



high performance machines



MAX 453 MAX 603 TOP 504 XXM

Made in ITALY

- A large clear user-friendly Digital Screen provides the operator with coherent parameter information.
- The Wire Feed System TOP 504 XXM digital operating concept incorporates Stepless Synergic Technology allowing for simple selection of PULSE MIG/MAG welding for Stainless Steel, Mild Steel, Aluminum and Cusi 3 Brazing.
- The TOP 504 XXM also include **P.A.W.TM** programs for thin material thicknesses from 1 to 2mm.
- The TOP 504 XXM also include **i-Cold PulseTM** increasing the welding speed by 35%.

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

i-Cold Pulse™



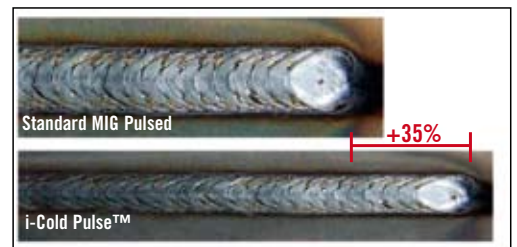
I-Cold Pulse™

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.

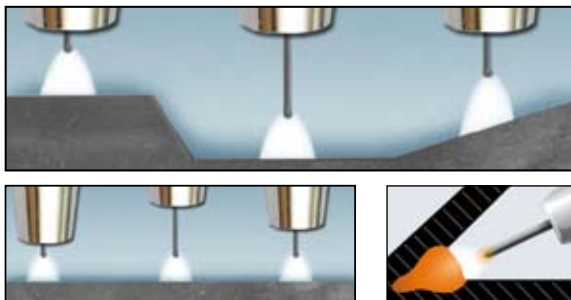
The result is a short concentrated and stable arc 100% easier to control. The dynamic cold welding characteristics significantly lower the heat input reducing distortion, spatters, re-working and cleaning plus less weld time. ST-Arc™ is a standard feature of all Stel MIG / MAG Stel welders.



ST-Arc™

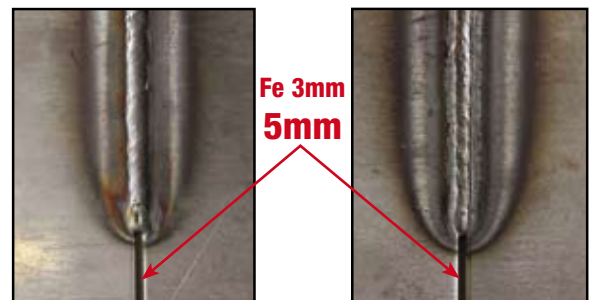
AUTO - COMPENSATION:

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:

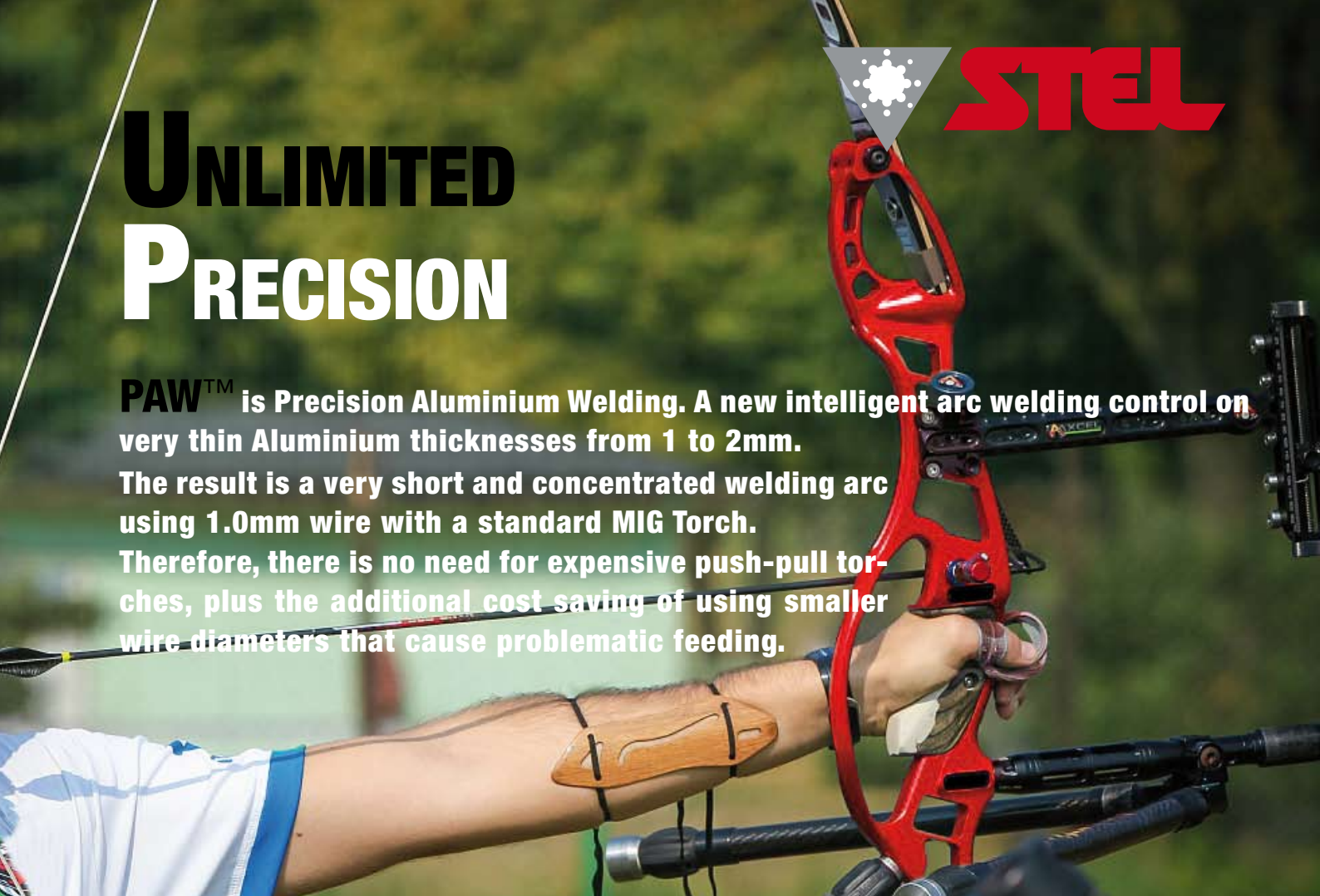
The Short-Arc ST-Arc characteristics of the IRON-MIG welding process is perfect for root passes, or where gaps are needed to be bridged.





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.



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 power source can weld AlMg5 and AlSi5 aluminum wires avoiding the use of expensive push-pull torches and smaller diameter wires.



Technical Data:	MAX 453	MAX 603			
Main Voltage	400 V	400 V	Earth Cable	70 mm ²	70 mm ²
Phase	3	3	Degree of Protection	IP 23	IP 23
Frequency	50/60 Hz	50/60 Hz	Insulation Class	H	H
No Load Voltage	80 V	74 V	Cooling	H2O	H2O
Efficiency	87 %	90 %	Work Temperature	40°C	40°C
Current Range	4-450 A	4-600 A	Length/Width/Height (mm)	1040x500x1405	1040x500x1405
Wire Feed Rollers	4	4	Weight	135 Kg	135 Kg
Welding Current 35% (40°C)	450 A	550 A			
Welding Current 60% (40°C)	430 A	500 A			
Welding Current 100% (40°C)	350 A	4500 A			

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

Technical Data wirefeed 4 rollers		
	Roll Diameter Material Motor Pressure Unit Power Main Voltage Max. wire speed Euro Connector	37 Aluminum DC Motor perm. magnet 2 (Front and Rear) 100 W 24 V / 42 V 20 m/min Brass Hexagonal
		<ul style="list-style-type: none"> • Rollers changing without tools • Robust • 4 Roll Feed • 2 Pressure Unit • Encoder Regulation • Wirefeed Made in Switzerland

MAIN ACCESSORIES



KIT MAX 453/603
 Full combo include:
 -Power Source
 -Water Cooler
 -Interconnecting Cables H2O 5m
 -Trolley
 Cod. KIT 453
 Cod. KIT 603



WIRE FEED ROLLER
 Cod. 6360600000 d.1,0-1,2mm Fe
 Cod. 6360900000 d.1,0-1,2mm Alu



TROLLEY MP
 The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.
 Cod. 600343000L



EARTH CLAMP 70MM
 Earth Clamp with 3m 50mm² rubber cable
 Cod. 607010001L



WATER COOLER MPX
 Cooling System for TIG and MIG/MAG water torch.
 Cod. 601473000L



TIG TTS 26 Torch
 Tig Torch with a professional and robust Torch trigger.
 Cod. 601294000L



MIG/MAG TORCH H2O
 Mig/Mag professional Torch
 Cod. 6015140000 4m Water



GAS REGULATOR 2 GAUGES
 Gas Regulator with 2 Gauges (Italian Gas Connection)
 Cod. 6055900000