dp 181H

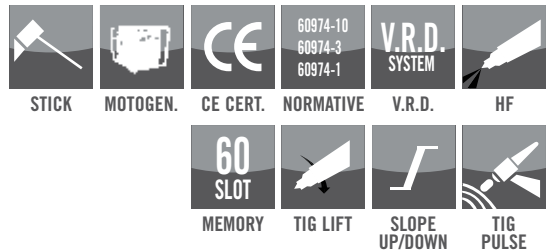
Bag KIT TIG dp 181H

Code	Description	
601309000L	TIG dp 181H	(Included with the bag KIT)
-	Tig Torch TTS 17 4m Air + 7 Ways Plug	(Included with the bag KIT)
-	Earth Clamp + Cable 25mm ² 3m	(Included with the bag KIT)
-	Bag STEL	(Included with the bag KIT)

Accessories

Code	Description	
6013070000	Bag STEL	(Included with the bag KIT)
600514000L	Trolley MPL	
602040000L	Earth Clamp + Cable 25mm ² 3m	(Included with the bag KIT)
609910000L	Tig Torch TTS 17 4m Air + 7 Ways Plug	(Included with the bag KIT)
600972000L	Tig Torch TTS 17 8m Air + 7 Ways Plug	(Included with the bag KIT)
601089000L	Tig Torch TTS 17 4m Air Pot. 1K + 7 Ways Plug	
609920000L	Tig Torch TTS 26 4m Air + 7 Ways Plug	
600973000L	Tig Torch TTS 26 8m Air + 7 Ways Plug	
601094000L	Tig Torch TTS 26 4m Air Pot 1 K + 7 Ways Plug	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	
601524000L	Remote FOOT Control Cad 4,5m	
6443500000	7 Ways Plug	(Included with the Power Source)
600376000L	Shoulder Strap	

TIG μ P 273H



DC TIG Inverter 3Phase



Made in ITALY

Technical Data TIG μ P 273H

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (30%)	8,2 A
Real Power (30%)	5,2 KVA
Power Factor	0,8
Efficiency	75 %
No Load Voltage	70 V
Current Range	4-230 A
Welding Current 40% (25°C)	230 A
Welding Current 100% (25°C)	200 A
Welding Current 30% (40°C)	230 A
Welding Current 60% (40°C)	190 A
Welding Current 100% (40°C)	175 A

Features TIG μ P 273H

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x185x400
Weight (600860000L Version)	20 Kg

The data is measured at an environment temperature of 40 °C

The availability of 60 programmable memories allows for the construction and recall of all parameters selected.

HF (High Frequency) ignition, slope up and slope down adjustment (from 0 to 10s) for a perfect crater filler. Pulsing adjustment from 0 to 300 Hz.

Its principal characteristics are: TIG DC welding (2T, 4T), Pulsing, pre-gas and post-gas time adjustment, variable slope up and down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Nickel Steels and Alloys Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig HF Start Welding Tig DC Lift start Welding Spot Tig Welding Electrode Welding 	<ul style="list-style-type: none"> Light Fabrications Ship-Building Motocycle Industries Nuclear Plant Building and plumbing Ordinary Maintenance Special Maintenance 	<ul style="list-style-type: none"> Inverter Technology Tig HF Start Slope UP / DOWN Post gas Tig 2 T / 4 T DC Pulsing Digital Display Fireproof plastic V.R.D.

Only Power Source

Code	Description
600860000L	TIG μ P 273H DC

Complete Combo Air

Code	Description
600860000L	TIG μ P 273H DC
602000001L	Earth Cable 50mm ² 3m
600706000L	Tig Torch TTS 26 4m Air + 7 Ways Plug C016
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

Complete Combo H2O

Code	Description
600860000L	TIG μ P 273H DC
601471000L	Water Cooler AWC MPS (Liquid NOT included)
600514000L	Trolley MPL
602000001L	Earth Cable 50mm ² 3m
600708000L	Tig Torch TTS 20 4m H2O + 7 Ways Plug C016
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

Accessories

Code	Description
601471000L	Water Cooler AWC MPS (Liquid NOT included)
600239000L	5L Tank Liquid STELFreeze
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
601408000L	Water Extensions Tube
602000001L	Earth Cable 50mm ² 3m
600706000L	Tig Torch TTS 26 4m Air + 7 Ways Plug C016
600707000L	Tig Torch TTS 26 8m Air + 7 Ways Plug C016
600711000L	Tig Torch TTS 26 4m Air U/D + 7 Ways Plug C016
600708000L	Tig Torch TTS 20 4m H2O + 7 Ways Plug C016
600709000L	Tig Torch TTS 20 8m H2O + 7 Ways Plug C016
600712000L	Tig Torch TTS 20 4m H2O U/D + 7 Ways Plug C016
600571000L	Remote Control RC1
600098000L	Cable for Remote Control RC1 10m
600099000L	Cable for Remote Control RC1 20m
600101000L	Cable for Remote Control RC1 30m
600102000L	Remote FOOT Control Cad 4,5m
6453700000	7 Ways Plug C016 (Included with the Power Source)
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

TIG μ P 403H



DC TIG Inverter 3Phase



Made in ITALY

Technical Data TIG μ P 403H

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	17,5 A
Real Power (35%)	8,6 KVA
Power Factor	0,75
Efficiency	82 %
No Load Voltage	68 V
Current Range	4-350 A
Welding Current 50% (25°C)	350 A
Welding Current 100% (25°C)	300 A
Welding Current 35% (40°C)	350 A
Welding Current 60% (40°C)	300 A
Welding Current 100% (40°C)	250 A

Features TIG μ P 403H

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 21S
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	600x300x615
Weight (600373000L Version)	41 Kg

The data is measured at an environment temperature of 40 °C

Possibility to save up to 60 Programs. Thanks to this system the operator can easily recall all parameters already set. Time saving and semplicity are the key for this innovative way of welding.

Its principal characteristics are: TIG DC welding (2T, 4T), post-gas time adjustment, variable slope up/slope down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch, pulsing regulation.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Nickel Steels and Alloys Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig HF Start Welding Tig DC Lift start Welding Spot Tig Welding Electrode Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Ship-Building Automotive Industries Nuclear Plant Military plant Ordinary Maintenance Special Maintenance 	<ul style="list-style-type: none"> Inverter Technology Tig HF Start Slope UP / DOWN Post gas Tig 2 T / 4 T DC Pulsing Digital Display

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



TIG TORCH
Tig Torch with a professional and robust Torch trigger.
- Tig Torch 20 4m H2O Cod. 601292000L
- Tig Torch 20 8m H2O Cod. 601293000L
- Tig Torch 18 4m H2O Cod. 601295000L
- Tig Torch 18 8m H2O Cod. 601296000L

Only Power Source

Code	Description
600373000L	TIG μ P 403H DC

Complete Combo H2O

Code	Description
600373000L	TIG μ P 403H DC
601471000L	Water Cooler AWC MPS
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

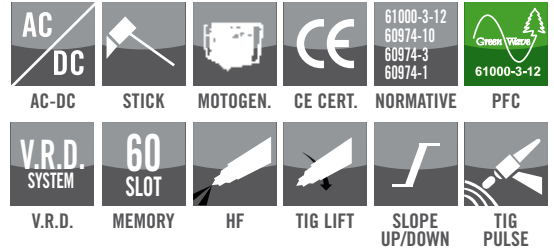
Accessories

Code	Description
601471000L	Water Cooler AWC MPS
600239000L	5L Tank Liquid STELFreeze
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601292000L	Tig Torch TTS 20 4m H2O + 2 Ways Plug
601293000L	Tig Torch TTS 20 8m H2O + 2 Ways Plug
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
601296000L	Tig Torch TTS 18 8m H2O + 2 Ways Plug
601297000L	Tig Torch TTS 18 4m H2O U/D + 14 Ways Plug
601287000L	2 Ways Plug
601286000L	14 Ways Plug
600571000L	Remote Control RC1
601288000L	Cable for Remote Control RC1 10m
601289000L	Cable for Remote Control RC1 20m
601291000L	Cable for Remote Control RC1 30m
601285000L	Remote FOOT Control Cad 4,5m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

(Included with the Power Source)

TIG dp 221Hpa AC-DC



AC-DC TIG Inverter PFC 1Phase



Made in ITALY

PFC Multi-Link™

Technical Data TIG dp 221Hpa AC-DC

Voltage Range	90 V → 290 V	
Main Voltage	115 V	230 V
Phase	1	1
Frequency	50/60 Hz	50/60 Hz
Real Current (20%)	14 A	11 A
Real Power (20%)	3,5 KVA	2,5 KVA
Power Factor	0,99	0,99
Efficiency	79 %	76 %
No Load Voltage	44 V	65 V
Current Range	4-155 A	4-220 A
Welding Current 30% (25°C)	155 A	220 A
Welding Current 100% (25°C)	120 A	165 A
Welding Current 20% (40°C)	155 A	220 A
Welding Current 60% (40°C)	130 A	165 A
Welding Current 100% (40°C)	110 A	145 A

Features TIG dp 221Hpa AC-DC

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x190x400
Weight (607540000L Version)	26 Kg

The date is measured at an environment temperature of 40 °C

This generation of Inverter is able to optimize the input power with the innovative PFC (Power Factor Correction) feature.

The advance PFC dynamics allows the complete exploitation of the available input amps resulting in the delivery of the required Welding Current without power leakage.

The Tig dp 221Hpa Auto-sensing is able to operate from any 1Phase input voltage in the world. This sophisticated device automatically links the primary Voltage supplied from 90V up to 290V without manually linking primary voltage terminals.

No switching or internal link-up required by the operator.

The INVERTER reliability is drastically improved compensating for any Voltage spike that occurs within the input range when being used with standard or smaller motor-generators.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Aluminum and Alloys Mild Steels Stainless Steels Nickel Steels and Alloys Castings Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig AC and DC Welding Tig HF Start Welding Tig DC Lift start Welding Spot Tig Welding Electrode Welding 	<ul style="list-style-type: none"> Medium-Light Fabrications Special Maintenance Petro-chemical Motorcycle Industries Nuclear Plant Food Industries Aerospace Industries 	<ul style="list-style-type: none"> Inverter Technology Fireproof plastic TIG Asymmetric Mode Complete AC Regulation Tig AC and DC Welding PFC Multi-Link™ V.R.D. AC and DC Pulsing

Main Accessories



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



TIG TORCH
Tig Torch with a professional and robust Torch trigger.
- Tig Torch 26 4m H2O Cod. 600706000L
- Tig Torch 26 8m H2O Cod. 600707000L
- Tig Torch 20 4m H2O Cod. 600708000L
- Tig Torch 20 8m H2O Cod. 600709000L



TANK STELFreeze
Cod. 600239000L
5 Liters Tank for Water Cooling System.

Only Power Source

Code	Description
607540000L	TIG dp 221Hpa AC-DC

Complete Combo H2O

Code	Description
607540000L	TIG dp 221Hpa AC-DC
601471000L	Water Cooler AWC MPS
600514000L	Trolley MPL
602000001L	Earth Cable 50mm ² 3m
600708000L	Tig Torch TTS 20 4m H2O + 7 Ways Plug C016
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

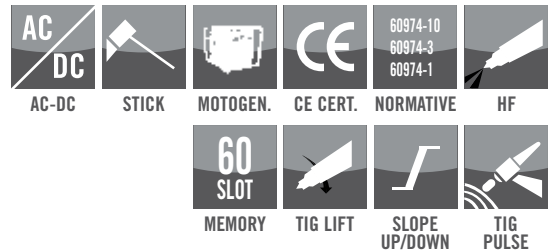
Accessories

Code	Description
601471000L	Water Cooler AWC MPS
600239000L	5L Tank Liquid STELFreeze
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
601408000L	Water Extensions Tube
602000001L	Earth Cable 50mm ² 3m
600706000L	Tig Torch TTS 26 4m Air + 7 Ways Plug C016
600707000L	Tig Torch TTS 26 8m Air + 7 Ways Plug C016
600711000L	Tig Torch TTS 26 4m Air U/D + 7 Ways Plug C016
600708000L	Tig Torch TTS 20 4m H2O + 7 Ways Plug C016
600709000L	Tig Torch TTS 20 8m H2O + 7 Ways Plug C016
600712000L	Tig Torch TTS 20 4m H2O U/D + 7 Ways Plug C016
600571000L	Remote Control RC1
600098000L	Cable for Remote Control RC1 10m
600099000L	Cable for Remote Control RC1 20m
600101000L	Cable for Remote Control RC1 30m
600102000L	Remote FOOT Control Cad 4,5m
6453700000	7 Ways Plug C016
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

(Included with the Power Source)

TIG μP 293H AC-DC



AC-DC TIG Inverter 3Phase



Made in ITALY

Technical Data TIG μP 293H AC-DC

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (25%)	9 A
Real Power (25%)	6,2 KVA
Power Factor	0,70
Efficiency	75 %
No Load Voltage	68 V
Current Range	4-250 A
Welding Current 35% (25°C)	250 A
Welding Current 100% (25°C)	170 A
Welding Current 25% (40°C)	250 A
Welding Current 60% (40°C)	180 A
Welding Current 100% (40°C)	150 A

Features TIG μP 293H AC-DC

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 21S
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	600x300x615
Weight (600349000L Version)	46 Kg

The date is measured at an environment temperature of 40 °C

Possibility to save up to 60 Programs. Thanks to this system the operator can easily recall all parameters already set. Time saving and simplicity are the key for this innovative way of welding.

HF (High Frequency) ignition, slope up and slope down adjustment (from 0 to 10s) for a perfect crater filler. Pulsing adjustment from 0 to 300 Hz.

Its principal characteristics are: TIG DC welding (2T, 4T), post-gas time adjustment, variable slope up/slope down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch, pulsing regulation.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys • Nickel Steels and Alloys • Copper and Alloys • Titanium 	<ul style="list-style-type: none"> • Tig AC and DC Welding • Tig HF Start Welding • Tig DC Lift start Welding • Spot Tig Welding • Electrode Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Ship-Building • Automotive Industries • Nuclear Plant • Military plant • Ordinary Maintenance • Special Maintenance 	<ul style="list-style-type: none"> • Inverter Technology • Tig HF Start • Slope UP / DOWN • Post gas • Tig 2 T / 4 T • Complete AC Regulation • Tig AC and DC Welding • Digital Display

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



TIG TORCH
Tig Torch with a professional and robust Torch trigger.
- Tig Torch 20 4m H2O Cod. 601292000L
- Tig Torch 20 8m H2O Cod. 601293000L
- Tig Torch 18 4m H2O Cod. 601295000L
- Tig Torch 18 8m H2O Cod. 601296000L



TANK STELFreeze
Cod. 600239000L
5 Liters Tank for Water Cooling System.

Only Power Source

Code	Description
600349000L	TIG μ P 293H AC-DC

Complete Combo H2O

Code	Description
600349000L	TIG μ P 293H AC-DC
601471000L	Water Cooler AWC MPS
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

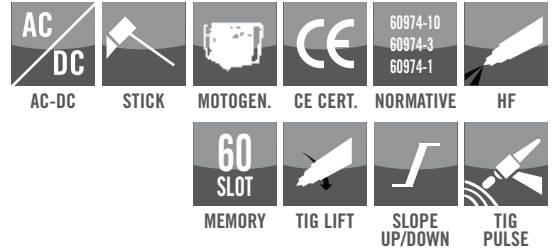
Accessories

Code	Description
601471000L	Water Cooler AWC MPS
600239000L	5L Tank Liquid STELFreeze
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601292000L	Tig Torch TTS 20 4m H2O + 2 Ways Plug
601293000L	Tig Torch TTS 20 8m H2O + 2 Ways Plug
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
601296000L	Tig Torch TTS 18 8m H2O + 2 Ways Plug
601297000L	Tig Torch TTS 18 4m H2O U/D + 14 Ways Plug
601287000L	2 Ways Plug
601286000L	14 Ways Plug
600571000L	Remote Control RC1
601288000L	Cable for Remote Control RC1 10m
601289000L	Cable for Remote Control RC1 20m
601291000L	Cable for Remote Control RC1 30m
601285000L	Remote FOOT Control Cad 4,5m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

(Included with the Power Source)

TIG μP 403H AC-DC



AC-DC TIG Inverter 3Phase



Made in ITALY

Technical Data TIG μP 403H AC-DC

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (45%)	14,5 A
Real Power (45%)	9,6 KVA
Power Factor	0,75
Efficiency	81 %
No Load Voltage	65 V
Current Range	4-350 A
Welding Current 50% (25°C)	350 A
Welding Current 100% (25°C)	300 A
Welding Current 45% (40°C)	350 A
Welding Current 60% (40°C)	300 A
Welding Current 100% (40°C)	280 A

Features TIG μP 403H AC-DC

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 21S
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	600x300x615
Weight (600345000L Version)	50 Kg

The date is measured at an environment temperature of 40 °C

Possibility to save up to 60 Programs. Thanks to this system the operator can easily recall all parameters already set. Time saving and simplicity are the key for this innovative way of welding.

HF (High Frequency) ignition, slope up and slope down adjustment (from 0 to 10s) for a perfect crater filler. Pulsing adjustment from 0 to 300 Hz.

Its principal characteristics are: TIG DC welding (2T, 4T), post-gas time adjustment, variable slope up/slope down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch, pulsing regulation.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys Nickel Steels and Alloys Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig AC and DC Welding Tig HF Start Welding Tig DC Lift start Welding Spot Tig Welding Electrode Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Ship-Building Automotive Industries Nuclear Plant Military plant Ordinary Maintenance Special Maintenance 	<ul style="list-style-type: none"> Inverter Technology Tig HF Start Slope UP / DOWN Post gas Tig 2 T / 4 T Complete AC Regulation Tig AC and DC Welding Digital Display

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



TIG TORCH
Tig Torch with a professional and robust Torch trigger.
- Tig Torch 20 4m H2O Cod. 601292000L
- Tig Torch 20 8m H2O Cod. 601293000L
- Tig Torch 18 4m H2O Cod. 601295000L
- Tig Torch 18 8m H2O Cod. 601296000L



TANK STELFreeze
Cod. 600239000L
5 Liters Tank for Water Cooling System.

Only Power Source

Code	Description
600345000L	TIG μ P 403H AC-DC

Complete Combo H2O

Code	Description
600345000L	TIG μ P 403H AC-DC
601471000L	Water Cooler AWC MPS
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

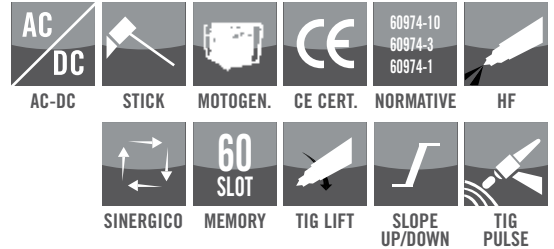
Accessories

Code	Description
601471000L	Water Cooler AWC MPS
600239000L	5L Tank Liquid STELFreeze
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601292000L	Tig Torch TTS 20 4m H2O + 2 Ways Plug
601293000L	Tig Torch TTS 20 8m H2O + 2 Ways Plug
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
601296000L	Tig Torch TTS 18 8m H2O + 2 Ways Plug
601297000L	Tig Torch TTS 18 4m H2O U/D + 14 Ways Plug
601287000L	2 Ways Plug
601286000L	14 Ways Plug
600571000L	Remote Control RC1
601288000L	Cable for Remote Control RC1 10m
601289000L	Cable for Remote Control RC1 20m
601291000L	Cable for Remote Control RC1 30m
601285000L	Remote FOOT Control Cad 4,5m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

(Included with the Power Source)

TIG μP 453H AC-DC



Inverter Trifase AC-DC



Made in ITALY

NEW
COMING IN 2019

Technical Data TIG μP 453H AC-DC

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (30%)	13,5 A
Real Power (30%)	7,5 KVA
Power Factor	0,8
Efficiency	80 %
No Load Voltage	68 V
Current Range	4-400 A
Welding Current 40% (25°C)	400 A
Welding Current 100% (25°C)	320 A
Welding Current 30% (40°C)	400 A
Welding Current 60% (40°C)	340 A
Welding Current 100% (40°C)	300 A

Features TIG μP 453H AC-DC

Earth Clamp - Cable/E.Holder	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	CE
Length/Width/Height (mm)	590x300x435
Weight (601512000L Version)	47 Kg

I dati sono stati rilevati ad una temperatura di 40 °C

Possibility to save up to 60 Programs. Thanks to this system the operator can easily recall all parameters already set. Time saving and simplicity are the key for this innovative way of welding.

HF (High Frequency) ignition, slope up and slope down adjustment (from 0 to 10s) for a perfect crater filler. Pulsing adjustment from 0 to 300 Hz.

Its principal characteristics are: TIG DC welding (2T, 4T), post-gas time adjustment, variable slope up/slope down, Tig lift, digital display to read the welding parameters, low energy consumption, V.R.D., up-down torch, pulsing regulation.

With LCD synergic technology provide for speedy selection of material thickness for welding.

A large clear user-friendly Digital Screen provides the operator with coherent parameter information. All parameters are displayed on the LCD screen to guide the operator through set-up and welding.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys Nickel Steels and Alloys Copper and Alloys Titanium 	<ul style="list-style-type: none"> Tig AC and DC Welding Tig HF Start Welding Tig DC Lift start Welding Spot Tig Welding Electrode Welding 	<ul style="list-style-type: none"> Medium-Heavy Fabrications Ship-Building Automotive Industries Nuclear Plant Military plant Ordinary Maintenance Special Maintenance 	<ul style="list-style-type: none"> Inverter Technology TIG Asymmetric Mode Complete AC Regulation Tig AC and DC Welding V.R.D. AC e DC Pulsing Wave Type Selection Display LCD

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



TIG TORCH
Tig Torch with a professional and robust Torch trigger.
- Tig Torch 20 4m H2O Cod. 601292000L
- Tig Torch 20 8m H2O Cod. 601293000L
- Tig Torch 18 4m H2O Cod. 601295000L
- Tig Torch 18 8m H2O Cod. 601296000L



TANK STELFreeze
Cod. 600239000L
5 Liters Tank for Water Cooling System.

Only Power Source

Code	Description
601512000L	TIG μ P 453H AC-DC

Complete Combo H2O

Code	Description
601512000L	TIG μ P 453H AC-DC
601473000L	Water Cooler AWC MPX
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

Accessories

Code	Description
601473000L	Water Cooler AWC MPX
600239000L	5L Tank Liquid STELFreeze
600343000L	Trolley Tig MP
602000001L	Earth Cable 50mm ² 3m
601292000L	Tig Torch TTS 20 4m H2O + 2 Ways Plug
601293000L	Tig Torch TTS 20 8m H2O + 2 Ways Plug
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
601296000L	Tig Torch TTS 18 8m H2O + 2 Ways Plug
601297000L	Tig Torch TTS 18 4m H2O U/D + 14 Ways Plug
601287000L	2 Ways Plug
601286000L	14 Ways Plug
600571000L	Remote Control RC1
601288000L	Cable for Remote Control RC1 10m
601289000L	Cable for Remote Control RC1 20m
601291000L	Cable for Remote Control RC1 30m
601285000L	Remote FOOT Control Cad 4,5m
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

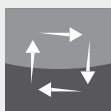
(Included with the Power Source)

MIG (GMAW)



INVERTER RANGE
INVERTER PFC RANGE
STEP MACHINE RANGE

SPECIAL FEATURES MIG STEL



SYNERGIC

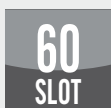
Synergic: Synergy by STEL allows easy adjustment of welding parameters. The operator adjusts only the wire speed while the microprocessor inside the welding machine will look for the correct welding parameter. This results in ease of use, great time saving for the operator and better welding cord aesthetic.



CC/CV

CC/CV: The MAX / 403S generator CC / CV mode allows the generator to be connected to the most common SUITCASE CC / CV.

It is sufficient to connect a power cable between the generator and the case to weld in standard MIG by adjusting the wire speed from the Suitcase.



MEMORY

MEMORY: There are 60 memory slots available to save your favorite programs. The feature is then easily recalled via the front panel.



TIG LIFT

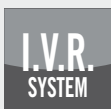
TIG LIFT: With our MMA products you can weld to TIG with LIFT trigger. This type of welding is without high frequency and provides an initial contact situation between the tungsten electrode of the torch and the material.

As soon as the torch is removed from the contact, the welder passes from 0 to the set solder value. The gas is supplied by a special valve mounted on the torch. **(MAX® 403/403S/453/603).**



PFC

PFC: In order to manufacture in respect of reducing harmonic distortion as per the limitations of European Standards December 2010 (EN 61000-3-12) Stel has developed an inovated PFC. (Power Factor Correction). The PFC Multi-Link is able to operate from any input voltage all over the world. This sophisticated device automatically links the primary Voltage supplied from any world plug without manually linking primary voltage terminals. No switching or internal link-up is required by the operator. **(MAX® 403S).**



I.V.R.

I.V.R. System: In any case of wrong connection 1 o 3 Phase there is no damage to the machine because PFC and I.V.R. systems blocks wrong input and prevent operator mistakes. **(MAX® 403S).**



TWIN FAN

TWIN FAN: Ventilation of all STEL welders is called "TWIN FAN" as it has two fans in its interior. A fan pushes the air inside the welding machine while the other pulls the hot air out. This type of ventilation avoids any turbulence that could cause the deposition of ferrous material inside the welding machine.



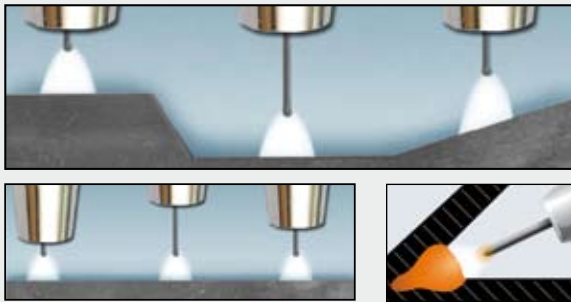
DOW CORNING: All the electronic boards produced by STEL are protected by DOW CORNING painting. This procedure guarantees:

- Existence of different climatic factors (UV, ozone, oxidation),
- Moisture protection, contaminants, short circuits and increased board life.

ST-ARC™

AUTO - COMPENSATION:

Automatically compensates for any variation in welding conditions caused either by irregularities of the workpiece or the movements of the operator's hand. Ideal for awkward angles.



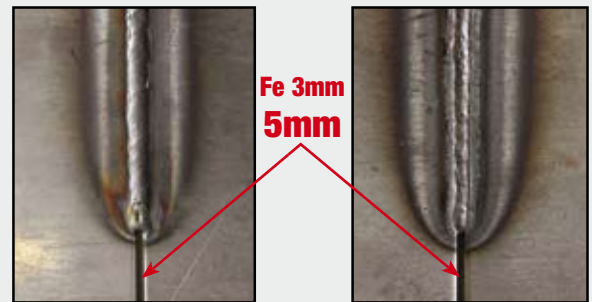
START CONTROL:

The approach speed of the wire to the piece and welding dynamics are synergic and provide limit spatters at the start with every material. The dynamic synergic technology provides for an extremely smooth, spatter free Arc Ignition with all materials.



GAP BRIDGING:

The Short-Arc ST-Arc characteristics of the IRON-MIG welding process is perfect for root passes, or where gaps are needed to be bridged.



LIGHT GAUGE MATERIALS:

The Short-Arc Dynamics result in excellent arc control, minimal spatter levels, reduced Heat Affected Zone and distortion, uniformed bead appearance, solid penetration, and almost no re-working.



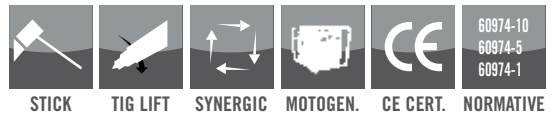
P.A.W™

Precision Aluminium Welding. A new intelligent arc welding control on very thin Aluminium thicknesses from 1 to 2mm. The result is a very short and concentrated welding arc using 1.0mm wire with a standard MIG Torch. Therefore, there is no need for expensive push-pull torches, plus the additional cost saving of using smaller wire diameters that cause problematic feeding.

I-COLD PULSE™

Normally pulsing is a "HOT" process. This has always caused problems of metal distortion (in particular thin material) and working speed. Achieving a fast process has been the manufacturer's challenge of the last years. New processes have developed with many different names under the title SPEED. What about the HEAT? This is the real challenge that STEL has taken with the innovative i-Cold Pulse™. Reducing the thermal heat STEL have been able to increase the welding speed by 35%. The arc is more concentrated and intense granting a better penetration.

Miggy 171



1Phase SYNERGIC Compact Inverter MIG/MAG



Made in ITALY

Technical Data Miggy 171

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (40%)	18,4 A
Real Power (40%)	4,3 KVA
Power Factor	0,8
Efficiency	85 %
No Load Voltage	15-22 V
Current Range	35-150 A
Wire Feed Rollers	2
Welding Current 50% (25°C)	150 A
Welding Current 100% (25°C)	120 A
Welding Current 40% (40°C)	150 A
Welding Current 60% (40°C)	135 A
Welding Current 100% (40°C)	105 A

Features Miggy 171

Earth Clamp - Cable/E.Holder	16 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x190x400
Weight (Version 601075000L)	19,0 Kg

The date is measured at an environment temperature of 40 °C

The principal characteristics are: possibility of MIG/MAG - TIG - MMA welding, microprocessor for functions control, anti-stick, TIG 2t and lift arc, designed and made in accordance with standard EN 60974/1 - EN 60974/10.

A highly competent wire feed mechanism results in smooth feeding of the wire producing a stable arc and quality welds.

Easy to change polarity for welding with gasless wires-no gas cylinder to carry. For site work the Miggy is ideal.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings 	<ul style="list-style-type: none"> Electrode Welding Tig DC Lift start Welding Mig/Mag Welding 	<ul style="list-style-type: none"> Light Fabrications Automotive Industries Special Maintenance Ordinary Maintenance Workshops Installers 	<ul style="list-style-type: none"> Synergic Inverter Technology 4,5kgs Spool Multiprocess (MIG,TIG,MMA) Flux Cored welding Mig Torch included Welding Kit included

Only Power Source

Code	Description	
601075000L	Miggy 171	
-	Cables KIT 16mm ² Dinse 25	(Included with the Power Source)
-	Mig Torch TMS 15 3m Air	(Included with the Power Source)
-	Roller d.30 0,6-0,8 Carbon Steel	(Included with the Power Source)

Complete Combo MIG

Code	Description	
601075000L	Miggy 171	
-	Cables KIT 16mm ² Dinse 25	(Included with the Power Source)
-	Mig Torch TMS 15 3m Air	(Included with the Power Source)
-	Roller d.30 0,6-0,8 Carbon Steel	(Included with the Power Source)
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Complete Combo MIG/TIG/STICK

Code	Description	
601075000L	Miggy 171	
-	Cables KIT 16mm ² Dinse 25	(Included with the Power Source)
-	Mig Torch TMS 15 3m Air	(Included with the Power Source)
-	Roller d.30 0,6-0,8 Carbon Steel	(Included with the Power Source)
6060900000	Tig Torch TTSE 17 4m Air	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Accessories

Code	Description	
601039000L	Cables KIT 16mm ² Dinse 25	(Included with the Power Source)
6061000000	Mig Torch TMS 15 3m Air	(Included with the Power Source)
6060900000	Tig Torch TTSE 17 4m Air	
600514000L	Trolley MPL	
606180000L	Setting up KIT	(Included with the Power Source)
6085800000	Spool no gas d. 0,9mm Kg 4,5	
605250000L	Welding KIT Aluminum Mg d.1,0	
6349800000	Roller d.30 0,9 Filo Flux Cored no gas	
6316000000	Roller d.30 0,6-0,8 Carbon Steel	(Included with the Power Source)
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	

Iron-Mig 201



1Phase SYNERGIC Compact Inverter MIG/MAG



ST-APC™



Made in ITALY

Technical Data Iron-Mig 201

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (20%)	15,8 A
Real Power (20%)	3,5 KVA
Power Factor	0,7
Efficiency	80 %
No Load Voltage	85 V
Current Range	20-190 A
Wire Feed Rollers	2
Welding Current 30% (25°C)	180 A
Welding Current 100% (25°C)	100 A
Welding Current 20% (40°C)	180 A
Welding Current 60% (40°C)	110 A
Welding Current 100% (40°C)	90 A

Features Iron-Mig 201

Earth Clamp - Cable/E.Holder	16 mm ²
Degree of Protection	IP 23S
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x250x390
Weight (Version 60146300L)	19 Kg

The date is measured at an environment temperature of 40 °C

The principal characteristics are: possibility of MIG/MAG and microprocessor for functions control. Designed and made in accordance with standard EN 60974/1 - EN 60974/10.

A highly competent wire feed mechanism results in smooth feeding of the wire producing a stable arc and quality welds.

Easy to change polarity for welding with gasless wires-no gas cylinder to carry. For site work the Iron-Mig is ideal.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings 	<ul style="list-style-type: none"> Mig/Mag Welding 	<ul style="list-style-type: none"> Light Fabrications Automotive Industries Special Maintenance Ordinary Maintenance Workshops Installers 	<ul style="list-style-type: none"> Synergic Inverter Technology 4,5kgs Spool Flux Cored welding Mig Torch included

Main Accessories



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



Trolley XPL
Cod. 601468000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 15 3m Air Cod. 6061000000



Spool-Gun Torch + Interface Board
Cod. 600513000L

Complete Combo MIG

Code	Description	
601463000L	Iron-Mig 201	
-	Earth Clamp + Cable 16mm ² 3m	(Included with the Power Source)
-	Mig Torch TMS 15 3m Air	(Included with the Power Source)
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	
601468000L	Trolley XPL	

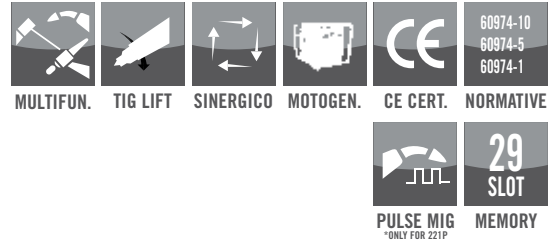
SPOOL-GUN Combo

Code	Description	
601463000L	Iron-Mig 201	
-	Earth Clamp + Cable 16mm ² 3m	(Included with the Power Source)
-	Mig Torch TMS 15 3m Air	(Included with the Power Source)
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
600513000L	Spool-Gun Torch KIT	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	
601468000L	Trolley XPL	

Accessories

Code	Description	
601039000L	Cables KIT 16mm ² Dinse 25	
6061000000	Mig Torch TMS 15 3m Air	(Included with the Power Source)
600514000L	Trolley MPL	
601468000L	Trolley XPL	
600513000L	Spool-Gun Torch KIT	
606180000L	Setting up KIT	(Included with the Power Source)
6085800000	Spool no gas d. 0,9mm Kg 4,5	
601412000L	Spool Holder 5KG d.200mm	
605250000L	Welding KIT Aluminum Mg d.1,0	
6349800000	Roller d.30 0,9 Filo Flux Cored no gas	
6316000000	Roller d.30 0,6-0,8 Carbon Steel	
6316200000	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Iron-Mig 221 MULTI Iron-Mig 221P MULTI



1Phase Compact Inverter MIG/MAG / Pulse MIG/MAG



Technical Data Iron-Mig 221-221P MULTI

Main Voltage	230/240 V
Phase	1
Frequency	50/60 Hz
Real Current (40%)	18,3 A
Real Power (40%)	4,2 KVA
Power Factor	0,7
Efficiency	83 %
No Load Voltage	76 V
Current Range	15-200 A
Wire Feed Rollers	2
Welding Current 35% (25°C)	200 A
Welding Current 100% (25°C)	140 A
Welding Current 25% (40°C)	200 A
Welding Current 60% (40°C)	140 A
Welding Current 100% (40°C)	120 A

Features Iron-Mig 221-221P MULTI

Earth Clamp	25 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x250x390
Weight (Version 60159800L)	20 Kg

The data is measured at an environment temperature of 40 °C

Compact lightweight and practical design makes the portable IRON MIG 221 – 221P MULTI ideally suited for all site-work and workshop applications. Both models 221 MULTI and 221P MULTI with LCD synergic technology provide for speedy selection of material thickness for welding.

A large clear user-friendly Digital Screen provides the operator with coherent parameter information. All parameters are displayed on the LCD screen to guide the operator through set-up and welding.

The function MULTISPOT, is a welding method which combines a pulse-arc with a pre-set time . Possibility to set both the welding time and the pause time separately.

Included Software:

- | | | | | |
|-------------------------|-----------------------------------|-----------------------------------|---------------------------|-----------------------------|
| - Fe 0,6mm | - AlMg5 0,8mm (221P) | - AISi3 0,8mm (221P) | - NiCr 0,8mm Pulse (221P) | - CuSi3 0,8mm Pulse (221P) |
| - Fe 0,8mm | - AlMg5 1,0mm P.A.W. (221P) | - AISi3 1,0mm P.A.W. (221P) | - NiCr 1,0mm Pulse (221P) | - CuSi3 1,0mm Pulse (221P) |
| - Fe 0,8mm Pulse (221P) | - AlMg5 1,0mm Pulse (221P) | - AISi3 1,0mm Pulse (221P) | | |
| - Fe 1,0mm | - AlMg5 1,0mm Double Pulse (221P) | - AISi3 1,0mm Double Pulse (221P) | | - Flux Cored 0,9mm no GAS |
| | - AlMg5 1,2mm (221P) | - AISi3 1,2mm (221P) | | - Flux Cored 0,9mm with GAS |

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys (221P) 	<ul style="list-style-type: none"> Mig/Mag Welding Mig/Mag Pulse Welding (221P) Mig/Mag Brazing (221P) Electrode Welding Tig DC Lift start Welding 	<ul style="list-style-type: none"> Light Fabrications Automotive Industries Special Maintenance Ordinary Maintenance Workshops Installers 	<ul style="list-style-type: none"> Electrode Welding LCD Display P.A.W. (Precision Aluminum Welding) Synergic Inverter Technology 4,5/15 kgs Spool Flux Cored welding Spot Mig

Main Accessories MIG



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



Trolley XPL
Cod. 601468000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

Only Power Source

Code	Description	
601596000L	Iron-Mig 221 MULTI	
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
601598000L	Iron-Mig 221P MULTI	
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)

MIG Combo Iron-Mig 221 MULTI (No Pulse)

Code	Description	
601598000L	Iron-Mig 221 MULTI	
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
601468000L	Trolley XPL	
605150000L	Mig Torch TMS 25 3m Air	
602040000L	Earth Clamp + Cable 25mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

MIG Combo Iron-Mig 221P MULTI (With Pulse)

Code	Description	
601598000L	Iron-Mig 221P MULTI	
-	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
601468000L	Trolley XPL	
605150000L	Mig Torch TMS 25 3m Air	
602040000L	Earth Clamp + Cable 25mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Main Accessories MIG Aluminum



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



KIT Aluminum TMS 25
Cod. 601391000L
Complete Set-up Kit for welding Aluminum.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



Earth Clamp with 25mm²
Cod. 602040000L
- Earth Clamp with 3m 25mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

MIG Aluminum Combo

Code	Description
601598000L	Iron-Mig 221P MULTI
-	Roller d.30 0,8-1,0 Carbon Steel
601391000L	KIT Saldatura Alluminio Mg d.1,0
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
605150000L	Mig Torch TMS 25 3m Air
602040000L	Earth Clamp + Cable 25mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories MIG/TIG



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



TIG TTSE Torch
Cod. 6060900000



Earth Clamp with 25mm²
Cod. 602040000L
- Earth Clamp with 3m 25mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

MIG/TIG Combo

Code	Description
601598000L	Iron-Mig 221P MULTI
-	Roller d.30 0,8-1,0 Carbon Steel
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
605150000L	Mig Torch TMS 25 3m Air
6060900000	Tig Torch TTSE 17 4m Air
602040000L	Earth Clamp + Cable 25mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories MIG/TIG/MMA



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



TIG TTSE Torch
Cod. 6060900000



Cables KIT
Cod. 602060000L
- Earth Clamp with 3m 25mm² rubber cable
- Elect. Holder with 4m 25mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges
(Italian Gas Connection)

MIG/TIG/MMA Combo

Code	Description
601598000L	Iron-Mig 221P MULTI
-	Roller d.30 0,8-1,0 Carbon Steel
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
605150000L	Mig Torch TMS 25 3m Air
6060900000	Tig Torch TTSE 17 4m Air
602060000L	Cables KIT 25mm ² Dinse 50
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories SPOOL-GUN



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



Spool-Gun Torch KIT
Cod. 600513000L



Earth Clamp with 25mm²
Cod. 602040000L
- Earth Clamp with 3m 25mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

SPOOL-GUN Combo

Code	Description
601598000L	Iron-Mig 221P MULTI
-	Roller d.30 0,8-1,0 Carbon Steel
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
600513000L	Spool-Gun Torch KIT
602040000L	Earth Clamp + Cable 25mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories MIG H2O



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 3m H2O Cod. 6015130000



Water Extensions Tube
Cod. 601408000L



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



Water Cooler Plug KIT
Cod. 601413000L

MIG H2O Combo

Code	Description
601598000L	Iron-Mig 221P MULTI
-	Roller d.30 0,8-1,0 Carbon Steel
600514000L	Trolley MPL
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)
6015130000	Mig Torch TMS 500 3m H2O
601408000L	Water Extensions Tube
601471000L	Water Cooler AWC MPS
601413000L	Water Cooler Plug KIT
602040000L	Earth Clamp + Cable 25mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

(Liquid NOT included)

Main Accessories



Spool Holder 5KG d.200mm
Cod. 601412000L



Remote FOOT Control Cad 4,5m
Cod. 600102000L



Spool-Gun Torch + Interface Board
Cod. 600513000L



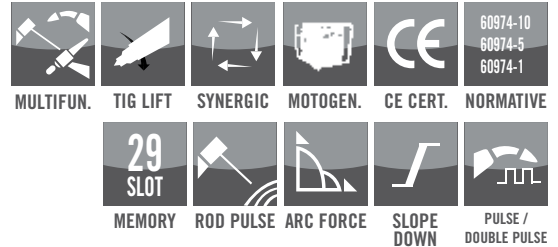
TIG TTSE Torch
Euro Connector with Gas control button.
Cod. 6060900000

Accessories

Code	Description	
600514000L	Trolley MPL	
601407000L	Trolley MPL Accessories (Tig Tube+Cables Hook+Tool Box)	
601408000L	Water Extensions Tube	
601468000L	Trolley XPL	
601412000L	Spool Holder 5KG d.200mm	
600102000L	Remote FOOT Control Cad 4,5m	
TBA	Remote FOOT Control Connection	
600513000L	Spool-Gun Torch KIT	
601471000L	Water Cooler AWC MPS	(Liquid NOT included)
601413000L	Water Cooler Plug KIT 230V 1Ph	
602040000L	Earth Clamp + Cable 25mm ² 3m	
605150000L	Mig Torch TMS 25 3m Air	
6043500000	Mig Torch TMS 36 4m Air	
6015130000	Mig Torch TMS 500 3m H2O	
6060900000	Tig Torch TTSE 17 4m Air	
602060000L	Cables KIT 25mm ² Dinse 50	
606180000L	Setting Up KIT	(Included with the Power Source)
6085800000	Spool no gas d. 0,9mm Kg 4,5	
601391000L	Welding KIT Aluminum Mg d.1,0	
6349800000	Roller d.30 0,9 Filo Flux Cored no gas	
6316000000	Roller d.30 0,6-0,8 Carbon Steel	
6316200000	Roller d.30 0,8-1,0 Carbon Steel	(Included with the Power Source)
6364200000	Roller d.30 0,8-1,0 Aluminum	
634640000L	Roller d.30 1,0-1,2 Aluminum	
6004880000	Liner Teflon/Grafite m.3 ø 0,8-1,0	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)	

Iron-Mig 303-303P

MIG
(GMAW)



3Phase Compact Inverter MIG/MAG / Pulse MIG/MAG



i-Cold Pulse™

ST-APC™

P.A.W.™
PRECISION ALUMINUM WELDING

ROD-PULSE™

**PULSE
DOUBLE PULSE
MIG/MAG**
*ONLY FOR 303P



Made in ITALY

NEW

Technical Data Iron-Mig 303-303P

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	12,1 A
Real Power (35%)	8,2 KVA
Power Factor	0,82
Efficiency	85 %
No Load Voltage	74 V
Current Range	15-300 A
Wire Feed Rollers	4
Welding Current 40% (25°C)	300 A
Welding Current 100% (25°C)	220 A
Welding Current 35% (40°C)	300 A
Welding Current 60% (40°C)	250 A
Welding Current 100% (40°C)	200 A

Features Iron-Mig 303-303P

Earth Clamp	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	680x300x435
Weight (Version 601429000L)	33 Kg

The data is measured at an environment temperature of 40 °C

Compact lightweight and practical design makes the portable 400V IRON MIG 303-303P ideally suited for all site-work and workshop applications. Both models 303 and 303P LCD synergic technology provide for speedy selection of material thickness for welding.

A large clear user-friendly Digital Screen provides the operator with coherent parameter information. All parameters are displayed on the LCD screen to guide the operator through set-up and welding.

This is the real challenge that STEL has taken with the innovative **i-Cold Pulse**. Reducing the thermal heat STEL have been able to increase the welding speed by 35%. The arc is more concentrated and intense granting a better penetration.

The function MULTISPOT, is a welding method which combines a pulse-arc with a pre-set time . Possibility to set both the welding time and the pause time separately.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels (303P) Castings Aluminum and Alloys (303P) 	<ul style="list-style-type: none"> Mig/Mag Welding Tig DC Lift start Welding Mig/Mag Pulse Welding (303P) Mig/Mag Pulse Welding i-Cold (303P) Mig/Mag Brazing (303P) Electrode Welding 	<ul style="list-style-type: none"> Light Fabrications Automotive Industries Special Maintenance Ordinary Maintenance Workshops Installers 	<ul style="list-style-type: none"> LCD Display Synergic Inverter Technology 4,5/15 kgs Spool P.A.W. (Precision Aluminum Welding) (303P) i-Cold Pulse (303P) 4 rolls wire feeder Spot Mig

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPX
Cod. 601473000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 36 4m Air Cod. 6043500000



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years.
Register on our website your product.

Only Power Source

Code	Description	
601435000L	Iron-Mig 303	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
601429000L	Iron-Mig 303P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
6941800000	Warranty Extension Pack 3&5 Years	

MIG Combo Iron-Mig 303P

Code	Description	
601429000L	Iron-Mig 303P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
600343000L	Trolley MP	
6043500000	Mig Torch TMS 36 4m Air	
602000001L	Earth Clamp + Cable 50mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

MIG H2O Combo

Code	Description	
601429000L	Iron-Mig 303P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
600343000L	Trolley MP	
601473000L	Water Cooler AWC MPX	(Liquid NOT included)
6015130000	Mig Torch TMS 500 3m H2O	
602000001L	Earth Clamp + Cable 50mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Main Accessories MIG Aluminum



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



4 ROLLERS DRIVING KIT 1,0mm ALU
Cod. 601459000L
Complete kit with 4 rollers driving for 1,0mm Aluminum wires.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 36 4m Air Cod. 6043500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years. Register on our website your product.

MIG Aluminum Combo

Code	Description
601429000L	Iron-Mig 303P
-	Roller d.37 1,0-1,2 Carbon Steel
600343000L	Trolley MP
6014590000	4 Rollers Driving KIT 0,8-1,0mm Aluminum
6043500000	Mig Torch TMS 36 4m Air
6008060000	Liner Teflon/Grafite m.4 ø 0,8-1,0
602000001L	Earth Clamp + Cable 50mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories TIG/MIG H2O Combo



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 3m H2O Cod. 6015130000



TIG TTSE Torch
Cod. 601294000L



Earth Clamp with 50mm²
Cod. 602000001L
- Earth Clamp with 3m 50mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

TIG/MIG H2O Combo

Code	Description
601429000L	Iron-Mig 303P
-	Roller d.37 1,0-1,2 Carbon Steel
600343000L	Trolley MP
601473000L	Water Cooler AWC MPX
6015130000	Mig Torch TMS 500 3m H2O
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
602000001L	Earth Clamp + Cable 50mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

(Liquid NOT included)

Main Accessories



Remote FOOT Control Cad 4,5m
Cod. 600102000L



Spool-Gun Torch + Interface Board
Cod. 601564000L + 601525000L



Push-Pull Torch + Interface Board
Cod. 601526000L



TIG Torch
Cod. 601294000L



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years.
Register on our website your product.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
600343000L	Trolley MP
601412000L	Spool Holder 5KG d.200mm
600102000L	Remote FOOT Control Cad 4,5m
TBA	Remote FOOT Control Connection
601525000L	Interface Board for Spool-Gun Torch
601564000L	Spool-Gun Torch
601526000L	Interface Board + Push-Pull Torch
601473000L	Water Cooler AWC MPX
600362000L	Water Cooler Plug MPX
602000001L	Earth Clamp + Cable 50mm ² 3m
6043500000	Mig Torch TMS 36 4m Air
6015130000	Mig Torch TMS 500 3m H2O
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
604290000L	Tig Torch TTS 26 4m Air + 14 Ways Plug
606180000L	Setting Up KIT
6361600000	Roller d.37 1,0-1,2 Flux Cored no gas
6360800000	Roller d.37 1,2-1,6 Flux Cored no gas
6364800000	Roller d.37 0,6-0,8 Carbon Steel
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel
6364900000	Roller d.37 0,8-1,0 Aluminum
6360900000	Roller d.37 1,0-1,2 Aluminum
600571000L	Remote Control Cad RC1
601551000L	Remote Control Cable Cad RC1 5m
6014590000	4 Rollers Driving KIT 0,8-1,0mm Aluminum
6014610000	4 Rollers Driving KIT 1,0-1,2mm Aluminum
6008060000	Liner Teflon/Grafite m.4 ø 0,8-1,0
6015580000	Liner Teflon/Grafite m.4 ø 1,0-1,2
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

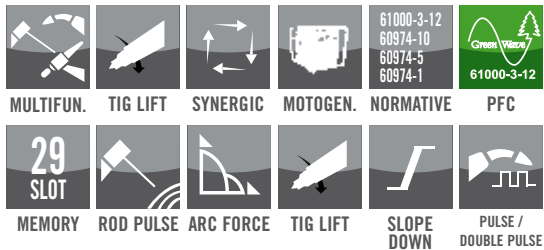
(Liquid NOT included)

(Included with the Water Cooler MPX)

(Included with the Power Source)

(Included with the Power Source)

Iron-Mig 303S-303S P



3Phase Compact Inverter Multivoltage PFC MIG/MAG / Pulse MIG/MAG



Technical Data Iron-Mig 303S-303S P

Voltage Range	200 V → 575 V
Main Voltage	230-400-460-500 V
Phase	1/3
Frequency	50/60 Hz
Real Current (35%)	31,3 / 19,2 A
Real Power (35%)	7,5 KVA
Power Factor	0,95
Efficiency	85 %
No Load Voltage	79 V
Current Range	15-300 A
Wire Feed Rollers	4
Welding Current 35% (25°C)	300 A
Welding Current 100% (25°C)	220 A
Welding Current 35% (40°C)	300 A
Welding Current 60% (40°C)	250 A
Welding Current 100% (40°C)	200 A

Features Iron-Mig 303S-303S P

Earth Clamp	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	680x300x435
Weight (Version 601432000L)	42 Kg

The data is measured at an environment temperature of 40 °C



Made in ITALY

NEW

Compact lightweight and practical design makes the portable 400V IRON MIG 303S-303S P ideally suited for all site-work and workshop applications. Both models 303S and 303S P LCD synergic technology provide for speedy selection of material thickness for welding.

A large clear user-friendly Digital Screen provides the operator with coherent parameter information. All parameters are displayed on the LCD screen to guide the operator through set-up and welding.

This is the real challenge that STEL has taken with the innovative **i-Cold Pulse**. Reducing the thermal heat STEL have been able to increase the welding speed by 35%. The arc is more concentrated and intense granting a better penetration.

The function MULTISPOT, is a welding method which combines a pulse-arc with a pre-set time . Possibility to set both the welding time and the pause time separately.

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels (303P) Castings Aluminum and Alloys (303P) 	<ul style="list-style-type: none"> Mig/Mag Welding Tig DC Lift start Welding Mig/Mag Pulse Welding (303P) Mig/Mag Pulse Welding i-Cold (303P) Mig/Mag Brazing (303P) Electrode Welding 	<ul style="list-style-type: none"> Light Fabrications Automotive Industries Special Maintenance Ordinary Maintenance Workshops Installers 	<ul style="list-style-type: none"> PFC LCD Display Synergic Inverter Technology 4,5/15 kgs Spool P.A.W. (Precision Aluminum Welding) I-Cold Pulse (303P) 4 rolls wire feeder

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPX
Cod. 601473000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 36 4m Air Cod. 6043500000



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years.
Register on our website your product.

Only Power Source

Code	Description	
601437000L	Iron-Mig 303S	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
601432000L	Iron-Mig 303S P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
6941800000	Warranty Extension Pack 3&5 Years	

MIG Combo Iron-Mig 303P

Code	Description	
601432000L	Iron-Mig 303S P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
600343000L	Trolley MP	
6043500000	Mig Torch TMS 36 4m Air	
602000001L	Earth Clamp + Cable 50mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

MIG H2O Combo

Code	Description	
601432000L	Iron-Mig 303S P	
-	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
600343000L	Trolley MP	
601473000L	Water Cooler AWC MPX	(Liquid NOT included)
601413000L	Water Cooler Plug KIT 230V 1Ph	
601554000L	Water Cooler Plug KIT 400V 3Ph	
6015130000	Mig Torch TMS 500 3m H2O	
602000001L	Earth Clamp + Cable 50mm ² 3m	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	

Main Accessories MIG Aluminum



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



4 ROLLERS DRIVING KIT 1,0mm ALU
Cod. 601459000L
Complete kit with 4 rollers driving for 1,0mm Aluminum wires.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 36 4m Air Cod. 6043500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years. Register on our website your product.

MIG Aluminum Combo

Code	Description
601432000L	Iron-Mig 303S P
-	Roller d.37 1,0-1,2 Carbon Steel
600343000L	Trolley MP
6014590000	4 Rollers Driving KIT 0,8-1,0mm Aluminum
6043500000	Mig Torch TMS 36 4m Air
6008060000	Liner Teflon/Grafite m.4 ø 0,8-1,0
602000001L	Earth Clamp + Cable 50mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Main Accessories TIG/MIG H2O Combo



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 3m H2O Cod. 6015130000



TIG TTSE Torch
Cod. 601294000L



Earth Clamp with 50mm²
Cod. 602000001L
- Earth Clamp with 3m 50mm² rubber cable



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)

TIG/MIG H2O Combo

Code	Description
601432000L	Iron-Mig 303S P
-	Roller d.37 1,0-1,2 Carbon Steel
600343000L	Trolley MP
601473000L	Water Cooler AWC MPX
601413000L	Water Cooler Plug KIT 230V 1Ph
601554000L	Water Cooler Plug KIT 400V 3Ph
6015130000	Mig Torch TMS 500 3m H2O
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
602000001L	Earth Clamp + Cable 50mm ² 3m
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

(Liquid NOT included)

Main Accessories



Remote FOOT Control Cad 4,5m
Cod. 600102000L



Spool-Gun Torch + Interface Board
Cod. 601564000L + 601525000L



Push-Pull Torch + Interface Board
Cod. 601526000L



TIG Torch
Cod. 601294000L



WARRANTY EXTENSION
Cod. 6941800000
Warranty extension pack 3&5 Years.
Register on our website your product.

Accessories

Code	Description
6941800000	Warranty Extension Pack 3&5 Years
600343000L	Trolley MP
601412000L	Spool Holder 5KG d.200mm
600102000L	Remote FOOT Control Cad 4,5m
TBA	Remote FOOT Control Connection
601525000L	Interface Board for Spool-Gun Torch
601564000L	Spool-Gun Torch
601526000L	Interface Board + Push-Pull Torch
601473000L	Water Cooler AWC MPX
601413000L	Water Cooler Plug KIT 230V 1Ph
601554000L	Water Cooler Plug KIT 400V 3Ph
602000001L	Earth Clamp + Cable 50mm ² 3m
6043500000	Mig Torch TMS 36 4m Air
6015130000	Mig Torch TMS 500 3m H2O
601294000L	Tig Torch TTS 20 4m H2O U/D + 14 Ways Plug
604290000L	Tig Torch TTS 26 4m Air + 14 Ways Plug
606180000L	Setting Up KIT
6361600000	Roller d.37 1,0-1,2 Flux Cored no gas
6360800000	Roller d.37 1,2-1,6 Flux Cored no gas
6364800000	Roller d.37 0,6-0,8 Carbon Steel
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel
6364900000	Roller d.37 0,8-1,0 Aluminum
6360900000	Roller d.37 1,0-1,2 Aluminum
600571000L	Remote Control Cad RC1
601551000L	Remote Control Cable Cad RC1 5m
6014590000	4 Rollers Driving KIT 0,8-1,0mm Aluminum
6014610000	4 Rollers Driving KIT 1,0-1,2mm Aluminum
6008060000	Liner Teflon/Grafite m.4 ø 0,8-1,0
6015580000	Liner Teflon/Grafite m.4 ø 1,0-1,2
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
6056100000	Gas Regulator with Flow Meter (Italian Gas Connection)

(Liquid NOT included)

(Included with the Power Source)

(Included with the Power Source)

MAX[®] 403 TOP 504 SM



3phase MIG/MAG Inverter

ST-Arc[™] ROD-PULSE[™]



Made in ITALY



Technical Data MAX[®] 403

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	19 A
Real Power (35%)	11,2 KVA
Power Factor	0,85
Efficiency	86 %
No Load Voltage	70 V
Current Range	4-400 A
Wire Feed Rollers	4
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A

Features MAX[®] 403

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	☑
Length/Width/Height (mm)	1040x500x1430
Weight (Version 600361000L)	120 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Wirefeed Made in Switzerland
Material	Aluminum	
Motor	DC Motor perm. magnet	
Pressure Unit	2 (Front and Rear)	
Power	100 W	
Main Voltage	42 V	
Max. wire speed	20 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels 	<ul style="list-style-type: none"> • Electrode Welding • Cellulosic Electrodes (No Citoflex) • TIG Lift Start Welding • Mig/Mag Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Heavy Industries • Special Maintenance • Petro-chemical • Nuclear Plant • Military plant • Mining 	<ul style="list-style-type: none"> • Inverter Technology • Multiprocess • Digital Display • V.R.D. • Arc-Force & Inductance Variable • CC-CV

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 SM
Cod. 600012001L
4 Rollers Wire Feeder for a professional welding.

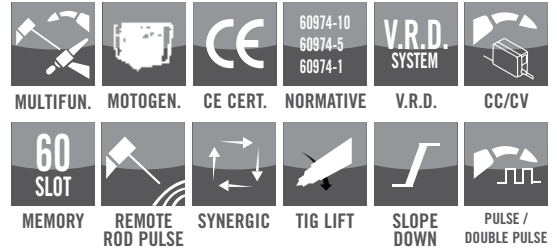
Complete Combo H₂O

Code	Description
600361000L	MAX [®] 403
-	Wire Feed TOP 504 SM
-	Water Cooler AWC MPS (Liquid NOT included)
-	Water Cooler Plug MPS for MAX [®] 403
-	Trolley MP
-	Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
6941800000	Warranty Extension Pack 3&5 Years
600066001L	Wheels Kit for Wire Feed
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

Accessories

Code	Description
600012001L	Wire Feed TOP 504 SM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601471000L	Water Cooler AWC MPS (Liquid NOT included)
600362000L	Water Cooler Plug MPS for MAX [®] 403
600239000L	5L Tank Liquid STELFreeze
601526000L	Interface Board + Push-Pull Torch
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6345000000	Roller d.37 0,8-1,0 Carbon Steel
6315900000	Roller d.37 1,0-1,2 Carbon Steel (included with the TOP 504 SM/XM)
6345100000	Roller d.37 1,2-1,6 Carbon Steel
6345300000	Roller d.37 1,2-1,6 Flux Cored
6327200000	Roller d.37 1,6-2,4 Flux Cored
6345200000	Roller d.37 1,0-1,2 Aluminum
6350500000	Roller d.37 1,6-2,4 Aluminum

MAX[®] 403 TOP 504 XM



3phase SYNERGIC PULSE/DOUBLE PULSE MIG/MAG Inverter



ST-APC[™]
ROD-PULSE[™]
**PULSE
DOUBLE PULSE
MIG/MAG**



Made in ITALY



Technical Data MAX[®] 403

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	19 A
Real Power (35%)	11,2 KVA
Power Factor	0,85
Efficiency	86 %
No Load Voltage	70 V
Current Range	4-400 A
Wire Feed Rollers	4
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A

Features MAX[®] 403

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	1040x500x1430
Weight (Version 601298000L)	120 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Wirefeed Made in Switzerland
Material	Aluminum	
Motor	DC Motor perm. magnet	
Pressure Unit	2 (Front and Rear)	
Power	100 W	
Main Voltage	42 V	
Max. wire speed	20 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Aluminum and Alloys • Nickel Steels and Alloys 	<ul style="list-style-type: none"> • Electrode Welding • Cellulosic Electrodes (No Citoflex) • TIG Lift Start Welding • Mig/Mag Welding • Mig/Mag Pulse Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Heavy Industries • Special Maintenance • Petro-chemical • Nuclear Plant • Military plant • Mining 	<ul style="list-style-type: none"> • Synergic • Inverter Technology • Multiprocess • Digital Display • V.R.D. • Arc-Force & Inductance Variable • CC-CV

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 XM
Cod. 600014001L
4 Rollers Wire Feeder for a professional welding.

Complete Combo H2O

Code	Description
601298000L	MAX [®] 403
-	Wire Feed TOP 504 XM
-	Water Cooler AWC MPS (Liquid NOT included)
-	Water Cooler Plug MPS for MAX [®] 403
-	Trolley MP
-	Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
6941800000	Warranty Extension Pack 3&5 Years
600066001L	Wheels Kit for Wire Feed
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

Accessories

Code	Description
600014001L	Wire Feed TOP 504 XM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601471000L	Water Cooler AWC MPS (Liquid NOT included)
600362000L	Water Cooler Plug MPS for MAX [®] 403
600239000L	5L Tank Liquid STELFreeze
601526000L	Interface Board + Push-Pull Torch
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6345000000	Roller d.37 0,8-1,0 Carbon Steel
6315900000	Roller d.37 1,0-1,2 Carbon Steel (included with the TOP 504 SM/XM)
6345100000	Roller d.37 1,2-1,6 Carbon Steel
6345300000	Roller d.37 1,2-1,6 Flux Cored
6327200000	Roller d.37 1,6-2,4 Flux Cored
6345200000	Roller d.37 1,0-1,2 Aluminum
6350500000	Roller d.37 1,6-2,4 Aluminum

MAX[®] 403S TOP 504 SM



3phase MIG/MAG Multivoltage PFC Inverter

ST-Arc[™]
ROD-PULSE[™]

PFC
Multi-Link[™]



Made in ITALY



Technical Data MAX[®] 403S

Voltage Range	200 V → 575 V
Main Voltage	230-400-460-500 V
Phase	1/3
Frequency	50/60 Hz
Real Current (35%)	24,5-12,5 A (16,5 - 400V)
Real Power (35%)	9,7 KVA (400V)
Power Factor	0,98
Efficiency	87 %
No Load Voltage	70 V
Current Range	4-400 A (4-300A 1F)
Wire Feed Rollers	4
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A (300A 1F)

Features MAX[®] 403S

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	1040x500x1430
Weight (Version 600192000L)	132 Kg

The data is measured at an environment temperature of 40 °C

Technical Data wirefeed 4 rollers		
	Roll Diameter	37
	Material	Aluminum
	Motor	DC Motor perm. magnet
	Pressure Unit	2 (Front and Rear)
	Power	100 W
	Main Voltage	42 V
	Max. wire speed	20 m/min
	Euro Connector	Brass Hexagonal
		<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Wirefeed Made in Switzerland

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels 	<ul style="list-style-type: none"> • Electrode Welding • Cellulosic Electrodes (No Citoflex) • TIG Lift Start Welding • Mig/Mag Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Heavy Industries • Special Maintenance • Petro-chemical • Nuclear Plant • Military plant • Mining 	<ul style="list-style-type: none"> • Inverter Technology • Multiprocess • PFC Multi-Link[™] • Digital Display • I.V.R. & V.R.D System • Arc-Force & Inductance Variable • CC-CV

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 60147100L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 SM
Cod. 600012001L
4 Rollers Wire Feeder for a professional welding.

Complete Combo H2O

Code	Description
600192000L	MAX [®] 403S
-	Wire Feed TOP 504 SM
-	Water Cooler AWC MPS (Liquid NOT included)
-	Water Cooler Plug MPS for MAX [®] 403S
-	Water Cooler Plug KIT 230V 1Ph & 400V 3ph
-	Trolley MP+ Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
6941800000	Warranty Extension Pack 3&5 Years
600066001L	Wheels Kit for Wire Feed
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

Accessories

Code	Description
600012001L	Wire Feed TOP 504 SM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601471000L	Water Cooler AWC MPS (Liquid NOT included)
600362000L	Water Cooler Plug MPS for MAX [®] 403
600239000L	5L Tank Liquid STELFreeze
601526000L	Interface Board + Push-Pull Torch
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6345000000	Roller d.37 0,8-1,0 Carbon Steel
6315900000	Roller d.37 1,0-1,2 Carbon Steel (included with the TOP 504 SM/XM)
6345100000	Roller d.37 1,2-1,6 Carbon Steel
6345300000	Roller d.37 1,2-1,6 Flux Cored
6327200000	Roller d.37 1,6-2,4 Flux Cored
6345200000	Roller d.37 1,0-1,2 Aluminum
6350500000	Roller d.37 1,6-2,4 Aluminum

MAX[®] 403S TOP 504 XM



3phase SYNERGIC PULSE/DOUBLE PULSE MIG/MAG Multivoltage PFC Inverter



**ST-Arc[™]
ROD-PULSE[™]**

**PULSE
DOUBLE PULSE
MIG/MAG**

**PFC
Multi-Link[™]**



Made in ITALY



Technical Data MAX[®] 403S

Voltage Range	200 V → 575 V
Main Voltage	230-400-460-500 V
Phase	1/3
Frequency	50/60 Hz
Real Current (35%)	24,5-12,5 A (16,5 - 400V)
Real Power (35%)	9,7 KVA (400V)
Power Factor	0,98
Efficiency	87 %
No Load Voltage	70 V
Current Range	4-400 A (4-300A 1F)
Wire Feed Rollers	4
Welding Current 45% (25°C)	400 A
Welding Current 60% (25°C)	370 A
Welding Current 100% (25°C)	350 A
Welding Current 35% (40°C)	400 A
Welding Current 60% (40°C)	350 A
Welding Current 100% (40°C)	300 A (300A 1F)

Features MAX[®] 403S

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	1040x500x1430
Weight (Version 600193000L)	132 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Encoder Regulation • Wirefeed Made in Switzerland
Material	Aluminum	
Motor	DC Motor perm. magnet	
Pressure Unit	2 (Front and Rear)	
Power	100 W	
Main Voltage	42 V	
Max. wire speed	20 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Aluminum and Alloys • Nickel Steels and Alloys 	<ul style="list-style-type: none"> • Electrode Welding • Cellulosic Electrodes (No Citoflex) • TIG Lift Start Welding • Mig/Mag Welding • Mig/Mag Pulse Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Heavy Industries • Special Maintenance • Petro-chemical • Nuclear Plant • Military plant • Mining 	<ul style="list-style-type: none"> • Synergic • Inverter Technology • Multiprocess • PFC Multi-Link[™] • Digital Display • I.V.R. & V.R.D System • Arc-Force & Inductance Variable • CC-CV

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 XM
Cod. 600014001L
4 Rollers Wire Feeder for a professional welding.

Complete Combo H2O

Code	Description
600193000L	MAX [®] 403S
-	Wire Feed TOP 504 XM
-	Water Cooler AWC MPS
-	Water Cooler Plug MPS for MAX [®] 403S
-	Water Cooler Plug KIT 230V 1Ph & 400V 3ph
-	Trolley MP + Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
6941800000	Warranty Extension Pack 3&5 Years
600066001L	Wheels Kit for Wire Feed
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

(Liquid NOT included)

Accessories

Code	Description
600014001L	Wire Feed TOP 504 XM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601471000L	Water Cooler AWC MPS
600362000L	Water Cooler Plug MPS for MAX [®] 403
600239000L	5L Tank Liquid STELFreeze
601526000L	Interface Board + Push-Pull Torch
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6345000000	Roller d.37 0,8-1,0 Carbon Steel
6315900000	Roller d.37 1,0-1,2 Carbon Steel
6345100000	Roller d.37 1,2-1,6 Carbon Steel
6345300000	Roller d.37 1,2-1,6 Flux Cored
6327200000	Roller d.37 1,6-2,4 Flux Cored
6345200000	Roller d.37 1,0-1,2 Aluminum
6350500000	Roller d.37 1,6-2,4 Aluminum

(Liquid NOT included)

(included with the TOP 504 SM/XM)

MAX[®] 453 TOP 504 XXM



3phase SYNERGIC PULSE/DOUBLE PULSE MIG/MAG Inverter 4.0



**ST-APC[™]
ROD-PULSE[™]**

**PULSE
DOUBLE PULSE
MIG/MAG**

i-Cold Pulse[™]

P.A.W.[™]

**4.0
industry**
COMING IN 2019



Made in ITALY

NEW
COMING IN 2019

Technical Data

MAX[®] 453

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	19 A
Real Power (35%)	12,4 KVA
Power Factor	0,85
Efficiency	87 %
No Load Voltage	80 V
Current Range	4-450 A
Wire Feed Rollers	4
Welding Current 60% (25°C)	450 A
Welding Current 100% (25°C)	370 A
Welding Current 35% (40°C)	450 A
Welding Current 60% (40°C)	430 A
Welding Current 100% (40°C)	350 A

Features

MAX[®] 453

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	☑
Length/Width/Height (mm)	1040x500x1405
Weight (Versione 601593000L)	135 Kg

The data is measured at an environment temperature of 40 °C

Technical Data wirefeed 4 rollers



Roll Diameter	37
Material	Fiber reinforced polyamide
Motor	DC a magneti permanenti
Pressure Unit	2 (Front and Rear)
Power	75 W
Main Voltage	24 V
Max. wire speed	20 m/min
Euro Connector	Brass Hexagonal

- Rollers changing without tools
- Robust
- 4 Roll Feed
- 2 Pressure Unit
- Wirefeed Made in Switzerland

Materials

- Mild Steels
- Stainless Steels
- Aluminum and Alloys
- Nickel Steels and Alloys

Welding Process

- Mig/Mag Welding
- Mig/Mag Pulse Welding
- Mig/Mag Pulse Welding i-Cold
- TIG Lift Start Welding
- Electrode Welding
- Mig/Mag Brazing

Environments

- Medium-Heavy Fabrications
- Heavy Industries
- Special Maintenance
- Petro-chemical
- Nuclear Plant
- Military plant
- Mining

Main Features

- Display LCD
- Synergic
- Inverter Technology
- 4,5/15 kgs Spool
- P.A.W. (Precision Aluminum Welding)
- i-Cold Pulse
- Industry 4.0
- 4 rolls wire feeder

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 XM
Cod. 601268000L
4 Rollers Wire Feeder for a professional welding with Digital Display and I-Cold Pulse Software.

Complete Combo H2O

Code	Description
601593000L	MAX® 453
-	Wire Feed TOP 504 XXM
-	Water Cooler AWC AWC MPX
-	Water Cooler Plug AWC MPX
-	Trolley MP
-	Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
-	Mig Torch TMS 500 4m H2O
-	Wheels Kit for Wire Feed
6941800000	Warranty Extension Pack 3&5 Years
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

(Liquid NOT included)

Accessories

Code	Description
601268000L	Wire Feed TOP 504 XXM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601473000L	Water Cooler AWC MPX
600362000L	Water Cooler Plug AWC MPX
600239000L	5L Tank Liquid STELFreeze
601622000L	Welding 4.0 Network KIT
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel
6360700000	Roller d.37 1,2-1,6 Carbon Steel
6360800000	Roller d.37 1,2-1,6 Flux Cored
6367200000	Roller d.37 1,6-2,4 Flux Cored
6360900000	Roller d.37 1,0-1,2 Aluminum
6367100000	Roller d.37 1,6-2,4 Aluminum

(included with the TOP 504 XXM)

(Liquid NOT included)

(Included with the Water Cooler MPX)

(included with the TOP 504 XXM)

(included with the TOP 504 XXM)

MAX[®] 603 TOP 504 XXM



3phase SYNERGIC PULSE/DOUBLE PULSE MIG/MAG Inverter 4.0



ST-APC[™]
ROD-PULSE[™]

**PULSE
DOUBLE PULSE
MIG/MAG**

i-Cold Pulse[™]

P.A.W.[™]
industry 4.0
COMING IN 2019



Made in ITALY

NEW
COMING IN 2019

Technical Data MAX[®] 603

Main Voltage	400 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	26 A
Real Power (35%)	18 KVA
Power Factor	0,85
Efficiency	87 %
No Load Voltage	80 V
Current Range	4-550 A
Wire Feed Rollers	4
Welding Current 45% (25°C)	550 A
Welding Current 60% (25°C)	520 A
Welding Current 100% (25°C)	430 A
Welding Current 35% (40°C)	550 A
Welding Current 60% (40°C)	500 A
Welding Current 100% (40°C)	400 A

Features MAX[®] 603

Earth Clamp - Cable/E.Holder	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	CE
Length/Width/Height (mm)	1040x500x1405
Weight (Versione 601594000L)	135 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Wirefeed Made in Switzerland
Material	Fiber reinforced polyamide	
Motor	DC a magneti permanenti	
Pressure Unit	2 (Front and Rear)	
Power	75 W	
Main Voltage	24 V	
Max. wire speed	20 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
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- Mild Steels
- Stainless Steels
- Aluminum and Alloys
- Nickel Steels and Alloys

- Mig/Mag Welding
- Mig/Mag Pulse Welding
- Mig/Mag Pulse Welding i-Cold
- TIG Lift Start Welding
- Electrode Welding
- Mig/Mag Brazing

- Medium-Heavy Fabrications
- Heavy Industries
- Special Maintenance
- Petro-chemical
- Nuclear Plant
- Military plant
- Mining

- Display LCD
- Synergic
- Inverter Technology
- 4,5/15 kgs Spool
- P.A.W. (Precision Aluminum Welding)
- I-Cold Pulse
- Industry 4.0
- 4 rolls wire feeder

Main Accessories



TROLLEY MP
Cod. 600343000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



WATER COOLER AWC MPS
Cod. 601471000L
Cooling System for TIG and MIG/MAG water torch.
Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



TOP 504 XM
Cod. 601268000L
4 Rollers Wire Feeder for a professional welding with Digital Display and I-Cold Pulse Software.

Complete Combo H2O

Code	Description
601594000L	MAX® 603
-	Wire Feed TOP 504 XXM
-	Water Cooler AWC AWC MPX
-	Water Cooler Plug AWC MPX
-	Trolley MP
-	Kit MIG for Trolley MP
-	Interconnecting Cables 70mm ² 5m H2O
-	Mig Torch TMS 500 4m H2O
-	Wheels Kit for Wire Feed
6941800000	Warranty Extension Pack 3&5 Years
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
607010001L	Earth Cable 70mm ² 3m with Clamp

(Liquid NOT included)

Accessories

Code	Description
601268000L	Wire Feed TOP 504 XXM
600343000L	Trolley MP
600367000L	Kit MIG for Trolley MP
600066001L	Wheels Kit for Wire Feed
601473000L	Water Cooler AWC MPX
600362000L	Water Cooler Plug AWC MPX
600239000L	5L Tank Liquid STELFreeze
601622000L	Welding 4.0 Network KIT
600407000L	Interconnecting Cables 70mm ² 5m Air
600408000L	Interconnecting Cables 70mm ² 5m H2O
600409000L	Interconnecting Cables 70mm ² 10m Air
600411000L	Interconnecting Cables 70mm ² 10m H2O
6015130000	Mig Torch TMS 500 3m H2O
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel
6360700000	Roller d.37 1,2-1,6 Carbon Steel
6360800000	Roller d.37 1,2-1,6 Flux Cored
6367200000	Roller d.37 1,6-2,4 Flux Cored
6360900000	Roller d.37 1,0-1,2 Aluminum
6367100000	Roller d.37 1,6-2,4 Aluminum

(included with the TOP 504 XXM)

(Liquid NOT included)

(Included with the Water Cooler MPX)

(included with the TOP 504 XXM)

(included with the TOP 504 XXM)

WELDING 4.0 NETWORK

Multiprocess MIG/MAG machine

4iO
industry



COMING IN 2019

MAX[®] 453-603 Welding 4.0 Network

www.stelgroup.it     



Complete Combo H2O MAX 453

Code	Description
601593000L	KIT MAX [®] 453 + TOP 504 XXM + Water Cooler AWC MPX
601622000L	Welding 4.0 Network KIT

Complete Combo H2O MAX 603

Code	Description
601594000L	KIT MAX [®] 603 + TOP 504 XXM + Water Cooler AWC MPX
601622000L	Welding 4.0 Network KIT

Sky-Mig 353K



3Phase Compact MIG/MAG - 10 Steps



Made in ITALY

Technical Data Sky-Mig 353K

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (20%)	8,5 A
Real Power (20%)	6 KVA
Power Factor	0,95
Efficiency	83 %
No Load Voltage	17,6-36 V
Current Range	30-300 A
Steps	10
Wire Feed Rollers	2/4
Welding Current 20% (40°C)	300 A
Welding Current 60% (40°C)	200 A
Welding Current 100% (40°C)	150 A

Features Sky-Mig 353K

Earth Cable	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	960x380x820
Weight (600112000L Version)	85 Kg

The data is measured at an environment temperature of 40 °C

Technical Data wirefeed 2 rollers			
	Roll Diameter	30	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 2 Roll Feed with (4 Roll Feed optional upgrade) • Wirefeed Made in Switzerland
	Material	Fiber reinforced polyamide	
	Motor	DC Motor perm. magnet	
	Pressure Unit	1 Central	
	Power	50 W	
	Main Voltage	42 V	
	Max. wire speed	19 m/min	
	Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys 	<ul style="list-style-type: none"> • Mig/Mag Welding 	<ul style="list-style-type: none"> • Light Fabrications • Medium-Heavy Fabrications • Automotive Industries • Ordinary Maintenance • Workshops and Building • Auto repair • Working sheets 	<ul style="list-style-type: none"> • Digital Display • 4 Roll Feed (Optional) • 2 T/ 4 T Mig/Mag Welding • Compact • Soft-Start (Soft,Medium,High) • Burn-Back Regolabile • Inching and Gas Purge. • Central Euro Torch Connector

Main Accessories



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



Rollers d. 30
Rollers for compact or separate Wire Feed.
- 0,8-1,0 Carbon Steel Cod. 6316200000
- 0,9 Flux Cored Cod. 6349800000



Rollers d. 37
Rollers for compact or separate Wire Feed.
- 0,8-1,0 Carbon Steel Cod. 6350700000

Only Power Source Air

Code	Description
600112000L	Sky-Mig 353K 2 Rolles
600113000L	Sky-Mig 353K 4 Rolles

Complete Combo Air 2 Rollers

Code	Description
600114000L	Sky-Mig 353K 2 Rolles
-	Earth Cable 50mm ² 3m
-	Mig Torch TMS 25 3m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

Complete Combo Air 4 Rollers

Code	Description
600115000L	Sky-Mig 353K 4 Rolles
-	Earth Cable 50mm ² 3m
-	Mig Torch TMS 25 3m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

Accessories

Code	Description
602000001L	Earth Cable 50mm ² 3m
607010001L	Earth Cable 70mm ² 3m with Clamp
605150000L	Mig Torch TMS 25 3m Air
6043500000	Mig Torch TMS 36 4m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
6316000000	Roller d.30 0,6-0,8 Carbon Steel
6316200000	Roller d.30 0,8-1,0 Carbon Steel
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6349800000	Roller d.30 0,9 Flux Cored
6346400000	Roller d.30 1,0-1,2 Aluminum

(Only for Power Source 2 Rolles)
(Included with the Power Source 2 Rolles)
(Included with the Power Source 4 Rolles))
(Only for Power Source 2 Rolles)
(Only for Power Source 2 Rolles)

Sky-Mig 453K



3Phase SYNERGIC Compact MIG/MAG - 30 Steps



Made in ITALY

Technical Data Sky-Mig 453K

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	15,3 A
Real Power (35%)	10,6 KVA
Power Factor	0,95
Efficiency	75 %
No Load Voltage	17,3-47 V
Current Range	30-400 A
Steps	3x10
Wire Feed Rollers	4
Welding Current 20% (40°C)	400 A
Welding Current 35% (40°C)	350 A
Welding Current 60% (40°C)	250 A
Welding Current 100% (40°C)	200 A

Features Sky-Mig 453K

Earth Cable	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	960x380x820
Weight (600144000L Version)	109 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • Wirefeed Made in Switzerland
Material	Fiber reinforced polyamide	
Motor	DC Motor perm. magnet	
Pressure Unit	1 Central	
Power	100 W	
Main Voltage	42 V	
Max. wire speed	19 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys 	<ul style="list-style-type: none"> • Mig/Mag Welding 	<ul style="list-style-type: none"> • Light Fabrications • Medium-Heavy Fabrications • Automotive Industries • Ordinary Maintenance • Workshops and Building • Auto repair • Working sheets 	<ul style="list-style-type: none"> • Synergic • Digital Display • 4 Roll Feed • 2 T/ 4 T Mig/Mag Welding • Compact • Soft-Start (Soft,Medium,High) • Burn-Back Adjustable • Inching and Gas Purge • Central Euro Torch Connector

Main Accessories



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 36 4m Air Cod. 6043500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



Rollers d. 37
Rollers for compact or separate Wire Feed.
- 0,8-1,0 Carbon Steel Cod. 6350700000
- 1,0-1,2 Carbon Steel Cod. 6360600000
- 1,2-1,6 Flux Cored Cod. 6360800000

Complete Combo Air

Code	Description
600144000L	Sky-Mig 453K Air
602000001L	Earth Cable 50mm ² 3m
6043500000	Mig Torch TMS 36 4m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

Complete Combo H2O

Code	Description
600146000L	Sky-Mig 453K H2O
600147000L	Water Cooler AWC MP Vertical
602000001L	Earth Cable 50mm ² 3m
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

Accessories

Code	Description	
600147000L	Water Cooler AWC MP Vertical	(Liquid NOT included)
600239000L	5L Tank Liquid STELFreeze	
600415000L	Water Cooler Setting Up Sky-Mig Air to Water KIT	(Included with the H2O Combo)
600437000L	Gas Cylinder Bracket for Water Version KIT	(Included with the H2O Combo)
600362000L	Water Cooler Plug MP Vertical	(Included with the H2O Combo)
600443000L	Water Pipes KIT	(Included with the H2O Combo)
602000001L	Earth Cable 50mm ² 3m	
607010001L	Earth Cable 70mm ² 3m with Clamp	
6043500000	Mig Torch TMS 36 4m Air	
6015140000	Mig Torch TMS 500 4m H2O	
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)	
6350700000	Roller d.37 0,8-1,0 Carbon Steel	
6360600000	Roller d.37 1,0-1,2 Carbon Steel	(Included with the Power Source)
6361600000	Roller d.37 1,0-1,2 Flux Cored	
6360800000	Roller d.37 1,2-1,6 Flux Cored	
6360900000	Roller d.37 1,0-1,2 Aluminum	

Sky-Mig 353S



3Phase Separate MIG/MAG - 10 Steps



Made in ITALY

Technical Data Sky-Mig 353S

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (20%)	8,5 A
Real Power (20%)	6 KVA
Power Factor	0,95
Efficiency	83 %
No Load Voltage	17,6-36 V
Current Range	30-300 A
Steps	10
Wire Feed Rollers	4
Welding Current 20% (40°C)	300 A
Welding Current 60% (40°C)	200 A
Welding Current 100% (40°C)	150 A

Features Sky-Mig 353S

Earth Cable	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	960x380x1370
Weight (600161000L Version)	104 Kg

The data is measured at an environment temperature of 40 °C

Technical Data wirefeed 4 rollers		
	Roll Diameter Material Motor Pressure Unit Power Main Voltage Max. wire speed Euro Connector	37 Fiber reinforced polyamide DC Motor perm. magnet 1 Central 100 W 42 V 19 m/min Brass Hexagonal
		<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • Wirefeed Made in Switzerland

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys 	<ul style="list-style-type: none"> • Mig/Mag Welding 	<ul style="list-style-type: none"> • Light Fabrications • Medium-Heavy Fabrications • Automotive Industries • Ordinary Maintenance • Workshops and Building • Auto repair • Working sheets 	<ul style="list-style-type: none"> • Digital Display • 4 Roll Feed • 2 T/ 4 T Mig/Mag Welding • Separate Wire Feeder • Soft-Start (Soft,Medium,High) • Burn-Back Regolabile • Inching and Gas Purge • Central Euro Torch Connector

Main Accessories



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 25 3m Air Cod. 6051500000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



Rollers d. 37
Rollers for compact or separate Wire Feed.
- 0,8-1,0 Carbon Steel Cod. 6350700000
- 1,0-1,2 Carbon Steel Cod. 6360600000
- 1,2-1,6 Flux Cored Cod. 6360800000

Only Power Source Air

Code	Description
600161000L	Sky-Mig 353S
-	Wire Feed TOP 304 TS Air
-	Interconnecting Cables 50mm ² 2,5m Air

Complete Combo Air

Code	Description
600134000L	Sky-Mig 353S
-	Wire Feed TOP 304 TS Air
-	Interconnecting Cables 50mm ² 2,5m Air
-	Earth Cable 50mm ² 3m
-	Mig Torch TMS 25 3m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
600066001L	Wheels Kit for Wire Feed

Accessories

Code	Description
601336000L	Wire Feed TOP 304 TS Air
600066001L	Wheels Kit for Wire Feed
602000001L	Earth Cable 50mm ² 3m
607010001L	Earth Cable 70mm ² 3m with Clamp
600416000L	Interconnecting Cables 50mm ² 2,5m Air
606490001L	Interconnecting Cables 70mm ² 5m Air
606500001L	Interconnecting Cables 70mm ² 10m Air
6051500000	Mig Torch TMS 25 3m Air
6043500000	Mig Torch TMS 36 4m Air
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel
6361600000	Roller d.37 1,0-1,2 Flux Cored
6360800000	Roller d.37 1,2-1,6 Flux Cored
6360900000	Roller d.37 1,0-1,2 Aluminum
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

(Included with the Power Source)

Sky-Mig 453S



3Phase Separate MIG/MAG - 30 Steps



Made in ITALY

Technical Data Sky-Mig 453S

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (35%)	15,3 A
Real Power (35%)	10,6 KVA
Power Factor	0,95
Efficiency	75 %
No Load Voltage	17,3-47 V
Current Range	30-400 A
Steps	3x10
Wire Feed Rollers	4
Welding Current 20% (40°C)	400 A
Welding Current 35% (40°C)	350 A
Welding Current 60% (40°C)	270 A
Welding Current 100% (40°C)	210 A

Features Sky-Mig 453S

Earth Cable	50 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	960x380x1370
Weight (600161000L Version)	121 Kg

The data is measured at an environment temperature of 40 °C

Technical Data wirefeed 4 rollers		
	Roll Diameter Material Motor Pressure Unit Power Main Voltage Max. wire speed Euro Connector	37 Fiber reinforced polyamide DC Motor perm. magnet 1 Central 100 W 42 V 19 m/min Brass Hexagonal
		<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • Wirefeed Made in Switzerland

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys 	<ul style="list-style-type: none"> • Mig/Mag Welding 	<ul style="list-style-type: none"> • Light Fabrications • Medium-Heavy Fabrications • Automotive Industries • Ordinary Maintenance • Workshops and Building • Auto repair • Working sheets 	<ul style="list-style-type: none"> • Digital Display • 4 Roll Feed • 2 T/ 4 T Mig/Mag Welding • Separate Wire Feeder • Soft-Start (Soft,Medium,High) • Burn-Back Regolabile • Inching and Gas Purge • Central Euro Torch Connector

Complete Combo Air

Code	Description
600135000L	Sky-Mig 453S Air
-	Wire Feed TOP 304 TS Air
-	Interconnecting Cables 50mm ² 2,5m Air
602000001L	Earth Cable 50mm ² 3m
6043500000	Mig Torch TMS 36 4m Air
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
600066001L	Wheels Kit for Wire Feed

Complete Combo H2O

Code	Description
600159000L	Sky-Mig 453S H2O
-	Water Cooler AWC MP Vertical (Liquid NOT included)
-	Wire Feed TOP 304 TS H2O
-	Interconnecting Cables 70mm ² 5m H2O
602000001L	Earth Cable 50mm ² 3m
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
600066001L	Wheels Kit for Wire Feed

Accessories

Code	Description
601336000L	Wire Feed TOP 304 TS Air (Included with the Air Combo)
600148000L	Wire Feed TOP 304 TS H2O (Included with the H2O Combo)
600417000L	Water Cooler Setting Up TOP 304 TS Air to Water (Included with the H2O Combo)
600437000L	Gas Cylinder Braket for Water Version KIT (Included with the H2O Combo)
600362000L	Water Cooler Plug MP Vertical (Included with the H2O Combo)
600147000L	Water Cooler AWC MP Vertical (Liquid NOT included)
600239000L	5L Tank Liquid STELFreeze
600066001L	Wheels Kit for Wire Feed
602000001L	Earth Cable 50mm ² 3m
607010001L	Earth Cable 70mm ² 3m with Clamp
600416000L	Interconnecting Cables 50mm ² 2,5m Air
606490001L	Interconnecting Cables 70mm ² 5m Air
606500001L	Interconnecting Cables 70mm ² 10m Air
606520001L	Interconnecting Cables 70mm ² 5m H2O
606530001L	Interconnecting Cables 70mm ² 10m H2O
6043500000	Mig Torch TMS 36 4m Air
6015140000	Mig Torch TMS 500 4m H2O
6350700000	Roller d.37 0,8-1,0 Carbon Steel
6360600000	Roller d.37 1,0-1,2 Carbon Steel (Included with the Power Source)
6360900000	Roller d.37 1,0-1,2 Aluminum
6360800000	Roller d.37 1,2-1,6 Flux Cored
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

Sky-Mig 553S



3Phase SYNERGIC Seperate MIG/MAG - 30 Steps



Technical Data	Sky-Mig 553S
Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (60%)	23,8 A
Real Power (60%)	16,5 KVA
Power Factor	0,95
Efficiency	91 %
No Load Voltage	18,8-46,2 V
Current Range	30-500 A
Steps	3x10
Wire Feed Rollers	4
Welding Current 20% (40°C)	500 A
Welding Current 60% (40°C)	450 A
Welding Current 100% (40°C)	350 A

Features	Sky-Mig 553S
Earth Cable	70 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	960x380x1370
Weight (600145000L Version)	190 Kg

The data is measured at an environment temperature of 40 °C



Technical Data wirefeed 4 rollers		
Roll Diameter	37	<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Wirefeed Made in Switzerland
Material	Aluminum	
Motor	DC Motor perm. magnet	
Pressure Unit	2 (Front and Rear)	
Power	100 W	
Main Voltage	42 V	
Max. wire speed	20 m/min	
Euro Connector	Brass Hexagonal	

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys 	<ul style="list-style-type: none"> • Mig/Mag Welding 	<ul style="list-style-type: none"> • Medium-Heavy Fabrications • Automotive Industries • Ordinary Maintenance • Workshops and Building • Auto repair • Working sheets 	<ul style="list-style-type: none"> • Synergic • Digital Display • 4 Roll Feed • 2 T/ 4 T Mig/Mag Welding • Separate Wire Feeder • Soft-Start (Soft,Medium,High) • Burn-Back Regolabile • Inching and Gas Purge • Central Euro Torch Connector

Main Accessories



MIG/MAG Torch
Mig/Mag professional Torch
- Mig Torch 500 4m H2O Cod. 6015140000



GAS REGULATOR 2 GAUGES
Cod. 6055900000
Gas Regulator with 2 Gauges (Italian Gas Connection)



Rollers d. 37
Rollers for compact or separate Wire Feed.
- 0,8-1,0 Carbon Steel Cod. 6345000000
- 1,0-1,2 Carbon Steel Cod. 6315900000
- 1,2-1,6 Flux Cored Cod. 6345300000

Complete Combo H2O

Code	Description
600145000L	Sky-Mig 553S H2O
-	Water Cooler AWC MP Vertical (Liquid NOT included)
-	Wire Feed TOP 504 TS H2O
-	Interconnecting Cables 70mm ² 5m H2O
607010001L	Earth Cable 70mm ² 3m with Clamp
6015140000	Mig Torch TMS 500 4m H2O
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)
600066001L	Wheels Kit for Wire Feed

Accessories

Code	Description
600149000L	Wire Feed TOP 504 TS H2O (Included with the Power Source)
600147000L	Water Cooler AWC MP Vertical (Liquid NOT included)
600239000L	5L Tank Liquid STELFreeze
600066001L	Wheels Kit for Wire Feed
607010001L	Earth Cable 70mm ² 3m with Clamp
606520001L	Interconnecting Cables 70mm ² 5m H2O
606530001L	Interconnecting Cables 70mm ² 10m H2O
6015140000	Mig Torch TMS 500 4m H2O
6345000000	Roller d.37 0,8-1,0 Carbon Steel
6315900000	Roller d.37 1,0-1,2 Carbon Steel (Included with the Power Source)
6345200000	Roller d.37 1,0-1,2 Aluminum
6361700000	Roller d.37 1,2-1,6 Aluminum
6345300000	Roller d.37 1,2-1,6 Flux Cored
6055900000	Gas Regulator 2 Gauges (Italian Gas Connection)

PLASMA CUTTING



INVERTER RANGE
INVERTER PFC RANGE

THOR 41K PFC



TEST GAS	MOTOGEN.	SAFETY BUTTON	CE CERT.	61000-3-12 60974-10 60974-1	61000-3-12 Green Welder
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INCLUDED

Inverter 1Phase PFC Plasma Cutting



PFC Multi-Link™



Technical Data THOR 41K PFC

Voltage Range	150 V → 290 V
Main Voltage	230 V
Phase	1
Frequency	50/60 Hz
Real Current (35%)	9,5 A
Real Power (35%)	2,2 KVA
Power Factor	0,99
Efficiency	74 %
No Load Voltage	250 V
Current Range	15-30 A
Cutting Current 40% (25°C)	30 A
Cutting Current 100% (25°C)	27 A
Cutting Current 35% (40°C)	30 A
Cutting Current 60% (40°C)	26 A
Cutting Current 100% (40°C)	25 A

Features THOR 41K PFC

Earth Cable	10 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	580x190x405
Weight (600223000L Version)	23,8 Kg

The data is measured at an environment temperature of 40 °C

The technology "Check Consumables" warns the operator when consumables are ready for replacement, therefore avoiding damage to torch.

Due to the PFC feature, the Plasmacutter Thor 41K PFC can cut connected to any 1Phase plug world wide, working from 150 to 290 V without modifications. The Air Compressor incorporated with the Inverter makes cutting possible without the use of large external industrial compressors.

Portable and compact, the THOR 41K PFC can be utilized in various areas, site-work, buildings and plumbing, fabrication work-shops and car body repairs. Simple operating use, fast cutting speeds.

CUTTING THICKNESS

8mm Recommended Quality Cut (500mm/min)	10mm Quality Cut (250mm/min)	12mm Maximun Separation
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PIERCE RATING OF 6mm

The declared cutting data are equal with internal or external compressor

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys Copper and Alloys 	<ul style="list-style-type: none"> Plasma Cutting 	<ul style="list-style-type: none"> Light Fabrications Special Maintenance Ordinary Maintenance Maintenance Building and plumbing Electricians and installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Ease of operation Test Gas Reset Incorporated Compressor Fireproof plastic PFC Consumables Check

Main Accessories



CIRCLE CUTTING KIT
Cod.6083000000
Complete Circle Cutting attachment for HammerCut 40K.



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source with HammerCut 40K 4m

Code	Description	
600223000L	THOR 41 K PFC	
-	Earth Cable 10mm ²	(Included with the Power Source)
-	HammerCut Torch 40K 4m	(Included with the Power Source)

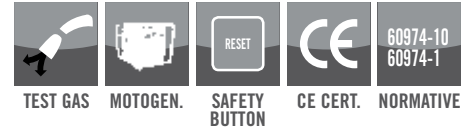
Recommended Consumables

Code	Description	Pack/Pcs
601051000L	Medium Electrode	10
601052000L	Air Diffusor	2
601053000L	Medium Tip	10
601256000L	Shield Cup Body	4
600331000L	Stand off Guide	1

Accessories

Code	Description	
607790000L	Earth Cable 10mm ²	(Included with the Power Source)
6002270000	HammerCut Torch 40K 4m	(Included with the Power Source)
6083000000	Circle Cutting KIT	
600514000L	Trolley MPL	

THOR 73 (3F)



Inverter 3Phase Plasma Cutting



Technical Data	THOR 73 (3F)
Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (60%)	11,3 A
Real Power (60%)	7,8 KVA
Power Factor	0,8
Efficiency	83 %
No Load Voltage	320 V
Current Range	30-60 A
Cutting Current 60% (25°C)	-
Cutting Current 100% (25°C)	50 A
Cutting Current 60% (40°C)	60 A
Cutting Current 100% (40°C)	40 A

Features	THOR 73 (3F)
Earth Cable	10 mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	500x200x360
Weight (601273000L Version)	14 Kg

The data is measured at an environment temperature of 40 °C

The THOR range is composed of a series of INVERTER Power Sources for plasma cutting.

The "Reset" feature is a Safety function that automatically isolates the machine whilst changing consumables, therefore providing added protection to the operator. The Arc can not be ignited while "Reset" warning is activated.

CUTTING THICKNESS

18mm Recommended Quality Cut (500mm/min)	22mm Quality Cut (250mm/min)	25mm Maximum Separation
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PIERCE RATING OF 12mm

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> • Mild Steels • Stainless Steels • Castings • Aluminum and Alloys • Copper and Alloys 	<ul style="list-style-type: none"> • Plasma Cutting 	<ul style="list-style-type: none"> • Medium Fabrications • Special Maintenance • Ordinary Maintenance • Maintenance • Building and plumbing • Electricians and installers • Workshops 	<ul style="list-style-type: none"> • Inverter Technology • Ease of operation • Test Gas • Reset

Main Accessories



CIRCLE CUTTING KIT
Cod.6074800000
Complete Circle Cutting attachment for Plasma Torch.



INTERFACE KIT FOR AUTOMATIONS
Cod. 600467000L
Possibility to connect Thor Series to an automatic system with the interface kit.



Trolley MPL
Cod. 600514000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.

Only Power Source with Torch 6m

Code	Description	
601273000L	THOR 73 3F	
-	Earth Cable 10mm ²	(Included with the Power Source)
-	Plasma Torch SL60 6m	(Included with the Power Source)

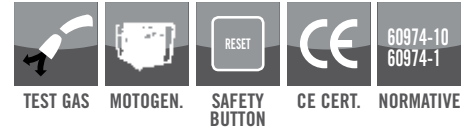
Recommended Consumables

Code	Description	Pack/Pcs
607360000L	Electrode	5
607370000L	Start Cartridge	1
607390000L	Tip Cutting 60A	5
607410000L	Shield Cup Body Maximum Life	1
607420000L	Shield Cup Cutting 60A	1

Accessories

Code	Description	
600263000L	Earth Cable 10mm ²	(Included with the Power Source)
600514000L	Trolley MPL	
600467000L	Automation KIT	
605600000L	Plasma Torch SL60 6m	(Included with the Power Source)
601416000L	Plasma Torch SL60 7,5m Automatic	
6074800000	Circle Cutting KIT	

THOR 123



Inverter 3Phase Plasma Cutting



Technical Data THOR 123

Main Voltage	380/415 V
Phase	3
Frequency	50/60 Hz
Real Current (20%)	13,5 A
Real Power (20%)	9 KVA
Power Factor	0,9
Efficiency	87 %
No Load Voltage	270 V
Current Range	20-100 A
Cutting Current 60% (25°C)	85 A
Cutting Current 100% (25°C)	75 A
Cutting Current 20% (40°C)	100 A
Cutting Current 60% (40°C)	75 A
Cutting Current 100% (40°C)	65 A

Features THOR 123

Earth Cable	16mm ²
Degree of Protection	IP 23
Insulation Class	H
Work Temperature	40°C
Safety Approved	
Length/Width/Height (mm)	495x280x720
Weight (600404000L Version)	46 Kg

The date is measured at an environment temperature of 40 °C

The THOR range is composed of a series of INVERTER Power Sources for plasma cutting.

The "Reset" feature is a Safety function that automatically isolates the machine whilst changing consumables, therefore providing added protection to the operator. The Arc can not be ignited while "Reset" warning is activated.

CUTTING THICKNESS

25mm Recommended Quality Cut (500mm/min)	30mm Quality Cut (250mm/min)	40mm Maximun Separation
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PIERCE RATING OF 15mm

Materials	Welding Process	Environments	Main Features
<ul style="list-style-type: none"> Mild Steels Stainless Steels Castings Aluminum and Alloys Copper and Alloys 	<ul style="list-style-type: none"> Plasma Cutting 	<ul style="list-style-type: none"> Medium & Heavy Fabrications Special Maintenance Ordinary Maintenance Maintenance Building and plumbing Electricians and installers Workshops 	<ul style="list-style-type: none"> Inverter Technology Ease of operation Test Gas Reset

Main Accessories



TROLLEY KIT XP
Cod. 600364000L
The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.



Plasma Torch 100 Automatic
Cod.600451000L
- Rubber Cable7,5m
- Long Life Consumables



INTERFACE KIT FOR AUTOMATIONS
Cod. 600455000L
Possibility to connect Thor Series to an automatic system with the interface kit.

Only Power Source with Torch 6m

Code	Description	
600404000L	THOR 123	
-	Earth Cable 16mm ²	(Included with the Power Source)
-	Plasma Torch SL100 6m	(Included with the Power Source)
600364000L	Trolley XP	

Recommended Consumables

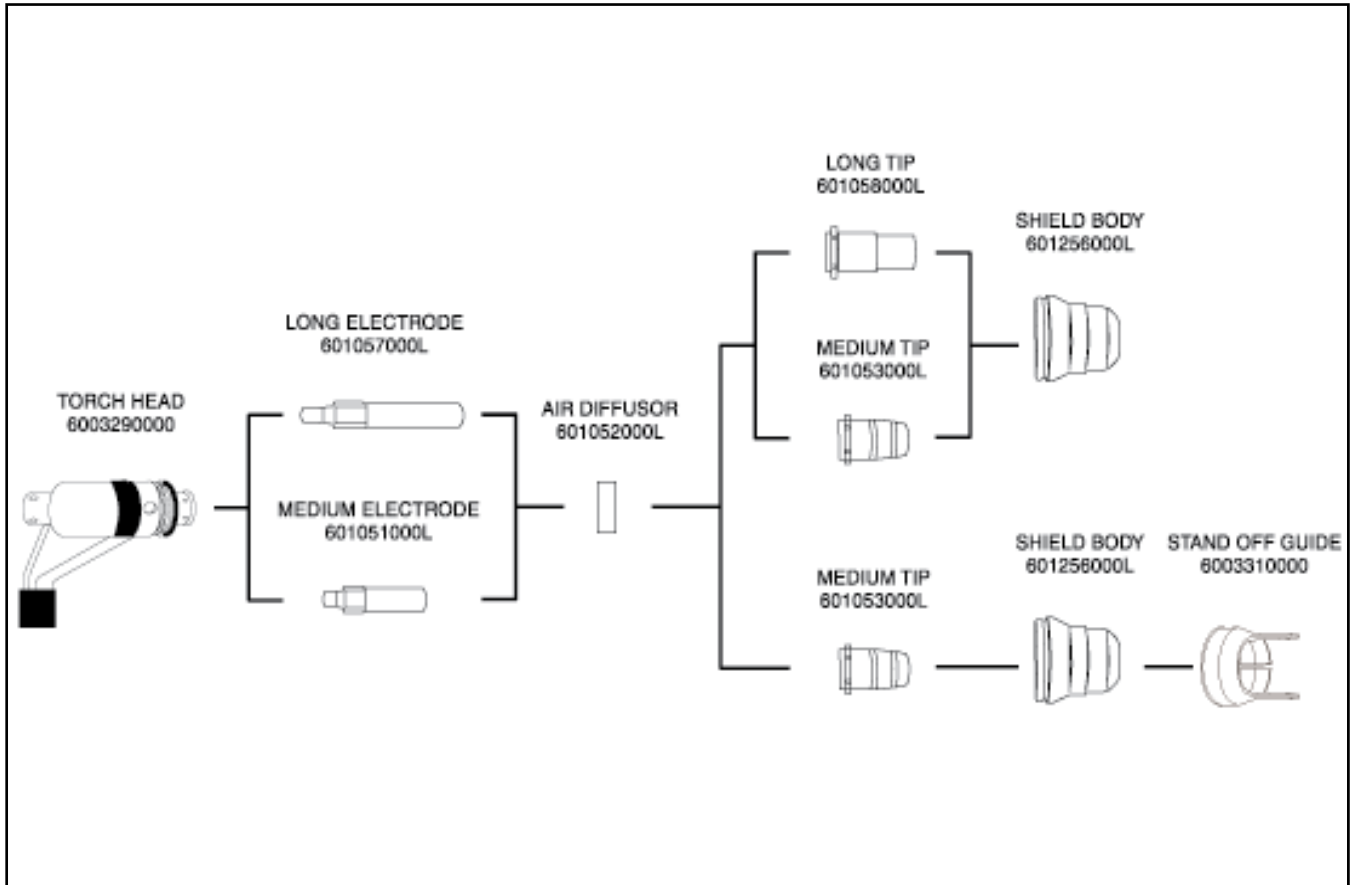
Code	Description	Pack/Pcs
607360000L	Electrode	5
6073700000	Start Cartridge	1
607400000L	Tip Cutting 100A	5
607410000L	Shield Cup Body Maximum Life	1
607430000L	Shield Cup Cutting 100A	1

Accessories

Code	Description	
600364000L	Trolley XP	
600455000L	Automation KIT	
600444000L	Earth Cable 16mm ²	(Included with the Power Source)
600445000L	Plasma Torch SL100 6m	(Included with the Power Source)
600451000L	Plasma Torch SL100 7,5m Automatic	
6074800000	Circle Cutting KIT	



HAMMERCUT 40K THOR 41K

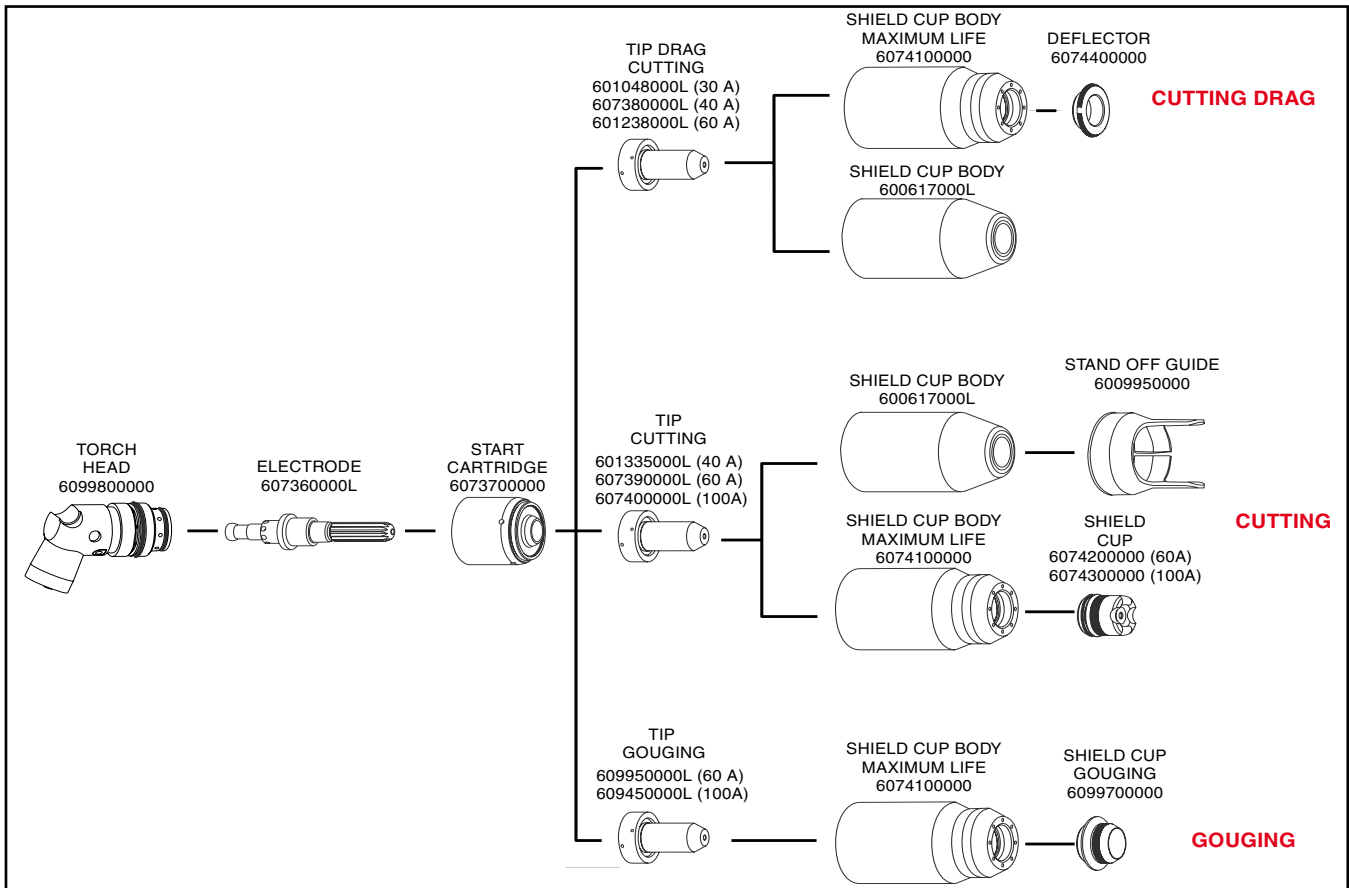


Consumables HAMMERCUT 40K

Code	Description	Pack/Pcs
601058000L	Long Tip 30A	10
601053000L	Medium Tip 30A	10
601057000L	Long Electrode	10
601051000L	Medium Electrode	10
601256000L	External Shield Body	4
600331000L	Stand Off Guide	1
601052000L	Air Diffusor	2
6003290000	Torch Head	1



SL60-100 THOR 73-123



Consumables SL60/SL100

Code	Description		Pack/Pcs
601048000L	Tip Cutting Drag 30A	9-8206	5
607380000L	Tip Cutting Drag 40A	9-8207	5
601238000L	Tip Cutting Drag 60A	9-8252	5
601335000L	Tip Cutting 40A	9-8208	5
607390000L	Tip Cutting 60A	9-8210	5
607400000L	Tip Cutting 100A	9-8212	5
609950000L	Tip Cutting Gouging 60A	9-8226	5
609450000L	Tip Cutting Gouging 100A	9-8228	5
607360000L	Electrode	9-8215	5
607410000L	Shield Cup Body Maximum Life	9-8237	1
600617000L	Shield Cup Body	9-8218	1
607420000L	Shield Cup Cutting 60A	9-8235	1
607430000L	Shield Cup Cutting 100A	9-8236	1
609970000L	Shield Cup Gouging	9-8241	1
600995000L	Stand off Guide	9-8281	1
607440000L	Deflector	9-8243	1
607370000L	Start Cartridge	9-8213	1
6099800000	Torch Head	9-8219	1
605600000L	Torch 6m SL60	7-5253	1
600445000L	Torch 6m SL100	7-5254	1

MULTI PROCESS



INVERTER RANGE

INVERTER PFC RANGE

MULTIP. RANGE



Inverter Multiprocess

Made in ITALY



**IRON-MIG 221-221P
MULTI**

**IRON-MIG
300-303P / 303S-303S P**

MAX 403-403S

MAX 453-603

Technical Data	Iron-Mig 221-221P MULTI	Iron-Mig 303-303P / 303S-303S P	MAX 403-403S	MAX 453-603
Main Voltage	230/240 V	230-400-460-500 V (400V x 303-303P)	400 V - 230/400/460/500 V	400 V
Phase	1	1/3 (3 x 303-303P)	3 - 1/3	3
Frequency	50/60 Hz	50/60 Hz	50/60 Hz	50/60 Hz
Real Current (35%)	18,3 A	12,1 A	19 A - 24,5/12,5 A (16,5 / 400V)	19 / 26 A
Real Power (35%)	4,2 KVA	8,2 KVA	11,2 KVA - 9,7 KVA (400V)	12,4 / 18 KVA
Power Factor	0,7	0,82	0,85 - 0,98	0,85
Efficiency	83 %	85 %	85 % - 87%	87 %
No Load Voltage	76 V	74 V	70 V	80 V
Current Range	4-400 A	15-300 A	4-400 A	4-450 / 550 A
Welding Current 35% (40°C)	200 A	300 A	400 A	450 / 550 A
Welding Current 60% (40°C)	140 A	250 A	350 A	430 / 500 A
Welding Current 100% (40°C)	120 A	200 A	300 A	350 / 400 A

Features	Iron-Mig 221-221P MULTI	Iron-Mig 303-303P / 303S-303S P	MAX 403-403S	MAX 453-603
Degree of Protection	IP 23	IP 23	IP 23	IP 23
Work Temperature	40°C	40°C	40°C	40°C
Length/Width/Height (mm)	500x250x390	680x300x435	460x250x600	680x300x435
Weight	20 Kg	33 - 42 Kg	32 Kg - 40 Kg	50 Kg

The date is measured at an environment temperature of 40 °C

Accessories



TOP 504 SM-XM
Cod. 600012001L - 600014001L
4 Rollers Wire Feeder for a professional
MIG welding or Synergic Pulse MIG.



TOP 504 XXM
Cod. 601268000L
4 Rollers Wire Feeder for a professional
welding. Synergic with Digital Display.



SUITCASE CC/CV
Cod. 601312000L
MAX® Series can operate together with many
different Industrial Suitcase Wire Feeders.



BOX TIG T.R.U. 500
Cod. 600009000L
With the BOX TIG the MAX® Series
became a TIG DC of 400/500Amps.

Only Power Source

Code	Description
601598000L	Iron-Mig 221 MULTI
601596000L	Iron-Mig 221P MULTI
601435000L	Iron-Mig 303
601429000L	Iron-Mig 303P
601437000L	Iron-Mig 303S
601432000L	Iron-Mig 303S P
600243000L	MAX® 403
601282000L	MAX® 403S
601507000L	MAX® 453
601476000L	MAX® 603

Accessories

Code	Description	
600009000L	Box TIG T.R.U. 500	(available only for MAX 403/403S)
600012001L	Wire Feed TOP 504 SM	
600014001L	Wire Feed TOP 504 XM	
601268000L	Wire Feed TOP 504 XXM	
600343000L	Trolley MP	
600364000L	Trolley XP	
600367000L	Kit MIG for Trolley MP	
601302000L	Kit TIG per Trolley MP	
600066001L	Wheels Kit for Wire Feed	(included with the TOP 504 XXM)
601471000L	Water Cooler AWC MPS	(Liquid NOT Included)
601473000L	Water Cooler AWC MPX	(Liquid NOT Included)
600362000L	Water Cooler Plug	(Included with the Water Cooler MPX)
601413000L	Water Cooler Plug KIT 230V 1Ph	
601554000L	Water Cooler Plug KIT 400V 3Ph	
600015000L	Remote Control RCCS	
600026000L	Cable for Remote Control RCCS 10m	
600027000L	Cable for Remote Control RCCS 20m	
600028000L	Cable for Remote Control RCCS 30m	
600407000L	Interconnecting Cables 70mm² 5m Air	
600408000L	Interconnecting Cables 70mm² 5m H2O	
600409000L	Interconnecting Cables 70mm² 10m Air	
600411000L	Interconnecting Cables 70mm² 10m H2O	
600037001L	Welding Connection Cable 5m T.R.U.	
600038000L	Welding Connection Cable 10m T.R.U.	
6043500000	Mig Torch TMS 36 4m Air	
6015130000	Mig Torch TMS 500 3m H2O	
6015140000	Mig Torch TMS 500 4m H2O	
600974000L	Tig Torch TTS 26 4m Air + 3 Ways Plug	
605060000L	Tig Torch TTS 18 4m H2O + 3 Ways Plug	
600975000L	Tig Torch TTS 26 8m Air + 3 Ways Plug	
600976000L	Tig Torch TTS 18 8m H2O + 3 Ways Plug	
6345000000	Roller d.37 0,8-1,0 Carbon Steel	
6315900000	Roller d.37 1,0-1,2 Carbon Steel	(included with the TOP 504 SM/XM/XXM)
6345100000	Roller d.37 1,2-1,6 Carbon Steel	
6345300000	Roller d.37 1,2-1,6 Flux Cored	
6327200000	Roller d.37 1,6-2,4 Flux Cored	
6345200000	Roller d.37 1,0-1,2 Aluminum	(included with the TOP 504 XXM)
6350500000	Roller d.37 1,6-2,4 Aluminum	

MARINE SOLUTION





INVERTER RANGE

MARINE (OFF-SHORE)

Inverter Multiprocess

Made in ITALY



Technical Data	MAX [®] 403 NAVY	MAX [®] 453	MAX [®] 603
Main Voltage	400 V	400 V	400 V
Phase	3	3	3
Frequency	50/60 Hz	50/60 Hz	50/60 Hz
Real Current (35%)	19 A	19 A	26 A
Real Power (35%)	11,2 KVA	12,4 KVA	18 KVA
Power Factor	0,85	0,85	0,85
Efficiency	86 %	87 %	87 %
No Load Voltage	70 V	80 V	80 V
Current Range	4-400 A	4-450 A	4-550 A
Welding Current 35% (40°C)	400 A	450 A	550 A
Welding Current 60% (40°C)	350 A	430 A	500 A
Welding Current 100% (40°C)	300 A	350 A	400 A

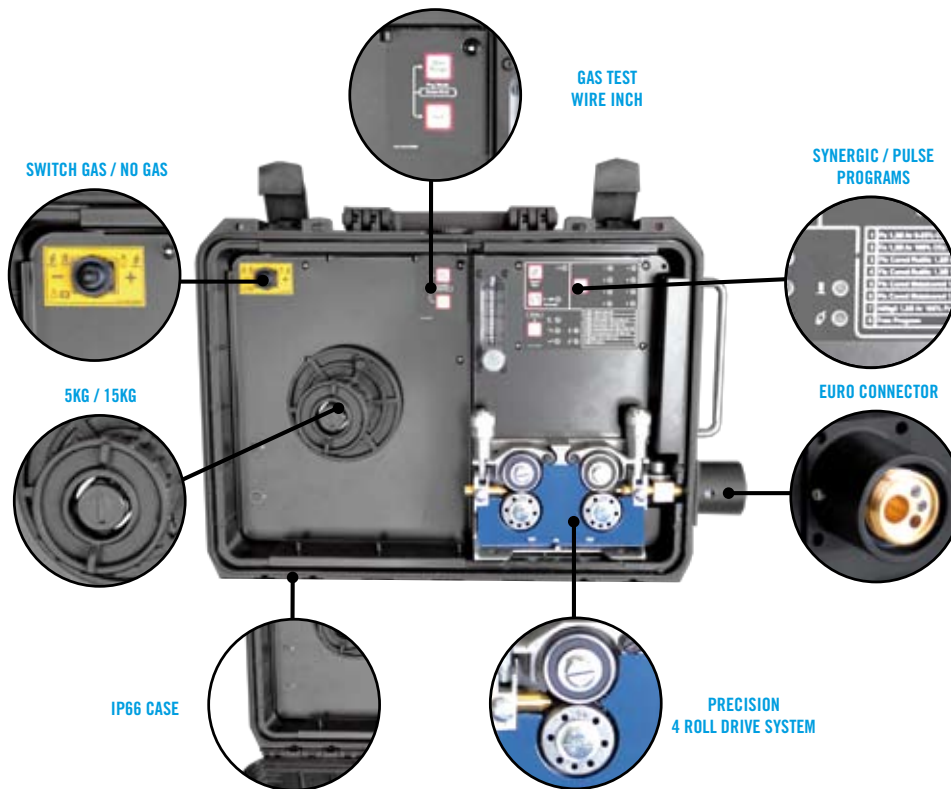
Features	MAX [®] 403 NAVY	MAX [®] 453	MAX [®] 603
Degree of Protection	IP 23	IP 23	IP 23
Work Temperature	40°C	40°C	40°C
Length/Width/Height (mm)	460x250x600	680x300x435	680x300x435
Weight	32 Kg	50 Kg	50 Kg

The data is measured at an environment temperature of 40 °C

Only Power Source

Code	Description
601537000L	MAX [®] 403 NAVY
601507000L	MAX [®] 453
601476000L	MAX [®] 603

TOP 504 NAVY 5 - 15



SYNERGIC PROGRAM AVAILABLE:

- Fe 1,2mm Ar 8-25% CO2
- Fe 1,2mm Ar 100% CO2
- Flx Cored Rutilic 1,2mm Ar 8-25% Co2
- Flx Cored Rutilic 1,2mm 100% CO2
- Flx Cored Metalcored 1,2mm Ar 8-25% CO2
- Flx Cored Metalcored 1,2mm 100% CO2
- AlMg5 1,2mm Ar 100% **PULSE**
- Free Program

Mig Inverter & Suitcase SYNERGIC/PULSE



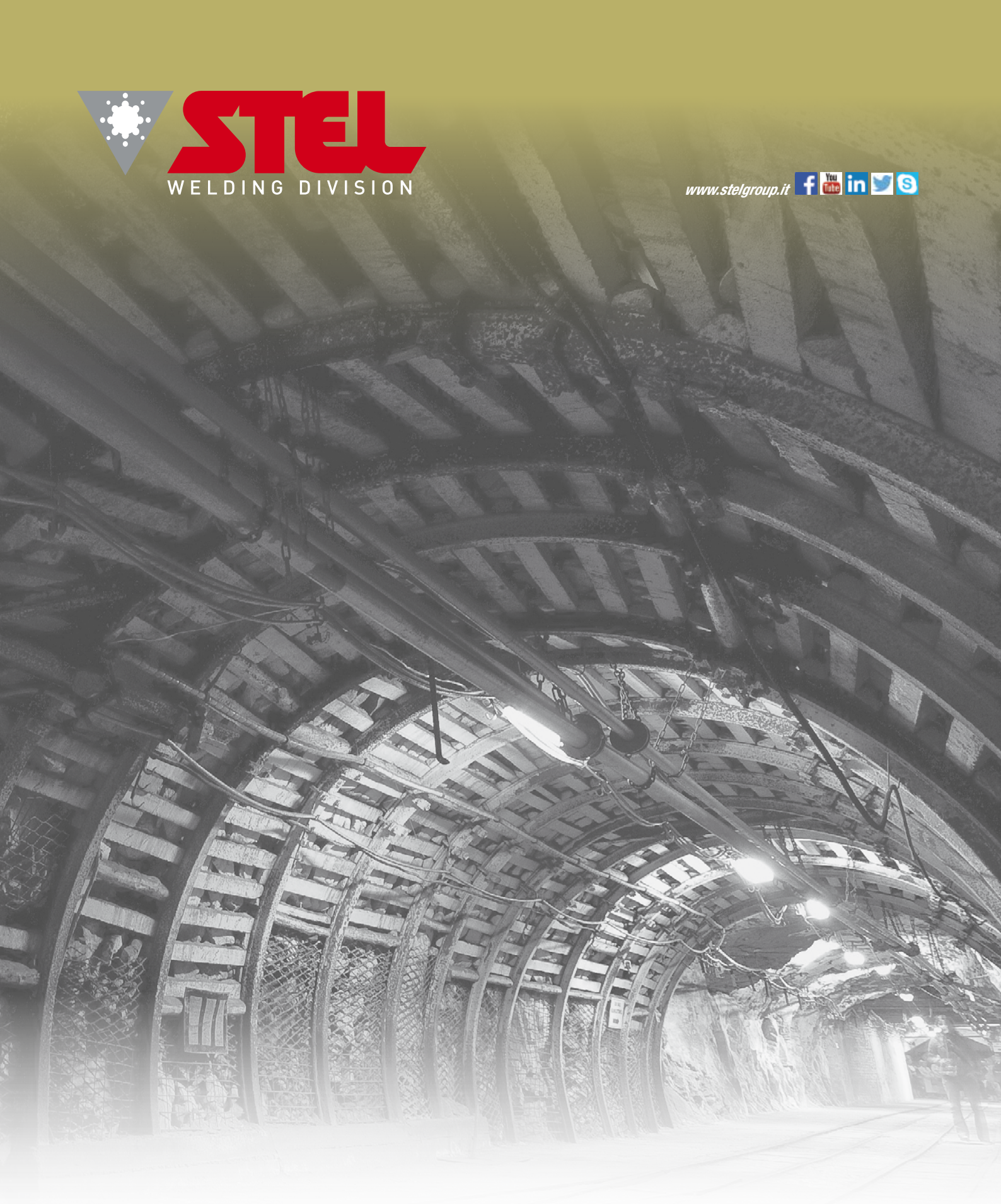
- 14 Ways Mono Cable
- **100m** Extensions Cables
- **40m** Ext. Cables with Alum. Program
- Wire Speed control from remote
- Electrovalve control from remote

Accessories

Code	Description
601312000L	SuitCase Navy 15 CC/CV - 15Kg
601481000L	TOP 504 NAVY 5 - 5Kg (Synergic + Pulse Mode)
601485000L	TOP 504 NAVY 15 - 15Kg (Synergic + Pulse Mode)
601442000L	Interconnecting Cables 50mm ² 30m COAXIAL CABLE
601443000L	Interconnecting Cables 50mm ² 40m COAXIAL CABLE
601422000L	Interconnecting Cables 50mm ² 50m COAXIAL CABLE
601445000L	Interconnecting Cables 70mm ² 40m COAXIAL CABLE
601446000L	Interconnecting Cables 70mm ² 50m COAXIAL CABLE

MINING SOLUTION





INVERTER RANGE

INVERTER PFC RANGE

UNDERGROUND

Inverter Multiprocess

Made in ITALY



**MAX[®] 171 PFC
ATX IP54**



**MAX[®] 503
ATX IP54 / OFF-SHORE**



**THOR 93
ATX IP54**

Technical Data	MAX [®] 171 PFC ATX IP54	MAX [®] 503 ATX IP54	THOR 93 ATX IP54
Main Voltage	90/290 V	400/500 V	400/500 V
Phase	1	3	3
Frequency	50/60 Hz	50/60 Hz	50/60 Hz
Real Current (35%)	11 A / *10 A (with 140 A@25%)	24,3/19,5 A	13,5 A
Real Power (35%)	2,5 KVA	17/13,5 KVA	9 KVA
Power Factor	0,99	0,8	90 %
No Load Voltage	20 V	20-80 V	270 V
Current Range	5-150 A	4-500 A	20-85 A
Welding Current 35% (40°C)	150 A (25%)	500 A	-
Welding Current 60% (40°C)	120 A	440 A	85 A
Welding Current 100% (40°C)	95 A	380 A	50 A

Features	MAX [®] 171 PFC ATX IP54	MAX [®] 503 ATX IP54	THOR 93 ATX IP54
Degree of Protection	IP 54	IP 54	IP 44/54
Length/Width/Height (mm)	400x170x300	610x300x530	460x250x600
Weight	13,5 Kg	54 Kg	50 Kg

The date is measured at an environment temperature of 40 °C

Only Power Source

Code	Description
600216000L	MAX [®] 171 PFC ATX IP54
609420000L	MAX [®] 503 ATX IP54
600414000L	THOR 93 ATX IP54 with Torch SL100

OFF-Shore System 20m Intercon. Cables Air

Code	Description
609420000L	MAX [®] 503 ATX IP54 OFF-SHORE
600022000L	Wire-Feeder TOP 504 OFF-SHORE
600126000L	Extension 5m Wire Feeder Connection
600125000L	Extension 5m Power Source Connection
601071000L	Extension 10m

OPEN-MINES

MAX[®] 403
MAX 403SMAX[®] 603

SKY-MIG 553S

THOR 123

Technical Data	MAX [®] 403	MAX [®] 403S	MAX [®] 603	Sky-Mig 553S	THOR 123
Main Voltage	400 V	230-400-460-500 V	400 V	380/415 V	380/415 V
Phase	3	3	3	3	3
Frequency	50/60 Hz	50/60 Hz	50/60 Hz	50/60 Hz	50/60 Hz
Real Current (35%)	19 A	24,5-12,5 A (16,5 - 400V)	26 A	23,8 A	13,5 A
Real Power (35%)	11,2 KVA	9,7 KVA (400V)	18 KVA	16,5 KVA	9 KVA
Power Factor	0,85	0,98	0,85	0,95	0,9
Efficiency	86 %	87 %	87 %	91 %	87 %
No Load Voltage	70 V	70 V	80 V	18,8-46,2 V	270 V
Current Range	4-400 A	4-400 A	4-550 A	30-500 A	20-100 A
Welding Current 35% (40°C)	400 A	400 A	550 A	500 A (20%)	100 A (20%)
Welding Current 60% (40°C)	350 A	350 A	500 A	440 A	75 A
Welding Current 100% (40°C)	300 A	300 A	400 A	380 A	65 A

Features	MAX [®] 403	MAX [®] 403S	MAX [®] 603	Sky-Mig 553S	THOR 123
Degree of Protection	IP 23	IP 23	IP 23	IP 23	IP 23
Work Temperature	40°C	40°C	40°C	40°C	40°C
Length/Width/Height (mm)	460x250x600	460x250x600	680x300x435	960x380x1370	495x280x720
Weight	32 Kg	40 Kg	50 Kg	155 Kg	46 Kg

The data is measured at an environment temperature of 40 °C

Only Power Source

Code	Description
600243000L	MAX [®] 403
601282000L	MAX [®] 403S
601476000L	MAX [®] 603
600145000L	Sky-Mig 553S H2O Combo
600404000L	THOR 123 with Torch SL100

ACCESSORIES



D I V I S I

Caste



STEL
WELDING DIVISION

www.stelgroup.it     

STEL
ULTRAVISION

Italia

MIG/TIG TORCH
TROLLEY
HELMET

TROLLEY

EVERYWHERE

The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.
4 Wheeled undercarriage with gas cylinder platform delivered as a kit.



TROLLEY MP

- TIG uP 293H AC/DC
- TIG uP 403H AC/DC
- TIG uP 453H AC/DC
- TIG uP 403H DC
- IRON-MIG 303-303P
- IRON-MIG 303S-303S P
- MAX 403 + TOP 504 SM
- MAX 403 + TOP 504 XM
- MAX 403S + TOP 504 SM
- MAX 403S + TOP 504 XM
- MAX 453 + TOP 504 XXM
- MAX 603 + TOP 504 XXM



TROLLEY MPL

- MAX 223C PIPELINE
- TIG dp 181H DC
- TIG uP 273H DC
- TIG dp 221Hpa AC/DC
- MIGGY 171
- IRON-MIG 201
- IRON-MIG 221-221P MULTI
- THOR 41K PFC
- THOR 73



TROLLEY XP

- MAX 403
- MAX 403S
- MAX 453
- MAX 403
- THOR 123



TROLLEY XPL

- IRON-MIG 201
- IRON-MIG 221-221P MULTI

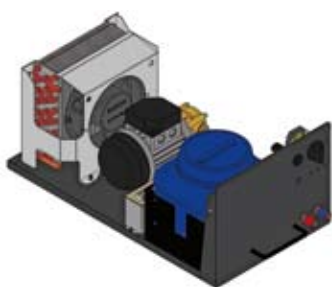
Trolley

Code	Description
600343000L	Trolley MP
600514000L	Trolley MPL
600364000L	Trolley XP
601468000L	Trolley XPL

WATER COOLING SYSTEM

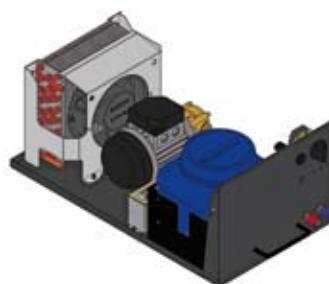
AWC

The STEL water cooler system is a re-circulation cooling system designed for use with water-cooled TIG, MIG torches. Closed-loop design with radiator reduces coolant temperatures and prevents the system from overheating. Closed-loop design also recirculates the coolant through a fan-cooled heat exchanger.



AWC MPS

- TIG uP 273H DC
 - TIG dp 221Hpa AC/DC
 - TIG uP 293H AC/DC
 - TIG uP 403H AC/DC
 - TIG uP 403H DC
 - IRON-MIG 201
 - IRON-MIG 221-221P MULTI
 - MAX 403 + TOP 504 SM
 - MAX 403 + TOP 504 XM
 - MAX 403S + TOP 504 SM
 - MAX 403S + TOP 504 XM
- Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



AWC MPX

- TIG uP 273H DC
 - TIG dp 221Hpa AC/DC
 - TIG uP 453H AC/DC
 - IRON-MIG 303-303P
 - IRON-MIG 303S-303S P
 - MAX 453 + TOP 504 XXM
 - MAX 603 + TOP 504 XXM
- Cooling Efficiency P = 1 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



AWC MP VERTICAL

- SKY-MIG 453K
 - SKY-MIG 453S
 - SKY-MIG 553S
- Cooling Efficiency P = 0,5 KW (1L/min)
Flow Rate with Tig Torch 18 8mt = 1,7 L/min



STELFREEZE TANK

5 Liters Tank for Water Cooling System.
STEL firmly advice the of "STELFREEZE" products in order to improve the life and the performance of components in use. **The use of liquid not approved by STEL will result in the loss of STEL warranty.**

Water Coolers

Code	Description	
600147000L	Water Cooler AWC MP Vertical	(Liquid NOT included)
601471000L	Water Cooler AWC MPS	(Liquid NOT included)
601473000L	Water Cooler AWC MPX	(Liquid NOT included)
601413000L	Water Cooler Plug KIT 230V 1Ph	
601554000L	Water Cooler Plug KIT 400V 3Ph	
600239000L	5L Tank Liquid STELFreeze	

Mig Torch 15/25/36 150/200/300A Air



The torch for Mig / Mag Welding is used when high productivity is required and a suitable flexibility of use. With this technology you can weld steel is austenitic and ferritic alloys of light metals (Al and Mg), copper alloys, nickel alloys and titanium alloys.

Technical Data	TMS 15	TMS 25	TMS 36
V Class	L	L	L
I ₂ max (Co ₂)	150	290	300
I ₂ max (Misc.)	100	260	270
V (Ac or Dc)	DC	DC	DC
∅ Wire	0,6-0,8 mm	0,8-1,2 mm	0,8-1,2 mm
Gas	8-12 l/1'	10-20 l/1'	10-20 l/1'
Cooling	Air	Air	Air

TMS 15

Code	Description
6061000000	Mig Torch TMS 15 3m Air

TMS 25

Code	Description
6051500000	Mig Torch TMS 25 3m Air

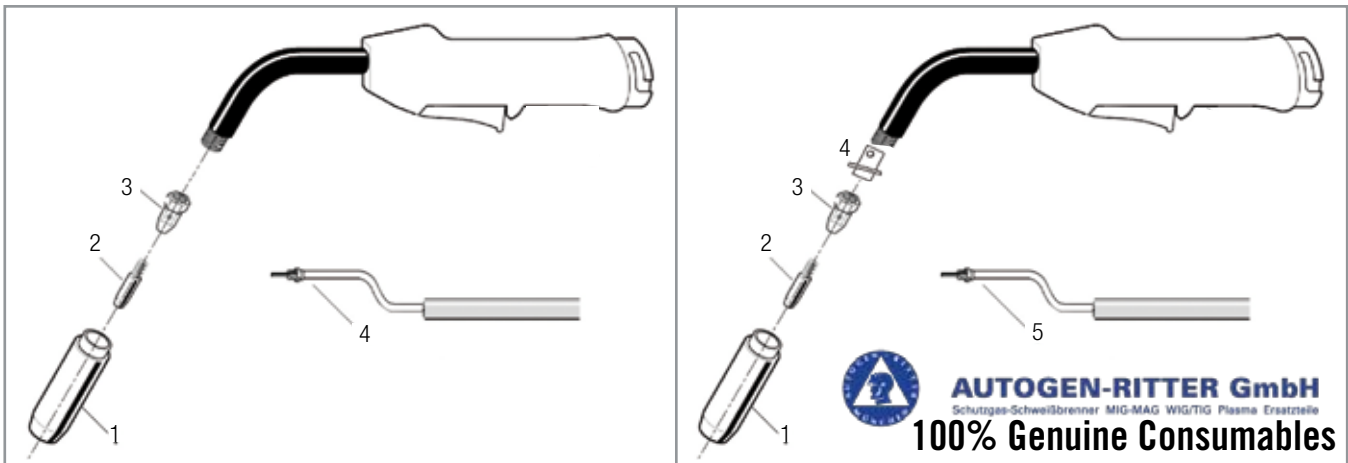
TMS 36

Code	Description
6043500000	Mig Torch TMS 36 4m Air

Exploded View and Spare Parts

Spare Parts and Consumables TMS 15/25

Spare Parts and Consumables TMS 36



Spare Parts and Consumables TMS 15

Code	Description	Position	Pack/Pcs
6341400000	Driving gas Nozzle	1	5
634110000L	Contact Tip \varnothing 0,6Cu	2	25
634120000L	Contact Tip \varnothing 0,8Cu	2	25
631570000L	Contact Tip \varnothing 1,0Cu	2	25
6346500000	Gas diffuser	3	5
6086900000	Liner m.3 \varnothing 0,6-0,8	4	1

Spare Parts and Consumables TMS 25

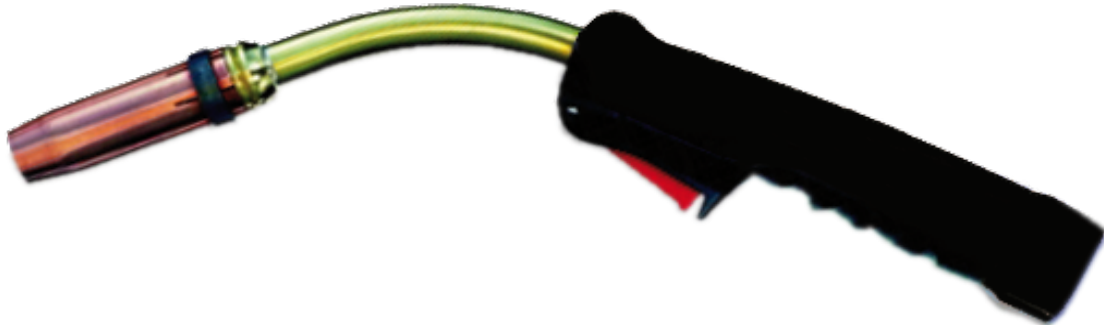
Code	Description	Position	Pack/Pcs
6066400000	Driving gas Nozzle	1	10
631560000L	Contact Tip \varnothing 0,8Cu	2	25
631570000L	Contact Tip \varnothing 1,0Cu	2	25
600491000L	Contact Tip \varnothing 0,8Cu-Cr-Zr (Recommended for Pulse Mode)	2	20
600489000L	Contact Tip \varnothing 1,0Cu-Cr-Zr (Recommended for Pulse Mode)	2	20
6066500000	Gas diffuser	3	1
6004880000	Liner Teflon/Grafite m.3 \varnothing 0,8-1,0	4	1

Spare Parts and Consumables TMS 36

Code	Description	Position	Pack/Pcs
6312400000	Driving gas Nozzle	1	1
631560000L	Contact Tip \varnothing 0,8Cu	2	25
631570000L	Contact Tip \varnothing 1,0Cu	2	25
631640000L	Contact Tip \varnothing 1,2Cu	2	25
6313400000	Tube Holder	3	1
6617200000	Gas diffuser	4	1
6008060000	Liner Teflon/Grafite m.4 \varnothing 0,8-1,0	5	1
6015580000	Liner Teflon/Grafite m.4 \varnothing 1,0-1,2	5	1



MIG Torch 500 500A H2O



The torch for Mig / Mag Welding is used when high productivity is required and a suitable flexibility of use. With this technology you can weld steel is austenitic and ferritic alloys of light metals (Al and Mg), copper alloys, nickel alloys and titanium alloys.

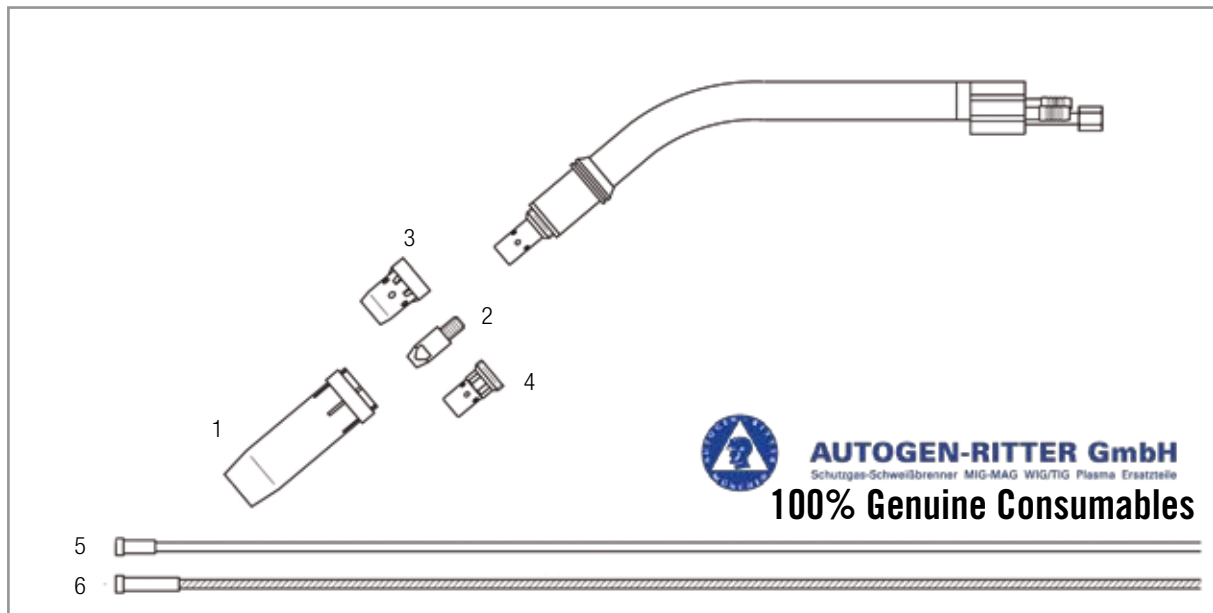
Technical Data TMS 500

V Class	L
I2 max (Co2)	500
I2 max (Misc.)	450
V (Ac or Dc)	DC
ø Wire	1,0-2,4 mm
Gas	10-25 l/1'
Cooling	H2O

TMS 500

Code	Description
6015130000	Mig Torch TMS 500 3m Air
6015140000	Mig Torch TMS 500 4m Air

Exploded View and Spare Parts



Spare Parts and Consumables

Code	Description	Position	Pack/Pcs
6312400000	Driving gas Nozzle	1	1
631880000L	Contact Tip \varnothing 1,0Cu	2	25
631890000L	Contact Tip \varnothing 1,2Cu	2	25
635040000L	Contact Tip \varnothing 1,6Cu	2	25
6016040000	Gas diffuser	3	1
6350200000	Tube Holder	4	1
6008090000	Liner m.4 \varnothing 1,0/1,2	6	1
6008120000	Liner m.4 \varnothing 1,2/1,6	6	1
6008060000	Liner Teflon/Grafite m.4 \varnothing 0,8/1,0 per Alluminio	5	1
6015580000	Liner Teflon/Grafite m.4 \varnothing 1,0/1,2 per Alluminio	5	1

Tig Torch 17V/26V

Technical Data

	TIG 17V	TIG 26V
V Class	L	L
I2 max (60% Argon)	150	250
I2 max (100% Argon)	115	200
V (Ac or Dc)	AC-DC	AC-DC
ø Electrode	1,0-2,4 mm	1,0-3,2 mm
Gas	6-12 l/1'	6-14 l/1'
Cooling	Air	Air

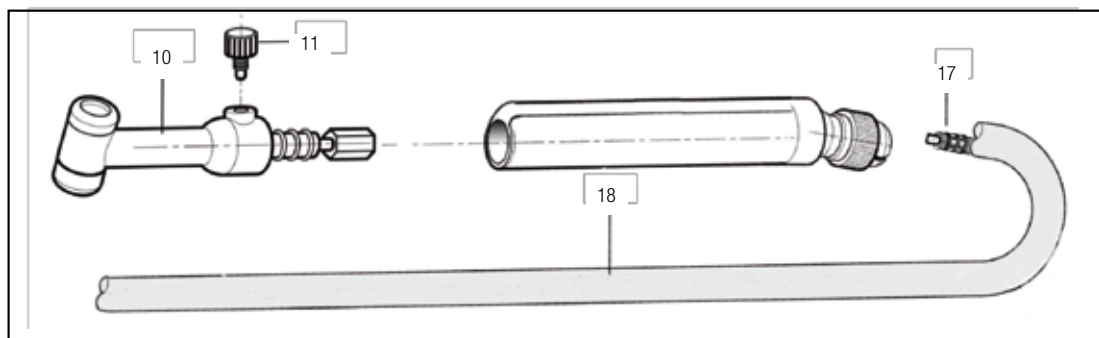


TIG Torch with Valve Air

Code	Description
6428300000	Tig Torch TTS 17V 4m Air Dinse 25 *
6428400000	Tig Torch TTS 17V 8m Air Dinse 25 *
6071400000	Tig Torch TTS 17V 4m Air Dinse 50 *
6009670000	Tig Torch TTS 17V 8m Air Dinse 50 *
642830000L	Tig Torch TTS 17V 4m Air Dinse 25 + CONSUMABLES
642840000L	Tig Torch TTS 17V 8m Air Dinse 25 + CONSUMABLES
607140000L	Tig Torch TTS 17V 4m Air Dinse 50 + CONSUMABLES
600967000L	Tig Torch TTS 17V 8m Air Dinse 50 + CONSUMABLES
6428500000	Tig Torch TTS 26V 4m Air Dinse 50 *
6009710000	Tig Torch TTS 26V 8m Air Dinse 50 *
642850000L	Tig Torch TTS 26V 4m Air Dinse 50 + CONSUMABLES
600971000L	Tig Torch TTS 26V 8m Air Dinse 50 + CONSUMABLES

* Without Consumables and Plug

Exploded View and Main Spare Parts



Spare Parts

Code	Description	Type	Position	Pack/Pcs
6007880000	Torch body with Valve	TIG 17V	10	1
6009440000	Valve with O Ring	TIG 17V	11	1
6007650000	Current Cable mt.4 M.12x1	TIG 17V	17	1
6007670000	Current Cable mt.8 M.12x1	TIG 17V	17	1
6008720000	Canvas protection "TUBIX" (m)	TIG 17V	18	1
6007870000	Torch body with Valve	TIG 26V	10	1
6009450000	Valve with O Ring	TIG 26V	11	1
6007660000	Current Cable mt.4 M.12x1	TIG 26V	17	1
6007680000	Current Cable mt.8 M.12x1	TIG 26V	17	1
6008730000	Canvas protection "TUBIX" (m)	TIG 26V	18	1

Tig Torch 17/26

Technical Data	TIG 17	TIG 26
V Class	L	L
I2 max (60% Argon)	190	250
I2 max (100% Argon)	150	200
V (Ac or Dc)	AC-DC	AC-DC
∅ Electrode	1,0-2,4 mm	1,0-3,2 mm
Gas	6-12 l/1'	6-14 l/1'
Cooling	Air	Air

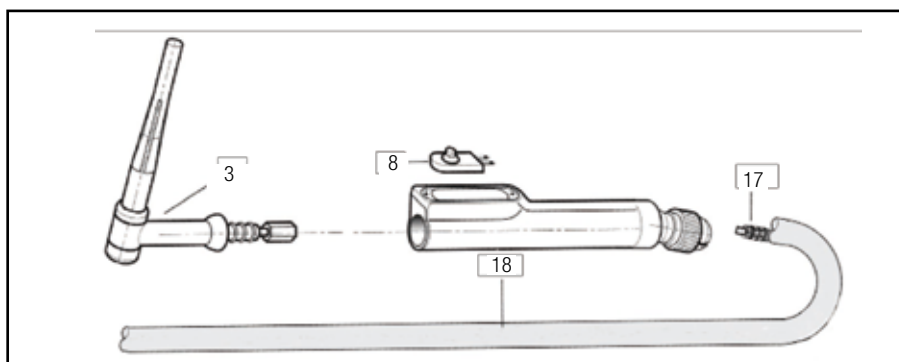


TIG Torch with Button Air

Code	Description
6007130000	Tig Torch TTS 17 4m Air *
6050300000	Tig Torch TTS 17 8m Air *
609910000L	Tig Torch TTS 17 4m Air + 7 Ways Plug
600972000L	Tig Torch TTS 17 8m Air + 7 Ways Plug
6060900000	Tig Torch TTS 17 4m Air + Euro Connector
6050500000	Tig Torch TTS 26 4m Air *
6050800000	Tig Torch TTS 26 8m Air *
609920000L	Tig Torch TTS 26 4m Air + 7 Ways Plug
600973000L	Tig Torch TTS 26 8m Air + 7 Ways Plug
600974000L	Tig Torch TTS 26 4m Air + 3 Ways Plug
600975000L	Tig Torch TTS 26 8m Air + 3 Ways Plug
600706000L	Tig Torch TTS 26 4m Air + 7 Ways Plug C016
600707000L	Tig Torch TTS 26 8m Air + 7 Ways Plug C016

* Without Consumables and Plug

Exploded View and Main Spare Parts



Spare Parts

Code	Description	Type	Position	Pack/Pcs
6007790000	Torch body	TIG 17	3	1
6039900000	Microswitch	TIG 17	8	1
6007650000	Current Cable mt.4 M.12x1	TIG 17	17	1
6007670000	Current Cable mt.8 M.12x1	TIG 17	17	1
6008720000	Canvas protection "TUBIX" (m)	TIG 17	18	1
6007810000	Torch body	TIG 26	3	1
6039900000	Microswitch	TIG 26	8	1
6007660000	Current Cable mt.4 M.12x1	TIG 26	17	1
6007680000	Current Cable mt.8 M.12x1	TIG 26	17	1
6008730000	Canvas protection "TUBIX" (m)	TIG 26	18	1

Tig Torch 18 350A H2O

Technical Data

TIG 18

V Class	L
I2 max (100% Argon)	350
V (Ac or Dc)	AC-DC
ø Electrode	1,0-4,0 mm
Gas	6-20 l/1'
Cooling	H2O
T°C (H2O)	30° C
Q Min (H2O)	1,5 (4m) -1,2 (8m)
P Min (H2O)	3 bar
P Max (H2O)	11 bar

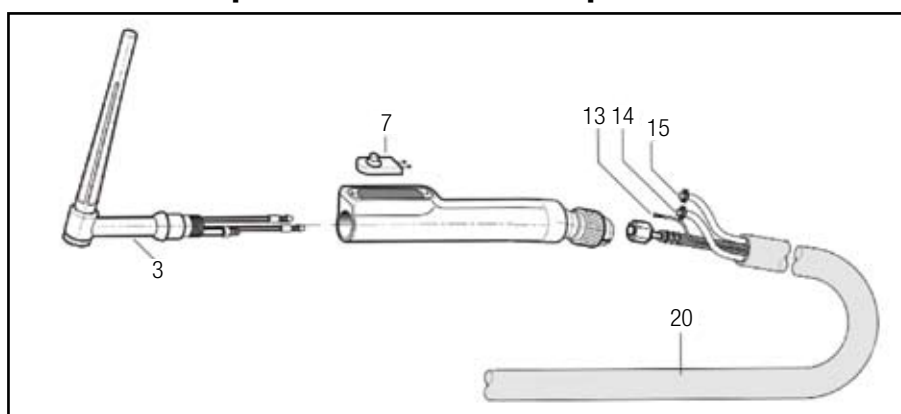


TIG Torch with Button Air

Code	Description
6050600000	Tig Torch TTS 18 4m H2O *
6050700000	Tig Torch TTS 18 8m H2O *
605060000L	Tig Torch TTS 18 4m H2O + 3 Ways Plug
600976000L	Tig Torch TTS 18 8m H2O + 3 Ways Plug
601295000L	Tig Torch TTS 18 4m H2O + 2 Ways Plug
601296000L	Tig Torch TTS 18 8m H2O + 2 Ways Plug

* Without Consumables and Plug

Exploded View and Main Spare Parts



Spare Parts

Code	Description	Position	Pack/Pcs
6007780000	Torch body	3	1
6039900000	Microswitch	7	1
6007620000	Comand Cable (m)	13	1
6009050000	Gas Hose (m)	14	1
6009030000	Water Hose (m)	15	1
6008730000	Canvas protection "TUBIX" (m)	20	1

Tig Torch 20 250A H2O

Technical Data

TIG 20

V Class	L
I2 max (100% Argon)	250
V (Ac or Dc)	AC-DC
ø Electrode	1,0-3,2 mm
Gas	6-15 l/1'
Cooling	H2O
T°C (H2O)	30° C
Q Min (H2O)	1,6 (4m) -1,2 (8m)
P Min (H2O)	3 bar
P Max (H2O)	10 bar

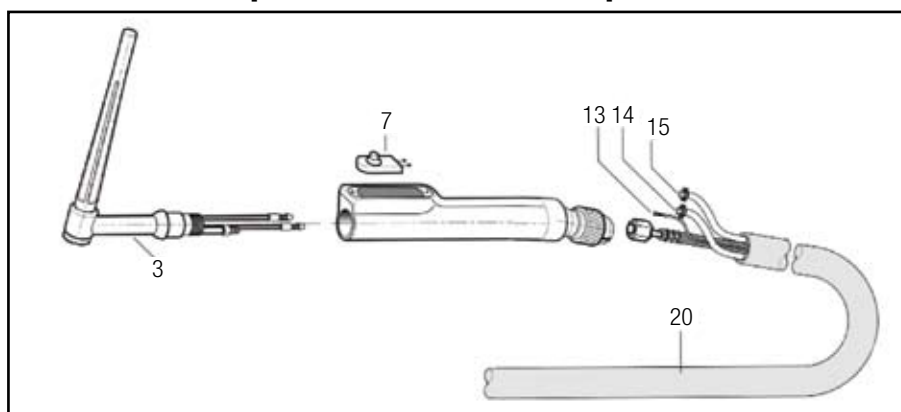


TIG Torch with Button Air

Code	Description
6048500000	Tig Torch TTS 20 4m H2O *
6067400000	Tig Torch TTS 20 8m H2O *
600704000L	Tig Torch TTS 20 4m H2O + 3 Ways Plug
600705000L	Tig Torch TTS 20 8m H2O + 3 Ways Plug
600708000L	Tig Torch TTS 20 4m H2O + 7 Ways Plug C016
600709000L	Tig Torch TTS 20 8m H2O + 7 Ways Plug C016
601292000L	Tig Torch TTS 20 4m H2O + 2 Ways Plug
601293000L	Tig Torch TTS 20 8m H2O + 2 Ways Plug

* Without Consumables and Plug

Exploded View and Main Spare Parts

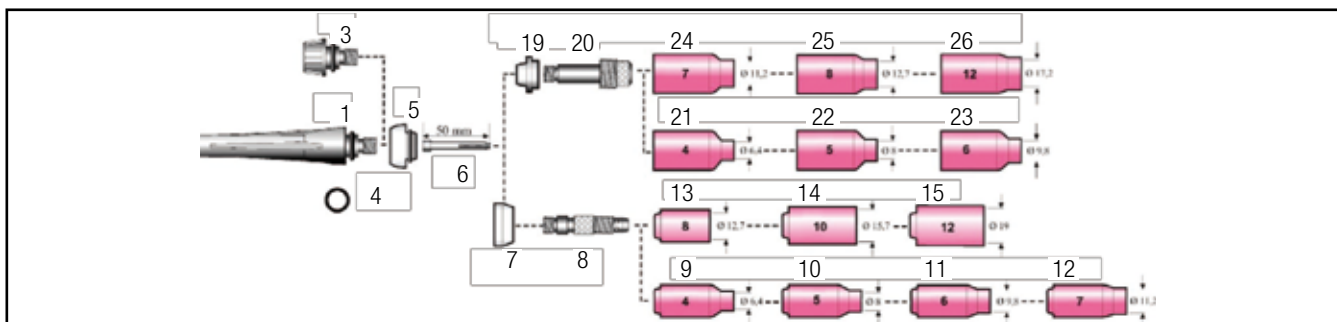


Spare Parts

Code	Description	Position	Pack/Pcs
6007770000	Torch body	3	1
6039900000	Microswitch	7	1
6007620000	Comand Cable (m)	13	1
6009040000	Gas Hose (m)	14	1
6009020000	Water Hose (m)	15	1
6008720000	Canvas protection "TUBIX" (m)	20	1

Consumables TIG

17V-26V-17-26-18

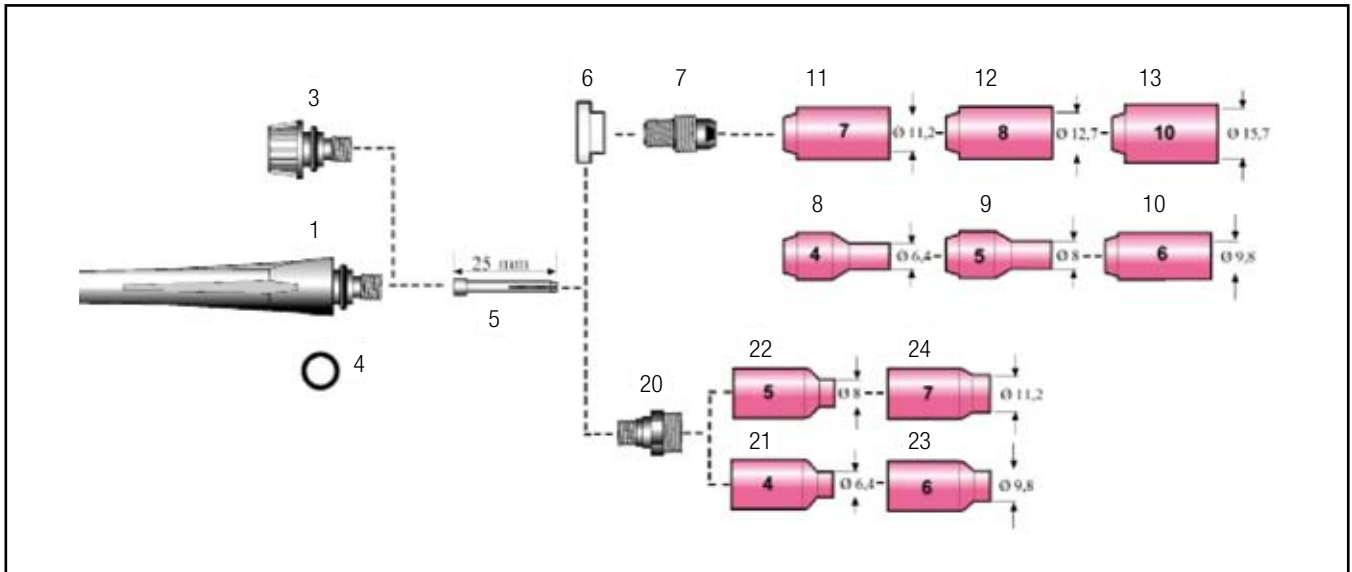


Consumables

Code	Description	Position	Pack/Pcs
600761000L	Back Cap Long 57Y02	1	5
600758000L	Back Cap Short 57Y04	3	5
600752000L	O Ring OR 2037	4	10
600814000L	Teflon Cup Gasket	5	5
600833000L	Collect Ø.1,0 10N22	6	10
600835000L	Collect Ø.1,6 10N23	6	10
600837000L	Collect Ø.2,0	6	10
600839000L	Collect Ø.2,4 10N24	6	10
600842000L	Collect Ø.3,2 10N25	6	10
600844000L	Collect Ø.4,0 54N20	6	10
600817000L	Teflon Insulator 18CG	7	5
600954000L	Collect body Ø.1,0 10N30	8	10
600955000L	Collect body Ø.1,6 10N31	8	10
600956000L	Collect body Ø.2,0	8	10
600957000L	Collect body Ø.2,4 10N32	8	10
600958000L	Collect body Ø.3,2 10N28	8	10
600959000L	Collect body Ø.4,0 406488	8	10
600911000L	Ceramic Nozzle GR.4 10N50	9	10
600912000L	Ceramic Nozzle GR.5 10N49	10	10
600913000L	Ceramic Nozzle GR.6 10N48	11	10
600914000L	Ceramic Nozzle GR.7 10N47	12	10
600915000L	Ceramic Nozzle GR.8 10N46	13	10
600908000L	Ceramic Nozzle GR.10 10N45	14	10
600909000L	Ceramic Nozzle GR.12 10N44	15	10
600815000L	Gas Lens Teflon Insulator	19	10
600845000L	Gas Lens Collect body Ø.1,0 45V24	20	10
600847000L	Gas Lens Collect body Ø.1,6 45V25	20	10
600849000L	Gas Lens Collect body Ø.2,4 45V26	20	10
600852000L	Gas Lens Collect body Ø.3,2 45V27	20	10
600854000L	Gas Lens Collect body Ø.4,0 45V28	20	10
600921000L	Ceramic Nozzle GR.4 54N18 Gas Lens	21	10
600924000L	Ceramic Nozzle GR.5 54N17 Gas Lens	22	10
600927000L	Ceramic Nozzle GR.6 54N16 Gas Lens	23	10
600931000L	Ceramic Nozzle GR.7 54N15 Gas Lens	24	10
600933000L	Ceramic Nozzle GR.8 54N14 Gas Lens	25	10
600917000L	Ceramic Nozzle GR.12 54N19 Gas Lens	26	10
600996000L	Ceriated Tungsten Electrode Ø 1,0 (Grey)	-	10
600997000L	Ceriated Tungsten Electrode Ø 1,6 (Grey)	-	10
600998000L	Ceriated Tungsten Electrode Ø 2,4 (Grey)	-	10
600999000L	Ceriated Tungsten Electrode Ø 3,2 (Grey)	-	10

Consumables TIG

9-20



Consumables

Code	Description	Position	Pack/Pcs
600759000L	Back Cap Long 41V24	1	5
600757000L	Back Cap Short 41V33	3	5
600563000L	O Ring OR 2018	4	10
600834000L	Collect Ø.1,0 13N21	5	10
600836000L	Collect Ø.1,6 13N22	5	10
600838000L	Collect Ø.2,0	5	10
600564000L	Collect Ø.2,4 13N23	5	10
600575000L	Collect Ø.3,2 13N24	5	10
600813000L	Teflon Insulator 598882	6	5
600855000L	Collect body Ø 1,0 13N26	7	10
600856000L	Collect body Ø 1,6 13N27	7	10
600951000L	Collect body Ø 2,0	7	10
600566000L	Collect body Ø 2,4 13N28	7	10
600953000L	Collect body Ø 3,2 13N29	7	10
600576000L	Ceramic Nozzle GR.4 13N08	8	10
600567000L	Ceramic Nozzle GR.5 13N09	9	10
600925000L	Ceramic Nozzle GR.6 13N10	10	10
600928000L	Ceramic Nozzle GR.7 13N11	11	10
600932000L	Ceramic Nozzle GR.8 13N12	12	10
600846000L	Gas Lens Collect body Ø.1,0 45V42	20	10
600848000L	Gas Lens Collect body Ø.1,6 45V43	20	10
600851000L	Gas Lens Collect body Ø.2,4 45V44	20	10
600853000L	Gas Lens Collect body Ø.3,2 45V45	20	10
600919000L	Ceramic Nozzle GR.4 53N58 Gas Lens	21	10
600923000L	Ceramic Nozzle GR.5 53N59 Gas Lens	22	10
600926000L	Ceramic Nozzle GR.6 53N60 Gas Lens	23	10
600929000L	Ceramic Nozzle GR.7 53N61 Gas Lens	24	10
600996000L	Ceriated Tungsten Electrode Ø 1,0 (Grey)	-	10
600997000L	Ceriated Tungsten Electrode Ø 1,6 (Grey)	-	10
600998000L	Ceriated Tungsten Electrode Ø 2,4 (Grey)	-	10
600999000L	Ceriated Tungsten Electrode Ø 3,2 (Grey)	-	10

HELMET ASPIRE

Unlimited VISION

Advantages

- Light
- Guarantee protection against welding arc
- Hands free working
- Perfect vision of the welding arc
- Better working on spot welding
- Maximum eyes protection

SENSITIVITY

The sensitivity set-up allows the operator to adjust the screen depending on the welding arc intensity:

- + Sensitivity: ideal for low amps welding.
- Sensitivity: ideal in presence of other light source.

DELAY

Some works need a faster or slower light delay:

- + Slower: ideal for MIG/MAG pulsed process
- Faster: ideal for Spot Welding or fast welding starts.



Features

Ideal for professional Welders MIG/MAG, MMA ,TIG thanks to the 2 front sensors which allow a perfect arc welding sensing.Possibility to set the DELAY, SENSITIVITY) and DIN of protection (SHADE 4/9-13). Solar charge.

Features:

Variable Shade:	External Potentiometer da 4/9-13
Power On/Off:	Automatic
Sentivity Control:	From Low to High with Potentiometer on the visor
Power Supply:	Solar Cell
Switching Time:	0,5ms
Dark to Light Time:	With Potentiometer on the visor
Low Amperage TIG:	5 amps
View Dimensions:	97x42mm

Welding Helmet

Code	Description
6014910000	Helmet ASPIRE JACKSON

STEL CLOTHES



STEL Clothing

Code	Description
6013680000	Polo STEL
6013690000	Felpa STEL

Available in size S / M / XL / XXL (Please write on the order your size)

GENERAL SALES CONDITIONS

1. ORDER CONFIRMATIONS

Orders given to agents binding only Customer are subject to approval of head office who has the right to refuse them within 15 days from receipt. Orders are in any case considered subject to terms herein indicated even if order confirmation is missing.

Any particular purchase conditions departing from these general terms must be explicitly indicated on order and then approved by head office with order confirmation.

2. PARTIAL OR TOTAL CANCELLATION OF ORDER

Any order change or cancellation is valid only if agreed by both parties: the request must be notified within and no later than 3 (three) days from order's receipt. However it is not possible to cancel an order concerning customised goods or expressly prepared in advance.

3. PRICE TERMS

For any increase of raw materials or labour costs, either officially authorised and due to causes depending on accidental local conditions head office has the right to review prices prior justified notice during processing of order.

Prices are quoted ex-works our factory, standard packing included (eventual personalised packing is not included).

4. PAYMENT

Payments must be effected only to head office of our company in Vicenza which is considered for all legal purposes the place of contract execution.

Customer will not have the right to modify one-sided payment conditions. In case of non-payment or delay our company will have the right to:

- request for immediate payment of all credits;
- deliver outstanding orders against advanced payment or suitable bank guaranty;
- withdraw from supply.

The lack of payment even if concerning one instalment or total invoice only authorises our company to back out of contract.

In case of delay payment the supplier will have the right to request for interests on arrears at the current Prime Rate applied by the main Italian Credit Institutes including collection expenses, bank rights and legal expenses.

5. DELIVERY (EXW)

Goods are delivered at buyer's risk and transport expenses are at his charge.

Carriage is ex-works our factory Via Del Progresso 59 36020 castegnero (VI) Italy (Incoterms 2000). The risk of lost or damage will be on buyer's charge even when the transport is organized by STEL and charged on the invoice. After 8 days from foreseen date of collection our company can arrange for delivery at any moment and without any prior notice debiting to buyer all relevant expenses.

6. OWNERSHIP OF GOODS

The ownership of goods supplied or at buyer's stock remains of STEL company until full payment of material delivered is made. In case of non-payment STEL has the right to request for the return of goods.

According to conditional sale invoice/s is/are considered unpaid after 20 (twenty) days from expiry date.

7. CLAIMS AND RETURNS OF GOODS

Claims must be effected on goods receipt and according to terms by law. Eventual damages caused by transport must be charged to forwarding agent and notified to supplier in copy within and no later than 8 (eight) days from delivery. Eventual damages do not give the right to stop payments.

Returns of goods are accepted only upon authorisation. Credit notes will be issued with a 20% depreciation of value to cover accounts, control and storage costs.

Goods returned must be of current production and new.

8. DELIVERY TIME

Delivery time is to be understood not peremptory therefore the buyer can not claim for damages or cancellation, even if partial, of contract in case of shipment delay.

9. SPARE PARTS AND SERVICE

The repair service and spare parts availability will be maintained till 7 years after product discontinuity.

10. CONDITIONS OF WARRANTY

***36 MONTHS:** From the date of D.D.T (Delivery Note) to the End User for Power Source with 3 Warranty Years Sticker.

24 MONTHS: From the date of D.D.T (Delivery Note) to the End User for Power Source 1 Phase

12 MONTHS: From the date of D.D.T (Delivery Note) to the End User for Power Source 3 Phase

12 MONTHS: From the date of D.D.T (Delivery Note) to the End User for Water cooler System, Water Pump and Wire Feeder.

The warranty will be valid only if the Power Sources will come with the **invoice copy with serial number**.

* Only if you purchased the 3&5 Warranty Extension Pack. Warranty Terms are available on www.stelgroup.it/Documents/Vario/3years_warranty.pdf

In case the above is not going to happen STEL will have the right to adopt the following procedure:

26 MONTHS: From the date of internal testing (noticeable from the serial number) for 1 Phase Power Source.

18 MONTHS: From the date of internal testing (noticeable from the serial number) for 3 Phase Power Source.

The STEL warranty is considered void for products that exceed 36 months storage.

11. WARRANTY NOT ALLOWED

Warranty doesn't cover the following items:

- Input cable due to wear and carelessness.
- Parts subject to normal wear (tips – nozzles – electrodes – tubes – diffusers – contact tips – liners)
- Tig torches – Mig torches – Plasma torches
- Earth Clamps and cables – Electrode Holders and cables – Welding Masks
- Single stage regulators

Warranty is not allowed under the following circumstances:

- Failures due to an uncorrect use or carelessness;
- Failures caused by transport;
- Wrong connection to power supply network;
- Power supply with different voltage than that indicated on the machine and on user manual;
- Repairs or breakage and convenient checks;
- Remove or breakage of label or stamp proving production date.
- in case of lack of payment even if concerning one instalment or total invoice

Warranty never extends to the duty of compensation for any kind of damages eventually suffered by people or by things.

Going transport expenses are at buyer's charge.

12. SHIPPING MATERIAL ON WARRANTY

Always contact your dealer or authorized service center for a repair under warranty.

The shipping cost to STEL is at customer charge.

The return shipping cost is at STEL charge (if warranty confirmed).

Where possible to replace the spare part under warranty at our authorized service center or dealer, the shipping cost of parts will be at STEL charge.

It's required the return of the faulty spare part at our office with shipping cost at the customer charge.

If the piece will be tampered or there were serious reasons to make void the warranty, STEL will charged the full amount of the two shipping costs.

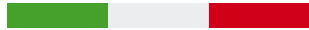
Cost of labor or intervention are not covered.

13. JURISDICTION

In case of dispute place of jurisdiction is Vicenza also departing from any other contrary agreement in conformity with art. 28 of the Italian Part No of Civil Procedure.

14. ENFORCEABLE LAW

The enforceable law is the Italian with express exclusion of Vienna Convention.



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