

MPi 220P

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



Quick Specs



Industrial Applications

Light fabrication
Maintenance and repair
Auto body
Farm/home

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
Stick (SMAW)
TIG (GTAW)
Flux-cored (FCAW)

Input Power 230 V, single-phase, 50/60 Hz

Amp/Volt Range MIG: 20–200 A, 15–24 V
Stick: 5–200 A, 20.2–28 V
TIG: 5–200 A, 10–18 V

Rated Output MIG: 110 A at 17.5 VDC, 100% duty cycle
Stick: 100 A at 24 VDC, 100% duty cycle
TIG: 100 A at 14 VDC, 100% duty cycle

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.

Full weld process capability.

MIG/MAG, pulse, stick and TIG are available to meet the demand of current applications.

Synergic welding library 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.

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



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.

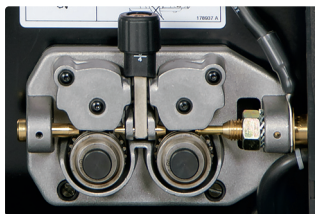
Built-in run-in/crater/burnback function for MIG helps provide better arc starts and reduces craters.



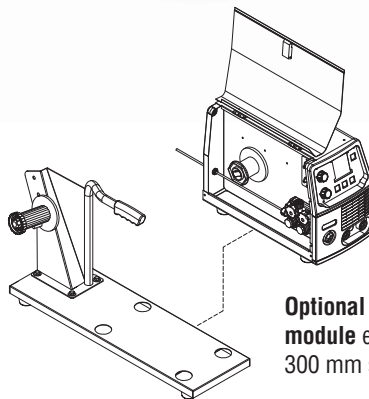
Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

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.

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



Cast aluminum drive system incorporates a dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make setup easier and faster.



Optional spool holder module enables use of a 300 mm spool of wire.



Warrantied for three years, parts and labour.



Specifications (Subject to change without notice.)



Input Power	Welding Mode	Amperage/ Voltage Ranges	Rated Output (Duty Cycle)			Max. Open-Circuit Voltage	IP Rating	Dimensions	Net Weight
			100%	60%	35%				
230 V, 1-phase, 50/60 Hz	MIG	2–200 A 15–24 V	110 A 17.5 V	140 A 21.0 V	180 A 23.0 V	35 V	IP22S	H: 365 mm (14.4 in.) W: 237 mm (9.3 in.) D: 548 mm (21.6 in.)	16 kg (35 lb.)
	Stick	5–200 A 20.2–28 V	100 A 24.0 V	130 A 25.2 V	170 A 26.8 V	65 V			
	TIG	5–200 A 10–18 V	100 A 14.0 V	130 A 15.2 V	180 A 17.2 V	65 V			

CE All CE models conform to the applicable parts of the IEC 60974 series of standards.

Drive Rolls and Wire Guides

Select drive rolls from chart below according to type and wire size being used.

Wire Size	“V” Groove Drive Roll for hard wire	“U” Groove Drive Roll for soft wire or soft-shelled cored wire	“V” Knurled Drive Roll for hard-shelled cored wire	Pressure Roll	Wire Inlet Guide
0.6/0.8 mm (.023/.030 in.)	156053051	—	—	156053112*	156090026*
0.8/1.0 mm (.030/.040 in.)	156053109*	156053053	—		
1.0/1.2 mm (.040/.045 in.)	156053052	156053054	156053110		

*Included with MPi 220P.

Ordering Information

Power Source	Stock No.	Description	Qty.	Price
MPi 220P	059016014	230 V, single-phase, 50/60 Hz		
Accessories				
Drive Rolls and Wire Guides		See chart above		
Weldcraft™ TIG Torch	WP-17VS4BXEY3GL	130 amps DC, 100 amps AC, 60% duty cycle		
Bernard® MIG Gun	Q2010TE3DEQ	Air-cooled, 200 A, 3 m (10 ft.). TOUGH LOCK™ consumables		
Wire Spool Holder	058066097	For 300 mm spool		

Date: Total Quoted Price:

Distributed by:

