













Technical Data: IRON-MIG 303/303P IRON-MIG 303S/303S P

Main Voltage	400 V	200/600 V	Earth Cable	50 mm ²	50 mm ²
Phase	3	1/3	Degree of Protection	IP 23	IP 23
Frequency	50/60 Hz	50/60 Hz	Insulation Class	H	H
No Load Voltage	74 V	79 V	Cooling	Air	Air
Efficiency	85 %	85 %	Work Temperature	40°C	40°C
Current Range	15-320 A	15-320 A	Length/Width/Height (mm)	590x300x435	680x300x435
Wire Feed Rollers	4	4	Weight	34 Kg	42 Kg
Welding Current 35% (40°C)	300 A	300 A			
Welding Current 60% (40°C)	250 A	250 A			
Welding Current 100% (40°C)	200 A	200 A			

The data is measured at an environment temperature of 40 °C

MAIN ACCESSORIES

 <p>TROLLEY MP The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease. Cod. 600343000L</p>	 <p>4 ROLLERS DRIVING KIT Complete kit with 4 rollers driving for 1,0mm and 1,2mm Aluminum wires. Cod. 6014590000 d.1,0mm Cod. 6014610000 d.1,2mm</p>
 <p>SPOOL GUN KIT Ideal for the use of soft wires (aluminum). Cod. 601564000L + 601525000L</p>	 <p>FLUX CORED ROLLERS Cod. 6349800000</p>  <p>SPOOL FLUXED CORED 5Kgs Spool of flux cored no gas wire. Cod. 6085800000</p>
 <p>REMOTE FOOT CONTROL WITH 4M CABLES Cod. 600102000L</p>	 <p>TIG TTS 26 Torch Tig Torch with a professional and robust Torch trigger. Cod. 601294000L</p>
 <p>MIG/MAG TORCH Mig/Mag professional Torch Cod. 6043500000</p>  <p>TORCIA MIG/MAG H2O Mig/Mag professional Torch Cod. 6015140000</p>	 <p>EARTH CLAMP 50MM Earth Clamp with 3m 50mm² rubber cable Cod. 602000001L</p>
 <p>WATER COOLER MPX Cooling System for TIG and MIG/MAG water torch. Cod. 601473000L</p>	 <p>GAS REGULATOR 2 GAUGES Gas Regulator with 2 Gauges (Italian Gas Connection) Cod. 6055900000</p>



high performance machines



IRON-MIG 303 IRON-MIG 303P IRON-MIG 303S IRON-MIG 303SP

Made in ITALY

- Compact lightweight and practical design makes this portable 'go anywhere' 400V 3Phase range of IRON MIG 303 ideally suited for all site-work and workshop applications.
- A large clear user-friendly Digital Screen provides the operator with coherent parameter information.
- All machines are extremely compact, reliable and lightweight, with a built-in wire feeding system for 5 and 15 kg spools.
- The IRON-MIG 303P / 303S P digital operating concept, incorporating Stepless Synergic Technology allowing for simple selection of PULSE MIG/MAG welding for Stainless Steel, Mild Steel, Aluminiums and Cusi 3 Brazing.
- The IRON-MIG 303P / 303S P also include **P.A.W.TM** programs for welding thin material thicknesses from 1 to 2mm.
- The IRON-MIG 303P / 303S P also include **i-Cold PulseTM** that increases the welding speed by 35%.
- The IRON-MIG 303S / 303S P also include **PFC Multi-LinkTM** to operate from any 1/3 Phase input voltage in the world.

For more informations please visit our website www.stelgroup.it
or contact us by info@stelgroup.it / 0444 639525

i-Cold Pulse™



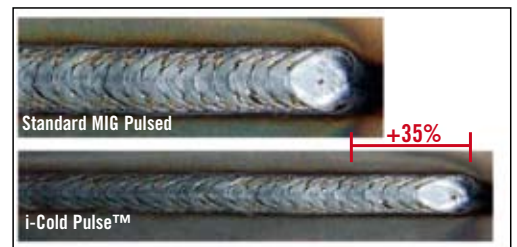
I-Cold Pulse™

Normally pulsing is a “HOT” process. This has always caused problems of metal distortion (in particular thin material) and working speed. Achieving a fast process has been the manufacturer’s challenge of the last years. New processes have developed with many different names under the title SPEED.

What about the HEAT?

This is the real challenge that STEL has taken with the innovative i-Cold Pulse™. Reducing the thermal heat STEL have been able to increase the welding speed by 35%.

The arc is more concentrated and intense granting a better penetration.



ST-Arc™ is the intelligent control of the Short Arc process, capable of handling automatically all variations within the welding process.

The result is a short concentrated and stable arc 100% easier to control. The dynamic cold welding characteristics significantly lower the heat input reducing distortion, spatters, re-working and cleaning plus less weld time.

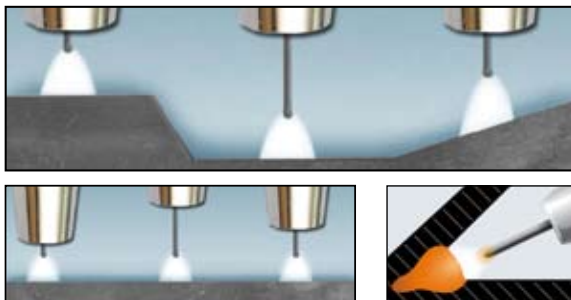
ST-Arc™ is a standard feature of all Stel MIG / MAG Stel welders.



ST-Arc™

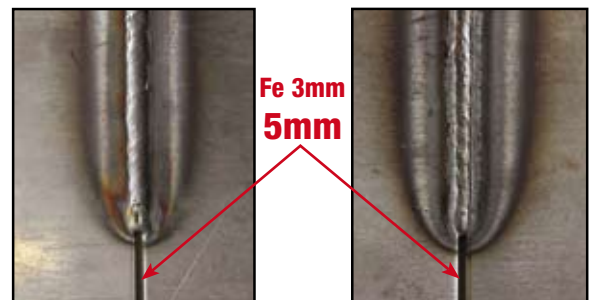
AUTO - COMPENSATION:

Automatically compensates for any variation in welding conditions caused either by irregularities of the workpiece or the movements of the operator’s hand. Ideal for awkward angles.



GAP BRIDGING:

The Short-Arc ST-Arc characteristics of the IRON-MIG welding process is perfect for root passes, or where gaps are needed to be bridged.





UNLIMITED PRECISION

PAW™ is Precision Aluminium Welding. A new intelligent arc welding control on very thin Aluminium thicknesses from 1 to 2mm. The result is a very short and concentrated welding arc using 1.0mm wire with a standard MIG Torch. Therefore, there is no need for expensive push-pull torches, plus the additional cost saving of using smaller wire diameters that cause problematic feeding. (Only for 303P - 303S P)



P.A.W.™

PROGRAMS:

There are 12 programs dedicated to aluminum. Programs are synergic and pulsed. Two PAW™ programs (AlMg5 and AlSi5) are available for thin material thicknesses from 1 to 2mm.

MIG SYNERGIC WIRE LIST 7-12				
AlMg5	1.0mm	Ar100%	PULS	<
AlMg5	1.0mm	Ar100%	DoublePULS	
AlMg5	1.2mm	Ar100%		
AlSi5	1.0mm	Ar100%	PAW	
AlSi5	1.0mm	Ar100%	PULS	
AlSi5	1.0mm	Ar100%	DoublePULS	

PULSE:

Preset synergic pulse programs greatly assists the operator with welding materials such as aluminum.



SHORT ARC:

The PAW™ programs offer a short highly concentrated arc that provide the operator with easy control during welding of thin materials. Weld appearance is excellent with absence of spatters.



ALUMINUM:

Owing to PAW™ technology, the IRON-MIG 303P-SP power source can weld AlMg5 and AlSi5 aluminum wires avoiding the use of expensive push-pull torches and smaller diameter wires.

