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Operating manual • English
Gebrauchsanweisung • Deutsch
Gebruiksaanwijzing • Nederlands
Manuel d'utilisation • Français

FASTMIG™

KM 300

KM 400

KM 500



FI

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PL

RU

OPERATING MANUAL

English

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1. PREFACE

1.1 GENERAL

Congratulations on your choice of the FastMig™ KM-series power source. Reliable and durable, Kemppi products are affordable to maintain, and they increase your work productivity.

This user manual contains important information on the use, maintenance, and safety of your Kemppi product. The technical specifications of the device can be found at the end of the manual. Please read the manual carefully before using the equipment for the first time. For your safety and that of your working environment, pay particular attention to the safety instructions in the manual.

For more information on Kemppi products, contact Kemppi Oy, consult an authorised Kemppi dealer, or visit the Kemppi Web site at www.kemppi.com.

The specifications presented in this manual are subject to change without prior notice.

Important notes

Items in the manual that require particular attention in order to minimise damage and personal harm are indicated with the '**NOTE!**' notation. Read these sections carefully and follow their instructions. Please also read the safety instructions in this manual and respect them.

1.2 SAFETY INSTRUCTIONS

Kemppi equipment is manufactured according to international standards for welding equipment. The products have top-quality operating safety. There are, however, always certain fire and electrical safety hazards involved with using welding equipment. Therefore, to ensure your personal safety and the safety of your working environment, carefully read the safety instructions below and respect them.

Welding arc, radiation, and spatter

- Shield your eyes and environment appropriately before you start welding or observe welding. The arc and its reflecting radiation damage unprotected eyes.
- When welding or in the proximity of someone who is welding, wear welding gloves and protective clothing, as the arc and the spatter burn unprotected skin.

Danger of fire or explosion

- Welding is always classified as hot work, and therefore you need to observe fire safety regulations.
- Always ensure that you have sufficient fire-fighting equipment available where you are welding.
- Remove flammable or explosive materials from the welding site. Also remember that metal dust can cause a fire.
- In special welding jobs, be prepared for hazards such as fire or explosion when welding container-type work pieces.
- Remember that fire can break out from sparks even several hours after the welding work is completed.

Mains voltage

- Ensure that the mains cable of the welding machine is not squeezed or exposed to sharp edges or a hot work piece under any circumstances.
- Do not take the power source inside a container, car, or similar work piece.
- Do not place the power source on a wet surface.
- Replace the mains cable immediately if you notice defects or wear in it. A faulty mains cable is life-threatening and can cause electrocution and fire.

Welding power circuit

- Isolate yourself by using dry protective clothing that is in good condition.
- Never work on a wet surface.
- Replace damaged welding cables with fault-free ones immediately.
- Do not put the MIG gun or welding cables on the welding machine or other electric equipment.

Welding fumes

- Make sure that there is sufficient ventilation during welding.
- Take extra precautions when welding metals containing lead, cadmium, zinc, mercury, or beryllium.

Noise

The noise level of welding is determined by the welding method and current used. The greatest source of noise, however, is the auxiliary functions of welding, such as slag removal, hammering, disc cutting, and grinding, as well as carbon-arc gouging.

- Always wear hearing protection when welding.
- Design your work methods and order in such a way as to minimise the number and duration of noise-producing work stages.

Magnetic field

The welding current creates a magnetic field around the welding cables and equipment with strength directly proportional to the welding current.

- Electric and magnetic fields may interfere with the operation of a pacemaker or hearing aid.
- Avoid carrying the cables and power source on your shoulder.
- Straighten any welding cables that have a loop in them.

Gas bottles and pneumatic devices

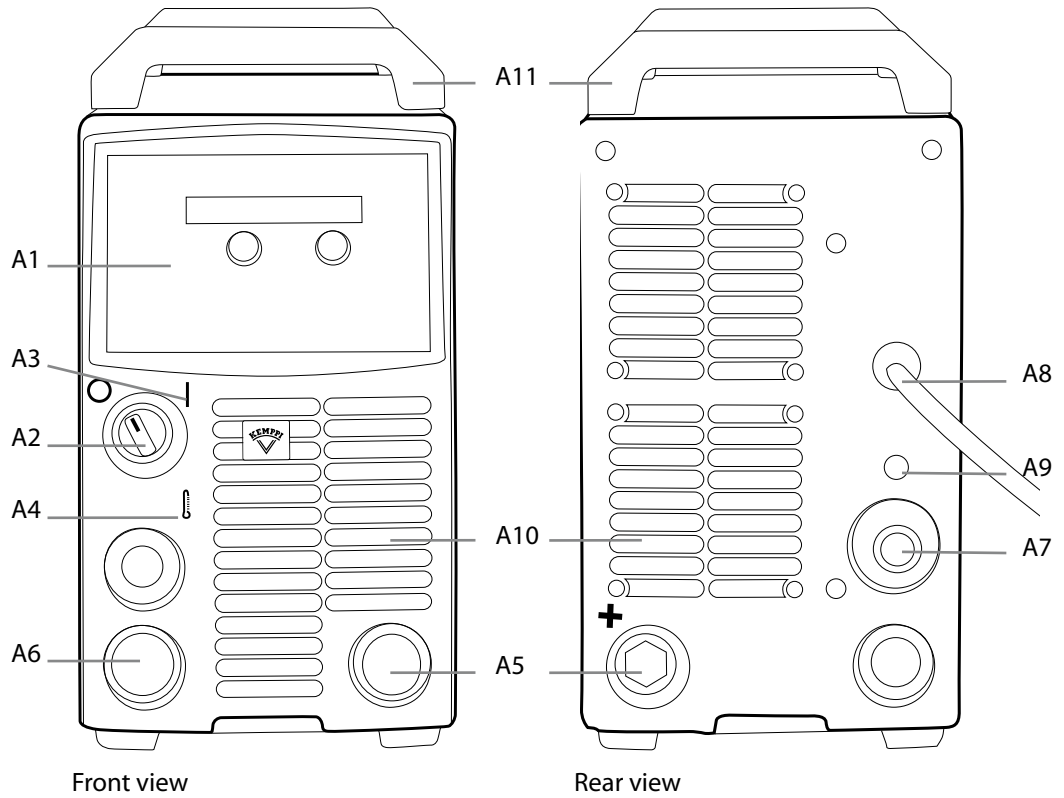
- Adhere to the instructions for handling pneumatic devices and gas bottles.
- Never lubricate any parts of gas equipment with oil or grease. Also, always keep your hands and tools free of grease when handling gas equipment.

NOTE! This equipment's electromagnetic compatibility (EMC) rating qualifies it for use in an industrial environment. Class-A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system.

1.3 INTRODUCTION

The FastMig™ KM-series power sources 300, 400, and 500 are MIG power sources designed for demanding professional use in the three-phase network. The power source has a control panel that allows ready control of the functions of the power source and the wire feeder.

Overview of the power source

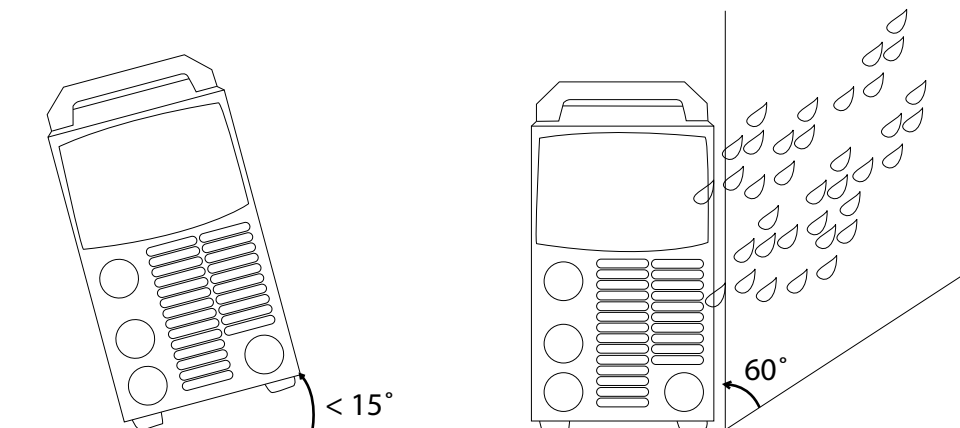


- A1 Control panel
- A2 Main switch
- A3 Signal light (I/O)
- A4 Thermal warning light
- A5 Welding cable connection
- A6 Earth connection
- A7 Control cable connection
- A8 Mains cable input
- A9 Fuse for control cable connection (6.3 A slow)
- A10 Fan grills
- A11 Carrying handles

2. INSTALLATION

2.1 POSITIONING OF THE MACHINE

Place the machine on a sturdy, level surface that is dry and does not release dust or other impurities to the suction air through the fan grill.



Notes for positioning of the machine

- Preferably, situate the machine somewhat above floor level.
- The surface inclination may not exceed 15 degrees.
- There must be at least 20 cm of free space in front of and behind the machine for cooling air circulation.
- Protect the machine against heavy rain and direct sunshine.
- Ensure the free circulation of the cooling air.

The protection class of the machine, IP 23 S, allows water spray to hit the machine's outer covering at a maximum angle of 60 degrees.

NOTE! Never aim the spray of sparks from a grinding machine toward the device.


2.2 CONNECTION TO MAINS

FastMig™ KM power sources are connected to the 400-V three-phase network using the mains cable supplied with the machine.

The machine is equipped with a five-metre mains cable that does not have a plug. Before use, check the mains cable and install a mains plug. If the cable does not comply with the local electrical regulations, replace it with a compliant cable. See 'Technical specifications'.

NOTE! The mains cable or plug may be installed or replaced by only an electrical contractor or installer authorised to perform such operations.

Replacement of the mains cable

1. Unscrew the mounting screws on the top and sides of the machine, and remove the case by lifting it.
2. Disconnect the phase leads from connectors L1, L2, and L3, and disconnect the protective earth lead.
3. Pass the cable to the machine through the inlet ring at the rear of the machine, and secure the cable with a cable clamp.
4. Connect the cable's phase leads to connectors L1, L2, and L3.
5. Connect the yellow-green protective earth lead to its connector .

NOTE! Do not connect the zero lead if you are using a five-lead cable.

The table below lists the fuse sizes for 100% load in a 400-V three-phase network with 4 x 10-mm² cable for different power source models.

Model	Fuse
KM 300	20 A delayed
KM 400	25 A delayed
KM 500	35 A delayed

2.3 WELDING AND EARTHING CABLES

The device has a welding cable connection both in the front and in the rear. The positions of the welding and earthing cable connections are shown earlier in section 'Introduction'.

The welding cable type to be used is rubber-insulated copper cable. The recommended cross-sections of the cables for different power source models are as follows:

Model	Cross-section
KM 300	50...70 mm ²
KM 400	70...90 mm ²
KM 500	70...90 mm ²

The table below shows the typical load capacities of the cables when the ambient temperature is 25 °C and the lead temperature is 85 °C.

Cable	Duty cycle (ED)				Voltage loss / 10 m
	100 %	60 %	35 %	20 %	
50 mm ²	285 A	316 A	371 A	458 A	0,35 V / 100 A
70 mm ²	355 A	403 A	482 A	602 A	0,25 V / 100 A
95 mm ²	430 A	498 A	606 A	765 A	0,18 V / 100 A
120 mm ²	500 A	587 A	721 A	917 A	0,21 V / 100 A

NOTE! Do not overload the welding cables, as an overload may cause voltage loss and overheating.

Connect the earth clamp directly to the work piece in such a way as to maximise the contact surface of the clamp. The point of connection must be unpainted and free of corrosion.

3. MACHINE USE

3.1 STARTING OF THE POWER SOURCE

Start the power source by turning the main switch (A2) on the front panel to the 'I' position. The standby indicator (A3) turns on. The control panel and wire feeder are not operational yet, and the text 'OFF' is shown on the control panel display.

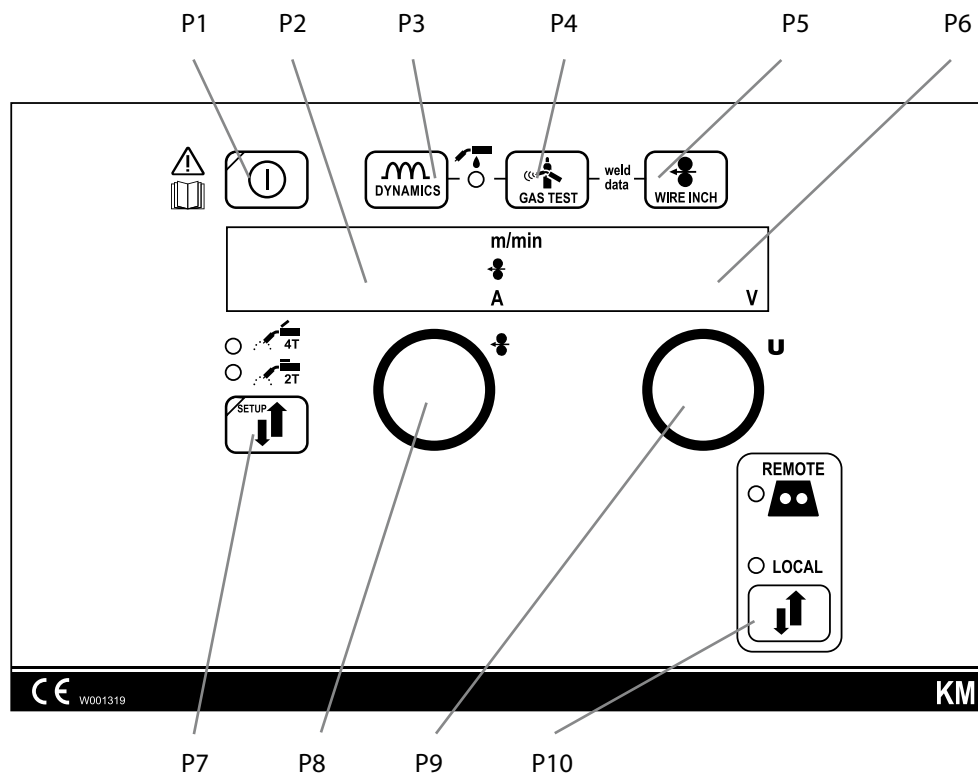
NOTE! Always turn the device on and off using the main switch, not via the mains socket.

The cooling fan is started for a moment when the main switch is turned to the 'I' position. The fan turns off after a while and then restarts during welding when the machine has warmed up sufficiently. The fan continues running even after up to 10 minutes of welding, depending on the temperature of the machine.

3.2 FRONT PANEL INDICATORS

The following indicators can be found on the front panel of the device:

- When the green indicator, A3, is on, the power source is in standby mode. This indicator is on when the machine is connected to the mains supply with the main switch in the 'I' position.
- When the yellow overheating indicator (A4) is on, the machine has overheated. The fan then starts. When the indicator turns off, the machine can be used again.
- When indicator A4 blinks, the machine has experienced a failure. Attempt to remedy the problem according to the instructions in Section 4, 'Troubleshooting'. If the failure cannot be eliminated, turn off the machine, and turn it on again. If the failure persists, write down any fault code that may be shown on the display and contact authorised Kemppi service agent.



3.3 USE OF THE CONTROL PANEL

The control panel is used for controlling and monitoring the operation of the power source and the wire feeder. The buttons are used for adjusting functions. The displays and indicators reflect the operating modes of the machine.

3.3.1 Starting of the control panel

- When you start the power source with the main switch (A2), the control panel remains in OFF mode and the wire feeder is not operational. The display shows the text 'OFF'.
- When you depress the start button P1 for at least one second, the control panel starts. The unit is now ready for welding and enters the mode that was active before the power was cut off.
- You can also start the control panel by quickly pressing the welding gun switch three times.

3.3.2 Displays

- When you are adjusting the machine settings, the control panel displays show adjustable operation parameters, their values, and the units of measure.
- During welding, display P2 shows the welding current value that is currently in use, while display P6 shows the welding voltage.

3.3.3 Control knobs

- The left-hand control knob (P8) allows adjustment of the speed of wire feeding. The selected speed is shown on the display on the left-hand side (P2).
- The control knob on the right-hand side (P9) allows you to adjust the welding voltage. The selected voltage is shown on the right-hand display (P6).

These adjusters are used also for selecting the values of the machine's operational parameters, such as the MIG mode and set-up features. A parameter for adjustment is selected with the left-hand knob (P8), while the value of the parameter is selected with the right-hand knob (P9).

3.3.4 Adjustment of MIG dynamics (arc force)

When you press button P3, you can adjust the MIG welding dynamics of the machine by means of the right-hand knob, P9. The welding dynamics setting affects the properties of the welding arc and the amount of spatter as follows:

- The value 0 is the recommended basic setting.
- Use values -1 ... -9 if you want a softer arc and less spatter.
- Use values 1 ... 9 if you want a rougher and more stable arc. This setting is useful when you are using 100% CO₂-shielding gas when welding steel.

3.3.5 Gas test

The gas test button (P4) opens the gas valve without activating the wire feed or power source. By default, gas flows for 20 seconds. The gas flow time remaining is shown on the display.

The right-hand knob (P9) allows you to set the default gas flow time, between 10 - 60 seconds, and store the new default value in the machine's memory. To abort the gas test, press the start button or gun switch.

3.3.6 Wire Inch

When you press the Wire inch button, P5, the wire feeder engine starts but the gas valve does not open and the power source is not activated. The default wire feed speed is 5 m/min, and you can adjust the speed with the right-hand knob. When the button is released, the wire feeding stops. The machine automatically goes back to the normal state after approximately five seconds from release of the button or immediately when you press the start button.

3.3.7 Selection of liquid- or gas-cooled MIG gun

You can select a MIG gun cooled with liquid or gas by pressing buttons 3 and 5 simultaneously and holding them down for at least one second.

- When the display reads 'GAS', you can use a gas-cooled MIG gun with the equipment.
- When the display reads 'COOLER', you can use a liquid-cooled MIG gun with the equipment.

You can change the gun selection by pressing buttons P3 and P4 again, as above. With a liquid-cooled gun selected, the liquid cooling function is started when the power source is started the next time.

3.3.8 Retrieval of weld data

The weld data function allows you to return to the welding current and voltage used during the previous session, with the weld data feature. To use the feature, press buttons P4 and P5 simultaneously.

3.3.9 Selection of control panel

Button P10 allows you to switch control between the control panels in the power source and wire feeder. The indicator shows which of the control panels is in use.

- When the 'LOCAL' light is on, the wire feeding speed and welding current are set using knobs P8 and P9 of the power source control panel.
- When the 'REMOTE' light is on, the wire feed speed and welding current are set using the control panel of the wire feeder. Control knobs of the power source are disabled in this mode.

3.3.10 Setting of the MIG operating mode

Button P7 allows you to set the MIG welding gun to either two-sequence or four-sequence mode. The indicator shows the mode selected.

- In two-sequence mode (2T), welding is started by pressing the gun switch and stopped by releasing the switch.
- In four-sequence mode (4T), the following actions take place:
 1. When you press the gun switch, the shielding gas starts to flow.
 2. When you release the switch, welding starts.
 3. When you press the switch again, welding ends.
 4. When you release the switch again, the flow of the shielding gas ends.

3.3.11 Setting of operation parameters

Button P7 also is used for changing welding parameters as follows:

- Depress button P7 for at least five seconds. The set-up menu appears on display P2.
- Select the parameter to adjust with the left-hand knob (P8) so that the name of the parameter you want to adjust is shown on display P2.
- Set a value for the parameter by using the right-hand knob (P9) such that the value you want is shown on display P2. The value you selected is recorded in the control panel memory.
- Exit the set-up menu by pressing button P7 again and holding for at least five seconds or by briefly pressing the control panel start button (P1).

The table below lists the operation parameters and their possible values.

Name of parameter	Name displayed	Parameter values	Factory values	Description
Pre gas Time	PrG	0.0...9.9 s	(0.1 s)	Pre-welding gas time in seconds
Post Gas Time	PoG	Aut, 0.1...32.0 s	(Aut)	Post-welding gas time in seconds or automatically according to welding current 1 s / 100 A (Aut)
Creep Start Level	CrE	10...170 %	(50 %)	Initial wire feeding speed as a percentage of the pre-set value: 10% = slowed start 100% = no creep start 170% = rush start
Start power	StA	-9...+9	(0)	Strength of initial pulse
Post Current Time	PoC	-9...+9	(0)	Post-welding current time
Remote Switch	rS	2t4, Inc	(2t4)	Selection of wire feed device switch operation
Calibration Menu	CAL	---, Ent	(---)	Wire feed speed calibration (see instructions in sub-section 3.3.12)
LongSystem Mode	LSy	on, OFF	(OFF)	Select 'ON' if you are using long (>40 m) connector cables
Restore Factory Settings	FAC	OFF, PAn, All	(OFF)	Restore factory settings; exit the menu by selecting 'All'

3.3.12 Calibration of the wire feed speed

When factory settings are used, the wire feed speed can be adjusted to between 4 and 100 without a unit of measurement. Only the LED symbol indicates that wire feed speed is the parameter to be set.

The unit of the wire feed speed (m/min) is shown once the wire feed speed of the device has been calibrated. To programmatically calibrate the wire feed speed:

1. To prepare the welding equipment for calibrating, do the following:
 - Connect the wire feeder to the power source with the control cable.
 - Insert the filler wire in the gun, and run the wire out of the contact tip.
 - Adjust the feeder wheels so that they are sufficiently tight.
 - Start the power source and turn on the control panel with the start button, P1.
2. Depress button P7 (SETUP) for at least five seconds. The set-up menu appears on the display.
3. Select the calibration menu (CAL) by rotating the left-hand knob, and then select the value 'Enter' (Ent) with the right-hand knob. Accept your selection by pressing button P10 (REMOTE/LOCAL) briefly.
4. Use the right-hand knob to select 'm/min' as the value of measure for the quantity to be calibrated, and accept your selection by briefly pressing button P10 (REMOTE/LOCAL).
5. Use the left-hand knob to set the first calibration point to the desired value (e.g., 2.0 m/min).
6. Cut the filler wire at the contact tip end. Press the trigger, and let the wire run until it stops automatically.
7. Measure the length of the loose wire end to an accuracy of 1 cm.
8. Enter the measurement with the right-hand knob, and accept your selection by pressing button P10 (REMOTE/LOCAL) briefly.
9. Use the left-hand knob to set the second calibration point to an appropriate value (e.g., 18.0 m/min).
10. Repeat steps 6–8.
11. The message 'Suc cES' appears on the display to indicate that calibration has ended successfully. At the same time, the device exits calibration mode and returns to basic operation mode.

4. TROUBLESHOOTING

In the event of a failure of the machine, contact an authorised Kemppi service agent. Before taking your unit for servicing, check the list below.

4.1 OVERLOAD (YELLOW INDICATOR LIT)

Two simultaneously operating fans cool the power source. The machine may, however, overheat if continuously loaded above the rated values or if the circulation of cooling air is prevented.

The yellow indicator (A10) is lit in the event of overheating. You then need to stop welding and let the machine cool down. The indicator light turns off when welding can be resumed.

4.2 CONTROL CABLE CONNECTOR FUSE

The rear wall of the power source contains fuse A9, which protects the control cable connector, A7. Using an incorrect fuse may cause damage to the power source. It is important that you always use the right kind of fuse. The type and size of the fuse are indicated next to the fuse socket.

4.3 ELECTRIC NETWORK OVERVOLTAGE OR UNDERVOLTAGE

If the power source is used in an electric network with insufficient voltage (less than 300 V), the control features of the device are disabled automatically.

The primary circuits of the power source are protected against power spikes. The product's mains voltage range is broad enough to prevent overvoltage problems at up to 440 V (see Section 8, 'Technical specifications'). Make sure that the voltage remains within the allowed range, especially if the operating power is supplied by a generator set.

4.4 MISSING PHASE IN THE ELECTRIC NETWORK

If a phase is missing from the mains current, the welding features will be adversely affected or the machine may have problems starting. Loss of a phase can be caused by a:

- Blown mains fuse.
- Damaged mains cable.
- Poor mains cable connection in the machine's terminal block or mains socket.

4.5 MACHINE ERROR CODES

The machine always checks its operation automatically during start-up and reports any failures detected. If failures are detected during start-up, they are shown as error codes on the control panel display.

Power source error codes

Err3 Power source overvoltage

The machine has stopped the welding because it has detected momentary voltage spikes or continuous overvoltage dangerous to the machine in the electric network. Check the quality of the supply network.

Err4 Power source overheating

The power source has overheated. The cause may be one of the following:

- 1) The power source has been used for a long time at maximum power.
- 2) The circulation of cooling air to the power source is blocked.
- 3) The cooling system has experienced a failure.

Remove any obstacle to air circulation, and wait until the power source fan has cooled down the machine.

Err5 Water unit alarm

The water circulation is blocked. The cause may be one of the following:

- 1) Congestion or disconnection in the cooling pipeline.
- 2) Insufficient cooling liquid.
- 3) Excessive cooling liquid temperature.

Check the circulation of the cooling liquid and the air circulation of the water unit.

Err23 Power source overvoltage warning

The power source has detected voltage spikes in the electric network. Short power spikes can be managed. They do not lead to interruptions in welding but may decrease the welding quality. Check the quality of the supply network.

Err61 The water unit is not found

The water unit is not connected to the equipment, or the connection has failed.

Set the machine to gas cooling (3.3.7) if you are using a gas-cooled welding gun, or connect a water unit.

Err155 Warning of the wire feed unit overheating

The voltage level of the wire feeding engine has increased. The cause may be a stained wire lead or a gun cable that is twisted at a sharp angle. Check the state of the gun, and clean the wire line if this is necessary.

Err154 Overloading of the wire feed motor

The welding has been interrupted because the wire feeding engine power has risen to a high level. The cause may be congestion in the wire line. Check the wire lead, contact tip, and feed rollers.

Err201 Use of PMT gun is prevented

The machine is intended for use with MMT guns. When a PMT gun is used, the gun's jumpers must be set to 'FU'. This error code may appear also if the contacts of the gun trigger are stained or there are problems with the trigger leads. Check the trigger's leads.

Other error codes:

The machine can show codes not listed here. In the event of an unlisted code appearing, contact an authorised Kemppi service agent and report the error code shown.

5. MAINTENANCE

The utilisation level of the power source and its working environment should be taken into consideration in planning the frequency of maintenance of the machine. Appropriate use and preventive maintenance guarantee the trouble-freest use of the equipment. This allows you to avoid interruptions in use and increases the productivity of the machine.

5.1 CABLES

Check the condition of welding and mains cables daily. Do not use damaged cables. Also make sure that all extension cables used in the mains connection are in proper condition and compliant with regulations.

NOTE! The mains cables may be repaired and installed only by electrical contractors and installers authorised to perform such operations.

5.2 POWER SOURCE

Before cleaning the interior of the machine, you need to remove the case by unscrewing the mounting screws at the top and sides of the machine.

NOTE! To prevent damage, wait approximately two minutes after disconnecting the mains cable before removing the machine's case.

Perform the following cleaning and maintenance at least every six months:

1. Clean the interior of the machine and the fan grill's net of any dust and stains – for example, with a soft brush and vacuum cleaner.
 - Do not use pressurised air. The stain may become compressed into the grooves of the coolers.
 - Do not use a pressure-washing device.
2. Check the electrical connections of the machine. Clean any oxidised connections, and tighten the loosened ones.
 - Check for the right tension before you start repairing the connections.

NOTE! Remember that the machine may be repaired only by an electrical contractor or installer authorised to perform such operations.

5.3 REGULAR MAINTENANCE

Authorised Kemppi service agents perform regular maintenance by agreement.

Tasks included in regular maintenance:

- Cleaning of equipment.
- Inspection and maintenance of the welding gun.
- Checking of connectors, switches, and control knobs.
- Checking of electrical connections.
- Checking of the mains cable and plug.
- Replacement of damaged or worn parts.
- Calibration testing, with adjustment of the functions and operational values of the machine, if necessary.

6. DISPOSAL OF THE MACHINE



Do not dispose of electrical equipment with normal waste!

In observance of European Directive 2002/96/EC on waste electrical and electronic equipment, and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and taken to an appropriate environmentally responsible recycling facility. The owner of the equipment is obliged to deliver a decommissioned unit to a regional collection centre, per the instructions of local authorities or a Kemppi representative. By applying this European Directive you will improve the environment and human health.

7. ORDERING NUMBERS

Item	Size	Part number
FastMig™ KM 300		6033000
FastMig™ KM 400		6034000
FastMig™ KM 500		6035000
Earthing cable	5 m, 50 mm ²	6184511
Earthing cable	5 m, 70 mm ²	6184711
Cooling device Fastcool 10		606810001
Transport unit PM500		6185291
Gun holder GH 30		6256030

8. TECHNICAL SPECIFICATIONS

FastMig™	KM 300	KM 400	KM 500
Mains voltage, 3~50/60 Hz	400 V, -15...+20%	400 V, -15...+20%	400 V, -15...+20%
Rated power			
60 ED	-	-	25.9 kVA
80 % ED	-	18.5 kVA	-
100% ED	12.9 kVA	16.9 kVA	20.1 kVA
Connection cable/fuse delayed	4 x 6 S, 5 m / 25 A	4 x 6 S, 5 m / 35 A	4 x 6 S, 5 m / 35 A
Loadability 40 °C			
60 % ED	-	-	500 A
80 % ED	-	400 A	-
100% ED	300 A	380 A	430 A
Max. welding voltage	48 V	48 V	48 V
Open circuit voltage	65 V	65 V	65 V
Idle power	25 W	25 W	25 W
Efficiency	87 %	87 %	87 %
Power factor	0,9	0,9	0,9
Storage temperature range	-40 ... +60 °C	-40 ... +60 °C	-40 ... +60 °C
Operating temperature range	-20 ... 40 °C	-20 ... 40 °C	-20 ... 40 °C
Degree of protection	IP23S	IP23S	IP23S

External dimensions				
	Length	590 mm	590 mm	590 mm
	Width	230 mm	230 mm	230 mm
	Height	430 mm	430 mm	430 mm
	Weight	34 kg	35 kg	36 kg
	Voltage supply for auxiliary devices	24 VDC	24 VDC	24 VDC
	Voltage supply for cooling unit	1~, 400 V / 250 VA	1~, 400 V / 250 VA	1~, 400 V / 250 VA

9. WARRANTY POLICY

Kemppi Oy provides a warranty for products manufactured and sold by the company if defects in materials or workmanship occur. Warranty repairs are to be carried out only by an authorised Kemppi Service Agent. Packing, shipping, and insurance are at the orderer's expense.

The warranty starts on the date of purchase. Spoken promises not included in the terms of warranty are not binding on the warrantor.

Limitations of the warranty

The following conditions are not covered under the terms of warranty: defects arising from normal wear and tear, non-compliance with operation and maintenance instructions, overloading, negligence, connection to incorrect or faulty supply voltage (including voltage surges outside equipment specifications), incorrect gas pressure, anomalies or failures in the electric network, transport or storage damage, and fire or damage due to forces of nature. This warranty does not cover direct or indirect travel costs, daily allowances, or accommodation related to warranty service.

The warranty does not cover welding torches and their consumables, feeder drive rolls, and feeder guide tubes.

Direct or indirect damage caused by a defective product is not covered under the warranty.

The warranty becomes void if modifications are made to the machine that are not approved by the manufacturer or if non-original spare parts are used in repairs.

The warranty is voided if repairs are carried out by a repair agent not authorised by Kemppi.

Undertaking warranty repairs

Warranty defects must be reported to Kemppi or an authorised Kemppi Service Agent without delay.

Before a warranty repair is undertaken, the customer must present proof of warranty or otherwise prove the validity of the warranty in writing. The proof must indicate the date of purchase and the manufacturing number of the unit to be repaired. The parts replaced under the terms of this warranty remain the property of Kemppi and must be returned to Kemppi if requested.

After a warranty repair, the warranty of the machine or equipment, repaired or replaced, shall be continued to the end of the original warranty period.

KEMPPI OY

PL 13
FIN – 15801 LAHTI
FINLAND
Tel +358 3 899 11
Telefax +358 3 899 428
www.kemppi.com

KEMPPIKONEET OY

PL 13
FIN – 15801 LAHTI
FINLAND
Tel +358 3 899 11
Telefax +358 3 734 8398
e-mail: myynti.fi@kemppi.com

KEMPPI SVERIGE AB

Box 717
S – 194 27 UPPLANDS VÄSBY
SVERIGE
Tel +46 8 590 783 00
Telefax +46 8 590 823 94
e-mail: sales.se@kemppi.com

KEMPPI NORGE A/S

Postboks 2151, Postterminalen
N – 3103 TØNSBERG
NORGE
Tel +47 33 346000
Telefax +47 33 346010
e-mail: sales.no@kemppi.com

KEMPPI DANMARK A/S

Literbuen 11
DK – 2740 SKOVLUNDE
DANMARK
Tel +45 4494 1677
Telefax +45 4494 1536
e-mail: sales.dk@kemppi.com

KEMPPI BENELUX B.V.

Postbus 5603
NL – 4801 EA BREDA
NEDERLAND
Tel +31 765717750
Telefax +31 765716345
e-mail: sales.nl@kemppi.com

KEMPPI (UK) Ltd

Martti Kemppi Building
Fraser Road
Priory Business Park
BEDFORD, MK443WH
ENGLAND
Tel +44 (0)845 6444201
Fax +44 (0)845 6444202
e-mail: sales.uk@kemppi.com

KEMPPI FRANCE S.A.S.

65 Avenue de la Couronne des Prés
78681 EPONE CEDEX
FRANCE
Tel +33 1 30 90 04 40
Telefax +33 1 30 90 04 45
e-mail: sales.fr@kemppi.com

KEMPPI GmbH

Otto – Hahn – Straße 14
D – 35510 BUTZBACH
DEUTSCHLAND
Tel +49 6033 88 020
Telefax +49 6033 72 528
e-mail: sales.de@kemppi.com

KEMPPI SP. z o.o.

Ul. Piłsudskiego 2
05-091 ZA_BKI
POLAND
Tel +48 22 7816162
Telefax +48 22 7816505
e-mail: info.pl@kemppi.com

KEMPPI WELDING MACHINES

AUSTRALIA PTY LTD
P.O. Box 404 (2/58 Lancaster Street)
INGLEBURN NSW 2565
AUSTRALIA
Tel. +61 2 9605 9500
Telefax +61 2 9605 5999
e-mail: info.au@kemppi.com

Kemppi OY LIMITADA

Av. Pdte. Edo. Frei Montalva 6001-81
Conchalí, SANTIAGO,
CHILE
Tel +56-2-949 1990
Telefax +56-2-949 1991
e-mail: arturo.silva@kemppi.com

ООО КЕМППИ

Polkovaya str. 1, Building 6
127018 MOSCOW
RUSSIA
Tel +7 495 739 4304
Telefax +7 495 739 4305
e-mail: info.ru@kemppi.com

ООО КЕМППИ

ул. Полковая 1, строение 6
127018 Москва
Tel +7 495 739 4304
Telefax +7 495 739 4305
e-mail: info.ru@kemppi.com