

İTECH MIG 350 4R

Full specifications



KEY FEATURES

Our line's most robust and powerful **SKANDI KRAFT iTech 350 4R** 3-in-1 welder suitable for use primarily in industry, metalshops and specialist firms. With the innovative **MIG/MAG AUTO system**, once the material, thickness and wire diameter are entered, the unit selects optimal settings and is ready to go. Semi-Pro welders will never regret the iTech, since they can focus on their technique instead of the settings. It also has a **MANUAL** settings mode for metalshop masters and pro welders. The machine is placed on a sturdy cart with swivelling castors, so 50L cylinders can be carried even in difficult conditions.

The **iTECH MIG 350 4R** comes with an innovative system of air flow through the cooling chamber **NorthernWind (NW)**, boosting the life, durability and duty cycle of the components.

It's equipped with a 4R four-roll feeder. Thanks to the improved feeder design, the wire is fed more smoothly and stable. It can connect 5m MIG torches and also mount a **D300** wire spool. It has a **5" LCD** display, for intuitive and easy operation in 5 languages. It offers a **comfortable**, quiet operating mode (**FAN STOP**) that also saves energy. For welding with **3 methods: (MIG/MAG-AUTO), electrode (MMA) and LIFT-TIG.**

The **iTECH MIG 350 4R** is all about intuitive operation and advanced functionality, for individual adjustment of settings in **PULSE, DUAL PULSE** and **INDUCTANCE** technologies. The unit has a **3-metre all-copper 4x4 [mm²]** 450 V/750 V power cable and a **3-metre all-copper 25 [mm²]** ground cable. The kit includes a 3-metre electrode holder and a **4-metre KD24 torch.**

The **iTECH MIG 350 4R** is ideal for **welding materials with thicknesses from 0.5 [mm] to 30 [mm]:**

- industry (steel structures, pipe welding)
- in the metalshop (welding of machine bodies, welding of installations)
- in a specialist pro workshop (welding of chrome-nickel components, welding of cast iron, welding of aluminium sides and trailers).

PRODUCT DETAILS

- **PULSE and DUAL PULSE** welding, for better transfer of filler material into the weld pool and boosting the quality and strength of the joint. Along with the high even welding current (350 A) powered at 400 V, the machine proves its value when welding thick structural components.
- The welder has a **4 roller wire feeder**, so the wire is fed smoothly and steadily as required, and the redesigned feeder can connect much **longer MIG torches**.
- **MIG/MAG AUTO system** - after choosing the type and thickness of the material and wire diameter, it can auto adjust your welding settings. Welder with an easy-to-read **5" LCD** display, **five selectable languages** and **18** memory channels to save your settings.
- For 4 types of welding: **MIG/MAG AUTO, MIG/MAG, LIFT-TIG** and **MMA**.
- The **FAN STOP** system switches off the fan at idle - so that the welder is quiet when powered up and fully functional, saves energy and attracts less dust. The fan automatically switches on.
- Can connect a **SPOOL GUN** holder (with integrated wire feeder), to ensure better material transfer to the joint.
- **Lamp inside the welder** for easy wire change in the wire feeder.
- **Push** button for quick wire ejection (**inching**).
- Welder on a **sturdy cart** with space for cylinders up to **50L**. A **chain to secure the cylinder** and **hooks** for transporting the machine are included.
- The device adjusts the welding current in the case of the **LIFT-TIG** method after setting the material thickness. In the **MMA** method, the device, together with the material thickness adjustment and intelligent parameter selection, provides the suggested diameter of the electrode to be used.
- **Convenient dials** and a **clear panel** make it easy to set the welder up quickly, even when wearing welding gloves.
- Features **2T** and **4T** options for more comfortably making longer welds.
- **SPOT functions** designed for spot welding. The machine has a preset heat-up time and the operator only sets the welding current. This function is most commonly used in auto repair shops.

- **Functions S_{2T} /S_{4T}** combines two welding techniques. Spot welding, for shielding gas to be discharged before and after welding occurs. In addition, a 2T and 4T function are used together to create the **S_{2T}/S₄** method, for welding to start and finish more precisely.
- It is built with high performance **IGBT** components.
- Gas preheater connector (**36 V**) - using a socket, the regulator can be connected with the preheater or the preheater itself and the gas can be heated to a positive temperature.

MIG/MAG AUTO welding

- The automatic setting of the welder: after specifying the type of material and the wire thickness and diameter, the machine adjusts the welding parameters. This system can be fine-tuned manually in order to adjust the welding current and other parameters.
- **PULSE** welding, for better transfer of filler material into the weld pool, boosting the quality and strength of the weld.
- Choice of **2T/4T**, for more comfort when making longer welds.
- Choice of weld material (**Carbon steel, Stainless steel, Al-Si** - soft aluminium, **Al-Mg** - hard aluminium, **Cu-Si** - **brazing**).

MIG/MAG welding

- **PULSE** welding, for better transfer of filler material into the weld pool, boosting the quality and strength of the weld.
- **2T/4T** selection, which enables longer welds to be produced more comfortably.
- **SPOT** welding functions and **S_{2T}** and **S_{4T}** welding support, i.e. shielding gas before the welding process from a lower current to the base current and finally lowering the current to the crater quench setting and shielding gas flows until the process is completed.
- Welding material selection (**Carbon steel, Stainless steel, Al-Si** - soft aluminium, **Al-Mg** - hard aluminium, **Cu-Si** - **brazing**).
- Selection of **weld material thickness**.
- Determination of wire diameter. In Al-Si and Al-Mg (**range 1.0-1.2 [mm]**), other materials from (**0.8-1.2 [mm]**).
- **Setting of wire feed** speed [m/min].
- **Welding current voltage** setting [V].

- **Adjustment of inductance** \pm [%].
- **Pulse frequency setting** in pulse mode [Hz].
- **Pulse cycle adjustment** [%].

MIG/MAG DUAL PULSE welding

- **Peak feed** speed [m/min].
- **Base wire feed** speed [m/min].
- **Adjustable** double pulse **frequency** [Hz].
- **Adjustable** double pulse **duty** [%].

MMA welding

- **Hot Start** - boosts the start of welding by temporarily increasing the welding current at the start.
- **Arc Force** - adjusts the length of the welding arc, making it possible to reduce or increase the depth of fusion and reduce spatter.
- **VRD** - turns off the arc when the electrode detaches from the material for a safer welding environment.
- **Anti Stick** - easier electrode detachment in the event of sticking.

LIFT-TIG welding

- **Adjustable welding current** [A], once set the welder prompts for the thickness of the sheet metal.
- The **LIFT-TIG** function comes with a **SOFT START** module, for no risk of damaging the electrode when starting the welding process.

Can return to factory settings by holding the "Return" button.

TECH SPECS

POWER SUPPLY PARAMETERS

Power supply: 400 V

Frequency: 50/60 Hz

Idling voltage: 74 V

TECHNICAL PARAMETERS

• MIG welding current: 40-350 A

• MIG welding voltage: 16-31.5 V

• MIG efficiency (at 40°C):

30%/350 A/ 31.5 V

60%/248 A/ 26.4 V

100%/192 A/ 23.6 V

• TIG welding current: 10-300 A

• TIG welding voltage: 10.4-22 V

• TIG efficiency (at 40°C):

30%/300 A/ 22 V

60%/212 A/ 18.5 V

100%/164 A/ 16.6 V

• MMA welding current: 30-300 A

• MMA welding voltage: 21.1-32 V

• MMA efficiency (at 40°C):

30%/300 A/ 32 V

60%/212 A/ 28.5 V

100%/164 A/ 26.6 V

• Feeder: 4 R

• Wire spool diameters: D200, D300

• Maximum spool size: 5 [kg], 16 [kg]

• Wire diameter for use in the welding machine: 0.8/1.0/1.2 [mm].

PHYSICAL SPECS

• Length x width x height of the welder with cart when the unit is folded:

89 × 51 × 81 [cm].

• Length x width x height of packaging, inside set with running gear:

74 × 43 × 90 [cm].

• Weight of unit: welder [net] 49 [kg], in box [gross] 62 [kg]

• Degree of protection of housing: IP21S

• Cooling: fan

ADDITIONAL FUNCTIONS

• 4-roll wire feeder for smooth filler material transfer: yes

• PULSE and DUAL PULSE for better quality welding: yes

• FAN STOP - switches off the fan when not in use: yes

• Connection for quick-connect gas hose (TYPE 21): yes

• Gas heater connection: yes

• SPOOL GUN external wire feeder connection: yes

• VRD voltage reduction and safety improvement: yes

• Arc Force welding arc length control: yes

• Hot Start rapid arc ignition: yes

• Anti sticking electrode: yes

• Cart: yes

Memory channels: 18

WHATS IN THE BOX?

- **SKANDI KRAFT iTech MIG 350 4R** welder with integrated 3-metre 4x4 [mm²] power cable.
- MIG torch MB 24 4-metre with Teflon graphite insert
- Additional blue steel insert 4 m for MB 24 torch for welding with 0.8 -1.0 [mm] wire diameter
- All-copper electrode holder 3 metres, cross section 25 [mm²]
- Wire rollers: for aluminium 2x 1.0-1.2U, for carbon steel 2x 0.8-1.0V
- Wire feeder rollers size 22/10/30 [mm]
- Gas cylinder mounting components: 2 x gas regulator mounting clamps, 2-metre gas hose, spanner, Allen key
- Current pins for torch KD24, MB24 (1x 0.8; 1x1.0; 1x1.0 ALU; 1x1.2 ALU)
- Bushing with spring for guiding the welding wire to the feeder.
- Instructions.

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