

ML 150 - MV 550 FKS - MIG MANAGER® MIG/MAG ERGO WELDING HOSES



Operational comfort and ergonomically correct working environment

Torch handle designed to fit perfectly into your hand

Tested by experienced welders

Central connection is a standard feature on all types

DIALOG torch for remote control of all Migatronik machines

MIG Manager® with advanced remote control of FLEX and Sigma machines

New digital operational comfort and ergonomics in the torch handle



Central connection with new ball-and-socket joint for flexible connection of the machine

With Migatronik's new brochure on MIG/MAG welding hoses at hand you will easily find the welding hose that suits your welding requirements. The following pages will give you an overall impression of the standard types in Migatronik's wide range of ergonomic welding hoses. In addition to the standard types, we develop and design custom-built special solutions.

Digital revolution

MIG Manager® is the name of Migatronik's digital MIG welding hose which communicates directly with the most advanced FLEX and Sigma welding machines. The MIG Manager® torch handle allows the welder adjustment of all vital parameters and direct output in the green display. The MIG Manager® covers a special requirement when it comes to welding operations where the welder does not have eye contact with the welding machine.

Advanced cooling system

FKS is the essence of Migatronik's watercooled welding hoses with the revolutionary double cooling-chamber

ensuring efficient cooling of the torch at the gas nozzle. Large quantities of radiant heat are absorbed from the weld pool and transported to the cooling unit. Migatronik FKS welding hoses are also available with Dialog adjustment of the welding current or with the digital MIG Manager® concept. The FKS has been developed specifically for heavy duty pulse welding and spray transfer welding.

Technology at both ends

Migatronik always endeavours to focus on simplicity and user-friendliness; elements that result in satisfaction and, indirectly, better economy. Ball-and-socket joint

relief at both ends of the hose is an example of innovative ergonomics as well as use of many combined materials in contact tips, gas diffusers, wire liners etc., all of which contributes to reliability and longer life of the hoses. Migatronik's complete range of watercooled or aircooled welding hoses offers a variety of thoroughly tested high-quality products.

MIGATRONIC ABBREVIATIONS

ML
Migatronik aircooled torch

MV
Migatronik watercooled torch

300
Model size

F
Remote control/
Dialog

KD
Separate tip
adaptor

T
Spring pins in
central connection

HD-S
Heavy Duty with
10 x 40 mm nozzle

FKS
Double cooling
chamber with extra
cooling of gas
nozzle



The advanced ergonomic MIG Manager® allows the welder access to vital functions and outputs at the torch handle.

Model ML 150

ML 150

3 m hose
4 m hose

80195150
80195151

ML 150 F

3 m hose
4 m hose

80194150
80194151



Model ML 250

ML 250

3 m hose
4 m hose

80195250
80195251

ML 250 F

3 m hose
4 m hose

80194250
80194251



ML 150/250 is always supplied with separate tip adaptor (KD) and central connection

Gas nozzle:			
	80140023* 53.5 mm	80140500 55 mm	80140022 60 mm
Contact tip:			
	Ø 0.6 M6 80130201	Ø 1.0 M6 80130203	
	Ø 0.8 M6 80130202*	Ø 1.2 M6 80130204	
Tip adaptor:			
Standard 34 mm	80110020*		
Retaining clamp:			
	80100021		
Swan neck:			
Curved 80151202*	Straight 80151201		
Steel liner:			
White for 0.6-0.8 wire	80160520		
Blue for 0.8-1.0 wire	80160521*		
4.4 m (also used for 3 m hoses)			
* = Standard on delivery			

Gas nozzle:		
	80140601* 57 mm	80140600 57 mm
Contact tip:		
	Ø 0.6 M6 80130201	Ø 1.2 M6 80130204
	Ø 0.8 M6 80130202*	Ø 1.6 M6 80131204
	Ø 1.0 M6 80130203	
Tip adaptor:		
Long 37 mm	80110601	Short 35 mm 80110602*
Retaining clamp:		
	80100600	
Swan neck:		
Curved 80151302*	Straight 80151301	
Steel liner:		
White for 0.6-0.8 wire	80160520	
Blue for 0.8-1.0 wire	80160521*	
Red for 1.2-1.6 wire	80160522	
4.4 m (also used for 3 m hoses)		
* = Standard on delivery		

Model ML 300

ML 300		ML 300 F	
3 m hose	80195300	3 m hose	80194300
4 m hose	80195301	4 m hose	80194301



Model ML 360

ML 360		ML 360 F	
3 m hose	80195360	3 m hose	80194360
4 m hose	80195361	4 m hose	80194361

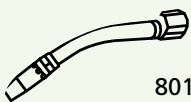
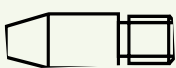
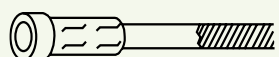


Model ML 360 MIG Manager®

3 m hose	80194362
4 m hose	80194363



ML 300/360 is always supplied with separate tip adaptor (KD) and central connection

Gas nozzle:			Tip adaptor:		
Standard:	80240303* 76 mm	80240300 76 mm	80240304 76 mm	M8-6 Long 25 mm	80112636*
Long:	80140700 84 mm	80140701 84 mm		M8-6 Long 32 mm	80112637
Swan neck:				M8-6 Short 22 mm	80110026
ML 300 Curved	80151502*			M8-6 Long 25 mm	80112640
ML 300 Straight	80151501			M8-8 Short 23 mm	80110300
ML 360 Curved	80151602*			M8-8 Long 28 mm	80112638
ML 360 Straight	80151601			M8-8 Long 32 mm	80112639
ML 360 Straight MIG Manager	80251607*			Gas diffuser:	
Contact tip:				White Short std.	80120301
Ø 0.6 M6	80130201	Ø 1.0 M6	80130203*	White Long 32,5 mm	80120306
Ø 0.8 M6	80130202	Ø 1.2 M6	80130204	Steel liner:	
				White for 0.6-0.8 wire	80160520
				Blue for 0.8-1.0 wire	80160521*
				Red for 1.2-1.6 wire	80160522
				4.4 m (also used for 3 m hoses)	

* = Standard on delivery

Model ML 240

Air-cooled

ML 240		ML 240 F	
3 m hose	80195240	3 m hose	80194240
4 m hose	80195241	4 m hose	80194241



Model ML 240
MIG Manager® Air-cooled

3 m hose	80194242
4 m hose	80194243



Model MV 240

Water-cooled

ML 240		ML 250 F	
3 m hose	80295240	3 m hose	80294240
4 m hose	80295241	4 m hose	80294241


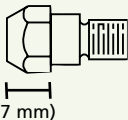
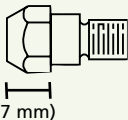
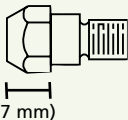
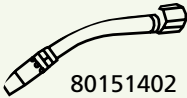




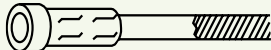


Model MV 240
MIG Manager® Water-cooled

3 m hose	80294245
4 m hose	80294246



ML/MV 240 is always supplied with separate tip adaptor (KD) and central connection

<p>Gas nozzle:</p>  <table border="0"> <tr> <td>80140610*</td> <td>80140611</td> </tr> <tr> <td>64 mm</td> <td>64 mm</td> </tr> </table>	80140610*	80140611	64 mm	64 mm	<p>Tip adaptor:</p> <table border="0"> <tr> <td>Ms</td> <td>83077149* (5 mm)</td> <td rowspan="3">  <p>26 mm (7 mm)</p> </td> </tr> <tr> <td>CuCrZr</td> <td>80110604 (5 mm)</td> </tr> <tr> <td>Ms</td> <td>80110603 (7 mm)</td> </tr> </table>	Ms	83077149* (5 mm)	 <p>26 mm (7 mm)</p>	CuCrZr	80110604 (5 mm)	Ms	80110603 (7 mm)								
80140610*	80140611																			
64 mm	64 mm																			
Ms	83077149* (5 mm)	 <p>26 mm (7 mm)</p>																		
CuCrZr	80110604 (5 mm)																			
Ms	80110603 (7 mm)																			
<p>Swan neck:</p>  <table border="0"> <tr> <td>ML 240</td> <td></td> <td>80151402</td> </tr> <tr> <td>ML 240</td> <td>MIG Manager</td> <td>80151403</td> </tr> <tr> <td>MV 240</td> <td></td> <td>80251101</td> </tr> <tr> <td>MV 240</td> <td>MIG Manager</td> <td>80251107</td> </tr> </table>	ML 240		80151402	ML 240	MIG Manager	80151403	MV 240		80251101	MV 240	MIG Manager	80251107	<p>Gas diffuser:</p> <table border="0"> <tr> <td>Black</td> <td>83077480*</td> <td rowspan="3">  </td> </tr> <tr> <td>White</td> <td>83077481</td> </tr> <tr> <td>Ceramic</td> <td>80220311</td> </tr> </table>	Black	83077480*		White	83077481	Ceramic	80220311
ML 240		80151402																		
ML 240	MIG Manager	80151403																		
MV 240		80251101																		
MV 240	MIG Manager	80251107																		
Black	83077480*																			
White	83077481																			
Ceramic	80220311																			
<p>Contact tip:</p>  <table border="0"> <tr> <td>Ø 0.6 M6</td> <td>80130201</td> <td>Ø 1.0 M6</td> <td>80130203* MV</td> </tr> <tr> <td>Ø 0.8 M6</td> <td>80130202* ML</td> <td>Ø 1.2 M6</td> <td>80130204</td> </tr> </table>	Ø 0.6 M6	80130201	Ø 1.0 M6	80130203* MV	Ø 0.8 M6	80130202* ML	Ø 1.2 M6	80130204	<p>Steel liner:</p>  <table border="0"> <tr> <td>White</td> <td>for 0.6-0.8 wire</td> <td>80160520</td> </tr> <tr> <td>Blue</td> <td>for 0.8-1.0 wire</td> <td>80160521*</td> </tr> <tr> <td>Red</td> <td>for 1.2-1.6 wire</td> <td>80160522</td> </tr> </table> <p>4.4 m (also used for 3 m hoses)</p>	White	for 0.6-0.8 wire	80160520	Blue	for 0.8-1.0 wire	80160521*	Red	for 1.2-1.6 wire	80160522		
Ø 0.6 M6	80130201	Ø 1.0 M6	80130203* MV																	
Ø 0.8 M6	80130202* ML	Ø 1.2 M6	80130204																	
White	for 0.6-0.8 wire	80160520																		
Blue	for 0.8-1.0 wire	80160521*																		
Red	for 1.2-1.6 wire	80160522																		

* = Standard on delivery

Double watercooling with extra cooling of gas nozzle

Model MV 400 FKS

MV 400 FKS

3 m hose 80295602
4 m hose 80295603

MV 400 FKS F

3 m hose 80294602
4 m hose 80294603

Model MV 500 FKS

MV 500 FKS

3 m hose 80295700
4 m hose 80295701

MV 500 FKS F

3 m hose 80294700
4 m hose 80294701

Model MV 400 FKS MIG Manager®

3 m hose 80294660
4 m hose 80294661

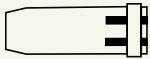
Model MV 500 FKS MIG Manager®

3 m hose 80294702
4 m hose 80294703

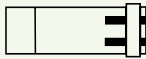
MV 400/500 FKS is always supplied

with separate tip adaptor

Gas nozzle:



80240307*
62 mm



80240308 Use 30-38 mm contact tip
62 mm

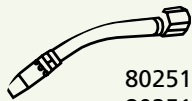
80240317
67 mm

80240318 Use 41 mm contact tip
67 mm

Swan neck:

MV 400 FKS

MV 400 FKS MIG Manager



80251500

80251501

Contact tip:

Ø 0.8 M8 80231101
Ø 1.0 M8 80231102
Ø 1.2 M8 80231103*



Ø 1.4 M8 80231106
Ø 1.6 M8 80231104

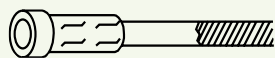
Tip adaptor:



80110408* 24 mm

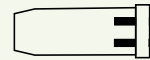
Steel liner:

White for 0.6-0.8 wire 80160520
Blue for 0.8-1.0 wire 80160521
Red for 1.2-1.6 wire 80160522*
4.4 m (also used for 3 m hoses)

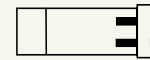


* = Standard on delivery

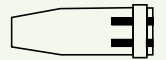
Gas nozzle:



Standard: 80240303*
76 mm



80240300
76 mm



80240304
76 mm

Long:

80140700
84 mm

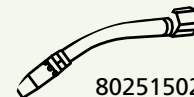
80140701
84 mm

Swan neck:

MV 500 FKS

MV 500 FKS MIG Manager

MV 500 FKS Flex



80251502

80251503

80251510

Contact tip:

Ø 0.8 M8 80231101
Ø 1.0 M8 80231102



Ø 1.2 M8 80231103*
Ø 1.6 M8 80231104

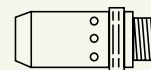
Gas diffuser:

White 80220312*



Ceramic 80220313

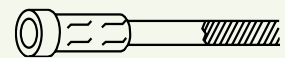
Tip adaptor:



80110410* CuCrZr 38 mm

Steel liner:

White for 0.6-0.8 wire 80160520
Blue for 0.8-1.0 wire 80160521
Red for 1.2-1.6 wire 80160522*
4.4 m (also used for 3 m hoses)



* = Standard on delivery

Model MV 450

MV 450		MV 450 F	
3 m hose	80295452	3 m hose	80294452
4 m hose	80295453	4 m hose	80294453
MV 450 (KD)		MV 450 F (KD)	
3 m hose	80295450	3 m hose	80294450
4 m hose	80295451	4 m hose	80294451

Model MV 550

MV 550		MV 550 F	
3 m hose	80295552	3 m hose	80294552
4 m hose	80295553	4 m hose	80294553
MV 550 (KD)		MV 550 F (KD)	
3 m hose	80295550	3 m hose	80294550
4 m hose	80295551	4 m hose	80294551



MV 450/550 available with integrated or separate tip adaptor (KD)

Gas nozzle:		Swan neck	
Standard:	80240303* 76 mm	80240300 76 mm	MV 450 80251204
Long:	80140700 84 mm	80140701 84 mm	MV 450 KD 80251202
		80240304 76 mm	MV 550 80251304
			MV 550 KD 80251302
Contact tip:		Steel liner:	
Ø 0.8 M8 80231101	Ø 1.2 M8 80231103*	White for 0.6-0.8 wire 80160520	
Ø 1.0 M8 80231102	Ø 1.6 M8 80231104	Blue for 0.8-1.0 wire 80160521	
		Red for 1.2-1.6 wire 80160522*	
		Yellow for > 2.0 wire 80160523	
Tip adaptor:		4.4 m (also used for 3 m hoses)	
Short 25 mm M8 Ms 80110401			
Long 29 mm M8 Ms 80110402*			
Short 25 mm M6 Ms 80110403			
Short 25 mm M8 CuCrZr 80110406			
Long 29 mm M8 CuCrZr 80110409			
Gas diffuser:		Insulating disc:	
White 80220309*			80220303
Black 80220306			
Ceramic 80220310			

* = Standard on delivery

CHOICE OF CONTACT TIP

Migatronic ML/MV torches are equipped as standard with E-Cu (copper) contact tips in the most frequently used dimension as well as gas nozzles. In many cases optimization of the nozzle may improve welding properties and/or reduce operating costs.

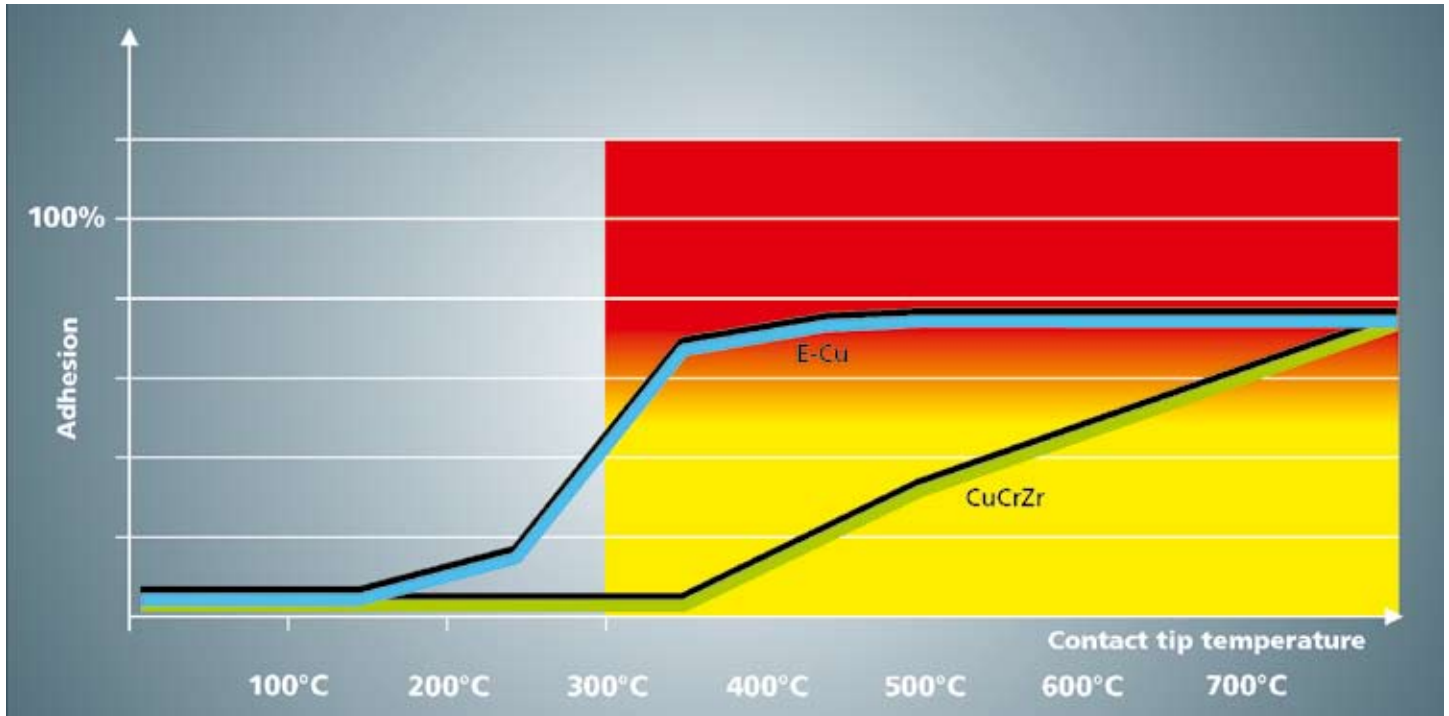
Contact tips for ML/MV torches are available in different materials and lengths so as to ensure best possible welding result.

For MIG pulse welding and aluminium welding we recommend longer contact tips, combined with longer gas nozzles, for optimization of welding current and gas shielding.

A slim contact tip will have a lower temperature, as it will receive less radiant heat from the arc. For optimization we recommend CuCrZr (copper, chromium, zirconium) contact tips which are considerably harder and less sensitive to high

temperatures contrary to the E-Cu type which will become soft and adhere to the welding wire if the temperature in the contact tip exceeds 300°C (please see the curve below).

For details about Migatronic contact tips, please see overleaf.



CHOICE OF TIP ADAPTOR - MATERIAL AND DESIGN

Some types of Migatronic torches with separate tip adaptors can be equipped with various designs of tip adaptors. This allows the welder to optimise to another type of contact tip (thread/length).

A tip adaptor made of CuCrZr will increase the performance of the torch. A standard tip adaptor is made of Ms (brass) which is characterized by its strength, but the thermal conductivity is not optimal. CuCrZr is characterized by the strength and ductility of Ms and the thermal conductivity of E-Cu.

The Migatronic MV 450/550 torches are supplied with either integrated or separate tip adaptors.

Torches with integrated tip adaptors have certain advantages in terms of performance, but the swan neck must be replaced if thread for contact tip becomes defective. For maximum performance of a given size of torch we recommend integrated tip adaptors.

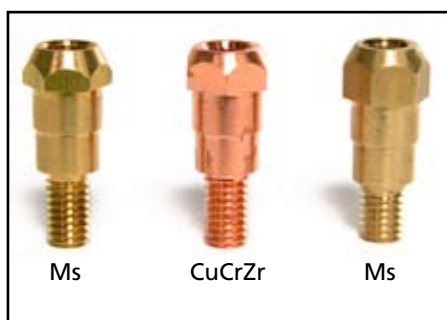
The performance of a torch with separate tip adaptor will typically be lower than the performance of a torch with

integrated tip adaptor. The advantage is, however, that the tip adaptor can be replaced. The FKS types have separate tip adaptors with direct connection to the cooling water. That is why they are up to the performance standard of torches with integrated tip adaptors.

The MV 500 FKS type is equipped as standard with separate CuCrZr tip adaptor.

For details about tip adaptors for the individual types of torches, please see pages 3-7.

ML/MV 240



MV 450/550



MIGATRONIC CONTACT TIPS


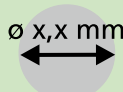

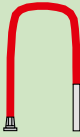
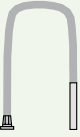

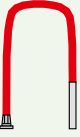
Contact tip - design and length	Item no.	Item description	ML 120 D	ML 140	ML 130	ML 150	ML 240	ML 250	ML 300	ML 360	MV 240	MV 450	MV 550	MV 450 HD-S	MV 550 HD-S	MV 400 FKS	MV 500 FKS
M 5																	
	80130140	∅ 0.6 M5 ∅ 5 x 18 mm Cu		•													
	80130141	∅ 0.8 M5 ∅ 5 x 18 mm Cu		•													
	80130142	∅ 1.0 M5 ∅ 5 x 18 mm Cu		•													
M 6																	
	80130001	∅ 0.6 M6 ∅ 6 x 25 mm Cu nickel-plated	•														
	80130002	∅ 0.8 M6 ∅ 6 x 25 mm Cu nickel-plated	•														
	80130003	∅ 1.0 M6 ∅ 6 x 25 mm Cu nickel-plated	•														
	80130004	∅ 1.2 M6 ∅ 6 x 25 mm Cu nickel-plated	•														
	80130101	∅ 0.6 M6 ∅ 6 x 25 mm Cu	•		•	•	•	•									
	80130102	∅ 0.8 M6 ∅ 6 x 25 mm Cu	•		•	•	•	•									
	80130103	∅ 1.0 M6 ∅ 6 x 25 mm Cu	•		•	•	•	•									
	80130104	∅ 1.2 M6 ∅ 6 x 25 mm Cu	•		•	•	•	•									
	80130201	∅ 0.6 M6 ∅ 8 x 28 mm Cu				•	•	•	•	•	•						
	80130202	∅ 0.8 M6 ∅ 8 x 28 mm Cu				•	•	•	•	•	•						
	80130203	∅ 1.0 M6 ∅ 8 x 28 mm Cu				•	•	•	•	•	•						
	80130204	∅ 1.2 M6 ∅ 8 x 28 mm Cu				•	•	•	•	•	•						
	80131200	∅ 0.8 M6 ∅ 8 x 28 mm CuCrZr				•	•	•	•	•	•						
	80131201	∅ 1.0 M6 ∅ 8 x 28 mm CuCrZr				•	•	•	•	•	•						
	80131202	∅ 1.2 M6 ∅ 8 x 28 mm CuCrZr				•	•	•	•	•	•						
	80131203	∅ 1.4 M6 ∅ 8 x 28 mm CuCrZr				•	•	•	•	•	•						
	80131204	∅ 1.6 M6 ∅ 8 x 28 mm CuCrZr				•	•	•	•	•	•						
M 8																	
	80231101	∅ 0.8 M8 ∅ 10 x 30 mm E-Cu										•	•			•	•
	80231102	∅ 1.0 M8 ∅ 10 x 30 mm E-Cu										•	•			•	•
	80231103	∅ 1.2 M8 ∅ 10 x 30 mm E-Cu										•	•			•	•
	80231106	∅ 1.4 M8 ∅ 10 x 30 mm E-Cu										•	•			•	•
	80231104	∅ 1.6 M8 ∅ 10 x 30 mm E-Cu										•	•			•	•
	80231111	∅ 1.0 M8 ∅ 8 x 35 mm CuCrZr										•	•			•	•
	80231112	∅ 1.2 M8 ∅ 8 x 35 mm CuCrZr										•	•			•	•
	80231113	∅ 1.6 M8 ∅ 8 x 35 mm CuCrZr										•	•			•	•
	80231121	∅ 1.0 M8 ∅ 10 x 35 mm E-Cu										•	•			•	•
	80231122	∅ 1.2 M8 ∅ 10 x 35 mm E-Cu										•	•			•	•
	80231123	∅ 1.6 M8 ∅ 10 x 35 mm E-Cu										•	•			•	•
	80231200	∅ 0.8 M8 ∅ 8 x 30 mm CuCrZr										•	•			•	•
	80231201	∅ 1.0 M8 ∅ 8 x 30 mm CuCrZr										•	•			•	•
	80231202	∅ 1.2 M8 ∅ 8 x 30 mm CuCrZr										•	•			•	•
	80231203	∅ 1.6 M8 ∅ 8 x 30 mm CuCrZr										•	•			•	•
	80231204	∅ 1.4 M8 ∅ 8 x 30 mm CuCrZr										•	•			•	•
	80231205	∅ 0.8 M8 ∅ 10 x 30 mm CuCrZr										•	•			•	•
	80231206	∅ 1.0 M8 ∅ 10 x 30 mm CuCrZr										•	•			•	•
	80231207	∅ 1.2 M8 ∅ 10 x 30 mm CuCrZr										•	•			•	•
	80231208	∅ 1.4 M8 ∅ 10 x 30 mm CuCrZr										•	•			•	•
	80231209	∅ 1.6 M8 ∅ 10 x 30 mm CuCrZr										•	•			•	•
	80231300	∅ 0.8 M8 ∅ 10 x 38 mm CuCrZr										•	•			•	•
	80231301	∅ 1.0 M8 ∅ 10 x 38 mm CuCrZr										•	•			•	•
	80231302	∅ 1.2 M8 ∅ 10 x 38 mm CuCrZr										•	•			•	•
	80231303	∅ 1.6 M8 ∅ 10 x 38 mm CuCrZr										•	•			•	•
	80231304	∅ 2.4 M8 ∅ 10 x 38 mm CuCrZr										•	•			•	•
	80231400	∅ 0.8 M8 ∅ 10 x 41 mm CuCrZr										•	•			•	•
	80231401	∅ 1.0 M8 ∅ 10 x 41 mm CuCrZr										•	•			•	•
	80231402	∅ 1.2 M8 ∅ 10 x 41 mm CuCrZr										•	•			•	•
	80231404	∅ 1.6 M8 ∅ 10 x 41 mm CuCrZr										•	•			•	•
M 10																	
	80231451	∅ 0.8 M10 ∅ 10 x 40 mm CuCrZr												•	•		
	80231452	∅ 1.0 M10 ∅ 10 x 40 mm CuCrZr												•	•		
	80231453	∅ 1.2 M10 ∅ 10 x 40 mm CuCrZr												•	•		
	80231454	∅ 1.6 M10 ∅ 10 x 40 mm CuCrZr												•	•		

Ring = CuCrZr material

• = Mild steel Fe, stainless steel CrNi and FCW
 (•) = Alternative, but we recommend •

• = Aluminium welding
 • = For gas nozzles with special length: please see torch type

MIGATRONIC WIRE LINERS

Wire	Wire diameter	Steel liner	Plastic liner (PEH) with bronze neck	Carbon teflon liner (carbon PTFE) with bronze neck	Carbon teflon liner (carbon PTFE) with bronze neck	Teflon liner (PTFE) with bronze neck
						
Length of liner		4.4 m	4.4 m	3.4 m	4.4 m	4.4 m
Fe Mild steel	0.6 mm 0.8 mm 1.0 mm 1.2 mm 1.4 mm 1.6 mm 2.0 mm 2.4 mm	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523				
CrNi Stainless steel	0.6 mm 0.8 mm 1.0 mm			80160699 80160699	80160700 80160700	80160146* 80160146*
Cu Copper alloys	1.2 mm 1.4 mm 1.6 mm 2.0 mm 2.4 mm			80160706 80160706 80160706	80160707 80160707 80160707	80160147* 80160148*
Fe Flux Steel with flux cored wire	0.6 mm 0.8 mm 1.0 mm 1.2 mm 1.4 mm 1.6 mm 2.0 mm 2.4 mm	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523				
CrNi Flux Stainless steel with flux cored wire	1.0 mm 1.2 mm 1.4 mm 1.6 mm			80160699 80160706 80160706 80160706	80160700 80160707 80160707 80160707	
Al Aluminium	1.0 mm 1.2 mm 1.4 mm 1.6 mm		80160711 80160713 80160713 80160713			80160146* 80160147* 80160148* 80160148*

* = Alternative, but we recommend item without *
For other lengths, please see page 11

Typical spare parts for central connections

Swivel nut:
80200303



Gas nipple:
26920008 Ms

80100004 Ms
26910008 CrNi

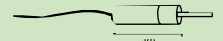


O-ring:
80100710



Spring pins:

Without spring	21.5 mm	80200312
Without spring	26.0 mm	80100748
Without spring	21.0 mm	80100756
Without spring	19.0 mm	80100773
With spring	24.0 mm	80100747
With spring	19.0 mm	80100755



MIGATRONIC WIRE LINERS

Nippel - design and length	Item no.	Item description	Automig X x 120 D	Automig XR x 120 D	Automig XE x 120 D	ML 140	ML 130	ML 150	ML 240	ML250	ML 300	ML 360	MV 240	MV 450	MV 550	MV 400 FKS	MV 550 FKS	MPL/V 300/400 MK I	MPL/V 300/400 MK II
				80160001	PEH 4.2 m 1.5 x 3.2 51 mm nipple														
	80160005	PEH 4.2 m 2.0 x 3.2 61 mm nipple	•																
	80160020	PEH 4.2 m 1.5 x 3.2 61 mm nipple																	
	80160528	Steel 4.2 m. 1.6 x 3.3 51 mm nipple																	
	80160538	Steel 4.2 m XR 0.8-1.0 61 mm w/O-ring nipple		•															
	80160539	Steel 4.2 m XR 0.8-1.0 51 mm w/O-ring nipple																	
	80160533	Steel 4.2 m 0.8-1.0 /Ø 4.0 light blue without nipple			•														
	80160536	Steel 2.0 m 0.8-1.0 /Ø 4.0 light blue																	
	80160715	PEH white 4.4 m 0.6-0.8 mm w. 165mm steel neck				•													
	80160716	PEH blue 4.4 m 0.8-1.0 mm w. 165 mm steel neck																	
	80160520	Steel 4.4 m w/nipple 0.6 - 0.8 white		•	•														
	80160550	Steel 5.4 m w/nipple 0.6 - 0.8 white																	
	80160521	Steel 4.4 m w/nipple 0.8 - 1.0 blue																	
	80160551	Steel 5.4 m w/nipple 0.8 - 1.0 blue																	
	80160518	Steel 8.4 m w/nipple 0.8 - 1.0 blue																	
	80160522	Steel 4.4 m w/nipple 1.2 - 1.6 red				•	•	•	•	•	•	•	•	•	•	•	•	•	•
	80160552	Steel 5.4 m w/nipple 1.2 - 1.6 red																	
	80160517	Steel 8.4 m w/nipple 1.0 - 1.6 red																	
	80160523	Steel 4.4 m w/nipple 1.6 - 2.4 yellow																	
	80160553	Steel 5.4 m w/nipple 1.6 - 2.4 yellow																	
	80160146	PTFE 4.4 m 0.6-0.8 Ø 4.0 white O-ring screw nipple																	
	80160149	PTFE 5.4 m 0.6-0.8 Ø 4.0 white O-ring screw nipple																	
	80160147	PTFE 4.4 m 0.8-1.0 Ø 4.0 blue O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
	80160150	PTFE 5.4 m 0.8-1.0 Ø 4.0 blue O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
with bronze neck	80160148	PTFE 4.4 m 1.2-1.6 Ø 4.0 red O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
	80160151	PTFE 5.4 m 1.2-1.6 Ø 5.4 red O-ring screw nipple																	
	80160620	PTFE 4.4 m 0.6-0.8 white O-ring screw nipple																	
	80160630	PTFE 5.4 m 0.8-1.0 white O-ring screw nipple																	
	80160621	PTFE 4.4 m 0.8-1.0 blue O-ring screw nipple																	
	80160631	PTFE 5.4 m 0.8-1.0 blue O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
No neck	80160622	PTFE 4.4 m 1.2-1.6 red O-ring screw nipple																	
	80160632	PTFE 5.4 m 1.2-1.6 red O-ring screw nipple																	
	80160623	PTFE 4.4 m 1.6-2.0 yellow O-ring screw nipple																	
	80160633	PTFE 5.4m 1.6-2.0 yellow O-ring screw nipple																	
	80160699	Carbon 3.4 m 0.8-1.0 mm O-ring screw nipple																	
	80160700	Carbon 4.4 m 0.8-1.0 mm O-ring screw nipple																	
with bronze neck	80160706	Carbon 3.4 m 1.2-1.6 mm O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
	80160707	Carbon 4.4 m 1.2-1.6 mm O-ring screw nipple																	
	80160708	Carbon 5.4 m 1.2-1.6 mm O-ring screw nipple																	
with bronze neck	80160711	PEH blue 4.4 m 0.8-1.0 mm O-ring screw nipple																	
	80160712	PEH blue 5.4 m 0.8-1.0 mm O-ring screw nipple				•	•	•	•	•	•	•	•	•	•	•	•	•	•
	80160713	PEH blue 4.4 m 1.2-1.6 mm O-ring screw nipple																	
	80160714	PEH blue 5.4 m 1.2-1.6 mm O-ring screw nipple																	
	80160135	PEH 8.5 m PP 1.2-1.6 mm O-ring screw nipple																•	•
	80160137	PTFE 0.3 m red PP neck MKII without nipple																	
	80160705	Carbon 8.5 m 1.2-1.6 mm O-ring screw nipple																•	•

• = Mild steel Fe • = Stainless steel CrNi • = Aluminium welding Al

ML 150 - MV 550 FKS - MIG MANAGER®

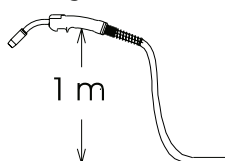
Technical data

We reserve the right to make changes

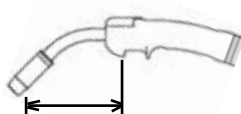
Model	ML 150	ML 240	ML 250	ML 300	ML 360	MV 240	MV 400 FKS	MV450 Integr./sep. tip adaptor	MV500 FKS	MV 550 Integr./sep. tip adaptor
Duty cycle:										
CO ₂ 60%	180 A	250 A	230 A	295 A	380 A	300 A	415 A	450 A/ 400 A	560 A	550 A/ 500 A
CO ₂ 100%	160 A	225 A	205 A	260 A	340 A	300 A	415 A	450 A/ 400 A	560 A	550 A/ 500 A
Mixgas 60%	170 A	220 A	225 A	255 A	310 A	270 A	350 A	400 A/ 350 A	520 A	500 A/ 450 A
Mixgas 100%	150 A	195 A	200 A	225 A	270 A	270 A	350 A	400 A/ 350 A	520 A	500 A/ 450 A
Technique:										
Cooling	Air	Air	Air	Air	Air	Water	Water	Water	Water	Water
Min. flow rate watercooling 1 bar	-	-	-	-	-	1 l/min.	1 l/min.	1 l/min.	1 l/min.	1 l/min.
Max. pressure (water)	-	-	-	-	-	5 bar	5 bar	5 bar	5 bar	5 bar
Max. water temp.	-	-	-	-	-	70°C	70°C	70°C	70°C	70°C
Gas flow +/-5%	15 l/min.*	15 l/min.*	15 l/min.*	15 l/min.*	15 l/min.*	15 l/min.	18 l/min.	18 l/min.	18 l/min.	18 l/min.
Wire diameter, mm	0.6-1.2	0.6-1.6	0.6-1.6	0.6-1.6	0.6-1.6	0.6-1.8	0.8-2.4	0.6-3.2	0.8-2.4	0.6-3.2
Cable, mm ²	16	25	25	35	50	16	16	16	16	16
Weight**	0.9 kg	1.2 kg	1.3 kg	1.6 kg	1.8 kg	1.5 kg	1.6 kg	1.6 kg	1.7 kg	1.6 kg
Total weight kg, 3 m	1.8 kg	2.1 kg	2.1 kg	3.9 kg	4.0 kg	3.0 kg	3.1 kg	3.0 kg	3.2 kg	3.0 kg
Total weight kg, 4 m	2.1 kg	2.6 kg	2.6 kg	4.7 kg	4.7 kg	3.6 kg	3.7 kg	3.6 kg	3.8 kg	3.6 kg
Connection	ZA	ZA	ZA	ZA	ZA	ZA	ZA	ZA	ZA	ZA
Length of swan neck***	10.5 cm	12.5 cm	11.5 cm	12.0 cm	16.5 cm	11.0 cm	13.5 cm	12.0 cm	15.0 cm	15.0 cm
Norm:										
IEC 60974-7	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
IEC 60974-10	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes

* Minimum gas flow
for compliance
with maximum
performance

** Weight



*** Length of swan neck



Special solutions for MIG/MAG welding hoses

Custom-built MIG/MAG welding hoses for special purposes can be supplied on request:

- Change of sequence on MIG/MAG torches (Migatronic machines)
- Adjustment of length of welding hose
- Adjustment of length of torch
- Special curve of torch

England

MIGATRONIC WELDING EQUIPMENT LTD
21, Jubilee Drive, Belton Park,
Loughborough
Leicestershire LE115XS - UK
Tel: (+44) 01509/267499
Fax: (+44) 01509/231959
Service department: (+44) 01509/211492

Svejsemaskinefabrikken Migatronic A/S

Aggersundvej 33, Postboks 206
DK-9690 Fjerritslev, Denmark
Tel: (+45) 96 500 600
Telefax: (+45) 96 500 601
Homepage: www.migatronic.com

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