

# MPi 220P

**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.



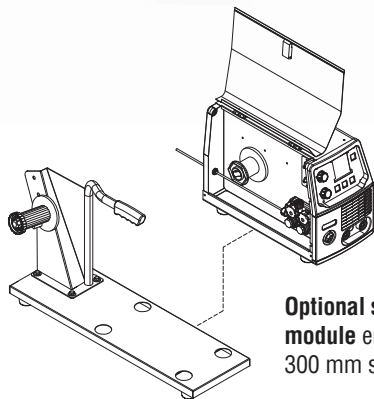
Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

**Excellent arc characteristics!** The MPi 220P offers positive arc starts and an extremely stable arc with minimal spatter on both mixed gases and straight CO<sub>2</sub>.

**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.



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# Specifications (Subject to change without notice.)



| Input Power                    | Welding Mode | Amperage/<br>Voltage<br>Ranges | Rated Output (Duty Cycle) |                 |                 | Max.<br>Open-Circuit<br>Voltage | IP Rating   | Dimensions        | Net<br>Weight |
|--------------------------------|--------------|--------------------------------|---------------------------|-----------------|-----------------|---------------------------------|---|-------------------|---------------|
|                                |              |                                | 100%                      | 60%             | 35%             |                                 |   |                   |               |
| 230 V,<br>1-phase,<br>50/60 Hz | MIG          | 2–200 A<br>15–24 V             | 110 A<br>17.5 V           | 140 A<br>21.0 V | 180 A<br>23.0 V | 35 V                            | IP22S<br><br>H: 365 mm<br>(14.4 in.)<br>W: 237 mm<br>(9.3 in.)<br>D: 548 mm<br>(21.6 in.) | 16 kg<br>(35 lb.) |               |
|                                | Stick        | 5–200 A<br>20.2–28 V           | 100 A<br>24.0 V           | 130 A<br>25.2 V | 170 A<br>26.8 V | 65 V                            |   |                   |               |
|                                | TIG          | 5–200 A<br>10–18 V             | 100 A<br>14.0 V           | 130 A<br>15.2 V | 180 A<br>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<br>for hard wire | “U” Groove Drive Roll<br>for soft wire or<br>soft-shelled cored wire | “V” Knurled Drive Roll<br>for hard-shelled<br>cored wire | Pressure Roll     | Wire Inlet Guide  |
|----------------------------|--|--|--|-------------------|-------------------|
| 0.6/0.8 mm (.023/.030 in.) | <b>156053051</b>                       | —  | —  | <b>156053112*</b> | <b>156090026*</b> |
| 0.8/1.0 mm (.030/.040 in.) | <b>156053109*</b>                      | <b>156053053</b>   | —  |                   |                   |
| 1.0/1.2 mm (.040/.045 in.) | <b>156053052</b>                       | <b>156053054</b>   | <b>156053110</b>   |                   |                   |

\*Included with MPi 220P.

## Ordering Information

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

**Date:** \_\_\_\_\_ **Total Quoted Price:** \_\_\_\_\_

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