

MPI 220P

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



Quick Specs



Applications

Light Fabrication
Maintenance and Repair
Auto Body
Farm/Home

Process

MIG/MAG
Pulsed MIG
Stick
TIG
Flux Cored

Input power: 230 VAC, 1 phase

Rated Output: MIG: 180 A/35% ID @ 23.0 V
Stick: 170 A/35% ID @ 26.8 V
TIG: 180 A/35% ID @ 17.2 V

Weight: 16 kg

The Power of Blue.®

Portability is number one: when you have to go to the job - because it can't come to you. The MPI 220P contains all you need to MIG weld in one small lightweight package. With the flip of a switch, all processes are available to meet the application at hand.

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

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

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

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



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

Synergic welding mode offers the simplicity of single knob control. The machine will select the correct voltage and amperage based on the wire feed speed (WFS) set by the operator.

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



Adjustable Hot Start™ for Stick arc starts. Adjust the optimal start current for the application. The current automatically increases the output amperage at the start of a weld.

Built-in upslope/downslope function for TIG helps provide better arc starts and reduces craters.

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

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



Power source is warranted for 3 years, parts and labour.



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Specifications



Model	IP Rating	Welding Mode	Rated Output (Duty cycle)			Max. Open-Circuit Voltage	Ampereage/ Voltage Range DC	input Power	Dimensions	Weight
			100%	60%	35%					
MPI 220P	IP22S	MIG	110 A	140 A	180 A	35 V	2-200 A 15-24 V 5-200 A 20.2-28 V	230 VAC 50/60 Hz 1 phase	H: 365 mm W: 237 mm D: 548 mm	16,0 kg
		Stick	100 A	130 A	170 A	65 V				
		TIG	100 A	130 A	180 A	65 V				
			17.5 V	21.0 V	23.0 V					
			24.0 V	25.2 V	26.8 V					
			14.0 V	15.2 V	17.2 V					

Drive Roll Kits

Drive Roll and Wire Guide Kits for MPI 220P

Base selection of drive rolls upon the following recommended usages:

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

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

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

Ordering Information

Power Source	Stock No.	Description
MPI 220P	059 016 014	230 VAC, 50/60 Hz, single-phase. Includes work clamp
Accessories		
Drive Roll Kit		See Drive Roll Kits table above
Tig Torch	WP-9VIS4STDRBXXXX	WP-9V single switch, 25 mm Dinse, no gas connection and plug, Gas 2 m long
	WP-17VIS4STDRBXXXX	WP-17V single switch, 25 mm Dinse, no gas connection and plug, Gas 2 m long
	WTC9VS4BXXXX	WTC-9V single switch, 25 mm Dinse, no gas connection and plug, Gas 2 m long
	WTC17VS4BXXXX	WTC-17V single switch, 25 mm Dinse, no gas connection and plug, Gas 2 m long
Mig Torch	Q201 0A0 8DE	Bernard Q 200 A, length 3,05 m

