

CITOPULS III 420/520

CITOSTEEL III 420/520

Boost your welding performance
and save energy



CITOPULS III / CITOSTEEL III

CITOPULS III / CITOSTEEL III are the only product on the MIG/MAG welding market offering superior quality welding and advanced welding processes with a simple interface at a competitive price. Moreover CITOPULS III is designed in a modular system to fit with all users' requirements.



Superior quality welding with advanced processes and features

- New inverter generation offering 30% less primary consumption regarding conventional equipment. Due to its performant efficiency you are saving significant amount on your energy cost
- More than 100 synergic lines for any base material
- Full range of processes:
 - Standard MIG/MAG
 - Pulsed MIG/MAG
 - Special arc transfer
 - MIG brazing
 - MMA coated electrodes
 - Gouging (*up to 6.3 mm diameter electrode*)
- Powerful installation up to 500 A at 60%
- Full A1 automatic interface.
This level of synchronization does not require an additional card, for simpler automatisaton
- Storage of 99 welding programs (*with expert wire feeder DMU P500 or advanced remote control RC JOB*)
- Parameter locking with a digit code (*with expert wire feeder DMU P500 or advanced remote control RC JOB*).
When this function is activated, the welder can still fine-tune the parameters in a +/- 20% range
- Call programs by trigger torch



The CITOPULS/CITOSTEEL high tech MIG/MAG equipment fits perfectly with the needs of the most demanding welding applications in various segments. Whatever your requirements, you will find with the CITOPULS/CITOSTEEL a superior welding quality with advanced processes with simple settings through an easy to use interface.

A user friendly interface for a really easy to use front panel

- Power source and wire feeder

A modular concept to fit with all users' requirements

Specify and build your own installation:

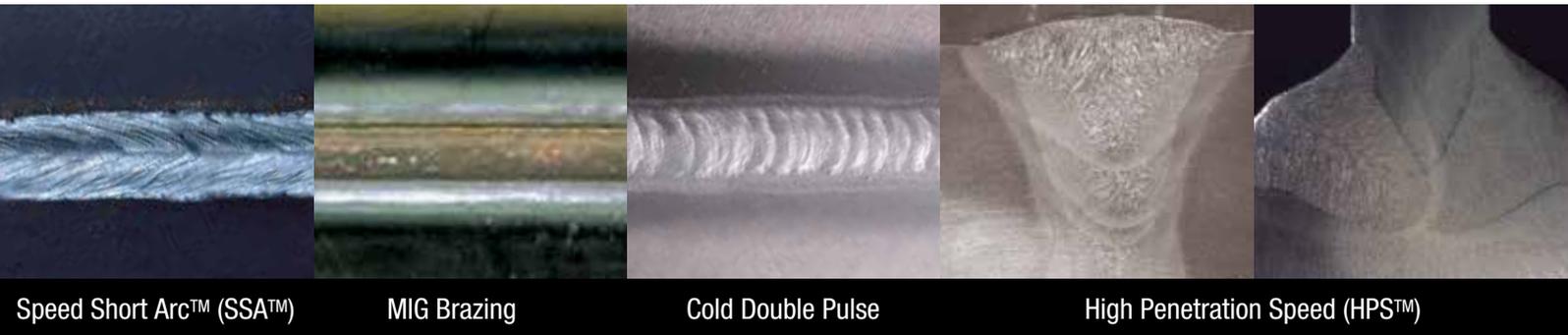
- Power source
- Wire feeders
- Cooling unit
- Harnesses (*up to 50 m for shipbuilding applications*)
- Trolleys for the installation and the wire-feeder
- Remote control
- Torches (*standard, with potentiometer, push-pull, automatic...*)

More benefits for the user

- Small machine for easier access
- Light installation (*34 kg for the power source*)
- Compatible with motor generator
- A powerful 4-wheel feeder unit



Focus on advanced processes



Speed Short Arc™ (SSA™)

Speed Short Arc™ provides a transfer mode using short circuits in a wire speed domain usually governed by globular conditions.

The current values used in this mode are very different from those used in conventional “short arc” operation. Faster wire speeds require a medium current together with a large peak current in order to form and detach the droplet more quickly.

High Penetration Speed (HPST™)

HPS (High Penetration Speed) is welding characteristic available with the high range of MIG/MAG inverter power sources manufactured by Air Liquide Welding. Using welding current usually given by Spray Arc behaviour, HPS arc transfer is combining two different main advantages:

- Provides lower voltage and so lower energy,
- A very accurate and dynamic regulation of the welding parameters.

This association is able to carry out very high productivity with the optimal welding performance.

Puls

Puls mode is a Puls current waveform offering a very stable arc without any spatters. This is the best to weld thin sheets in stainless steel and aluminium. Moreover, you will keep high performance whatever your welding position.

Soft Silence Pulse™ (SSP™)

This is a pulse transfer with a special waveform producing a soft and silent arc. The behavior of the Soft silent puls is very suitable for stainless steel application request the best wetting possible.

Silence because the noise of the arc is divided by two regarding a normal puls mode what can be really appreciated when you have to weld in a confident area.

Moreover the stability given by this transfer allows to weld in all positions and especially in vertical up without weaving when it is associated to a sequencer welding cycle.

Sequencer

The sequencer or cold double Puls produces very high quality welds on thin material while avoiding distortion.

The operating technique is made easier due to good control of the weld pool even on badly-prepared sheets. This sequencer mode automatically chains arc and cold arc regimes together.

The sequencer is available within flat or Puls current.

MIG Brazing

MIG brazing appeared in the late 1990’ s as a better replacement for flame brazing.

Since this time, it has gone from strength to strength and has become an essential process in automobile construction.

The use of digital technology further increases the performance of this process both from the point of view of the quality of the joint produced, the productivity obtained and also the preservation of coatings applied to steel sheets for corrosion protection.

Which process in which machine – overview table

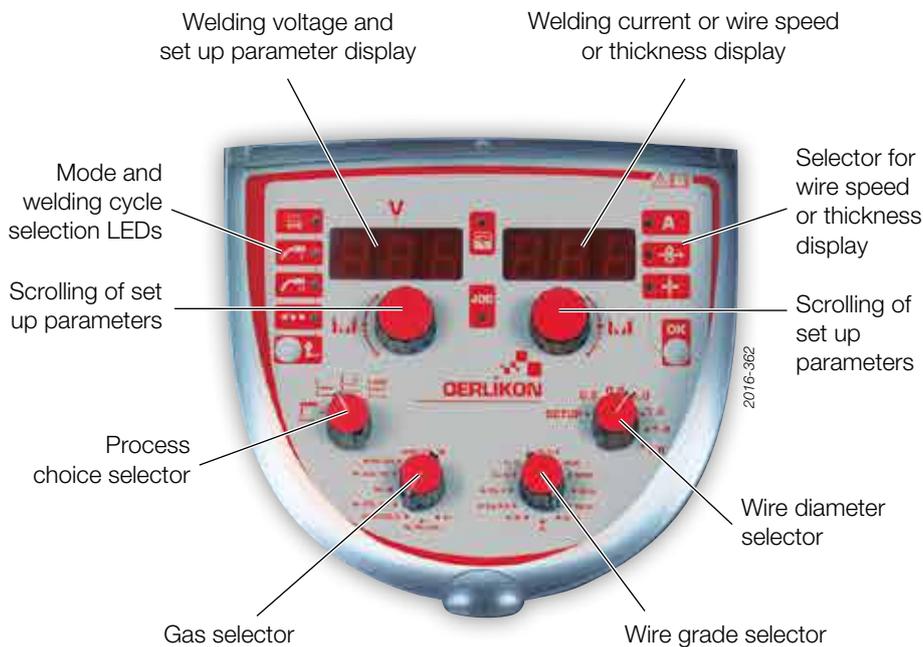
	CITOSTEEL III 420	CITOSTEEL III 520	CITOPULS III 420	CITOPULS III 520
SSA (Speed short Arc)	✓	✓	✓	✓
HPS (High Penetration Speed)	✓	✓	✓	✓
PULS			✓	✓
SSP (Soft Silent Puls)			✓	✓
SEQUENCER	✓	✓	✓	✓
MIG BRAZING	✓	✓	✓	✓

Front panels are easy to understand and use

CITOPULS/CITOSTEEL power source and wire feeder have been designed to improve welding processes. They are built with a user interface designed for a really easy to understand and to use front panel.



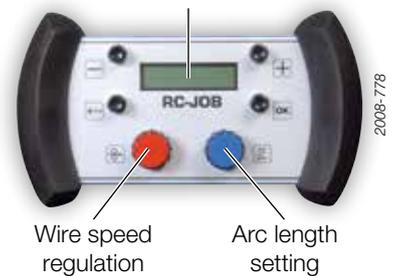
Power source



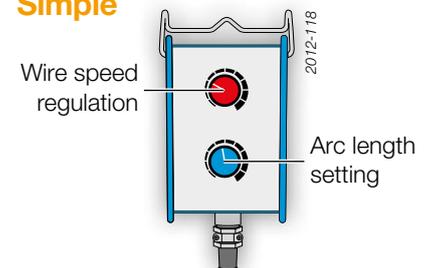
Remote control

RC-JOB

Program selection and advance parameters display and buttons

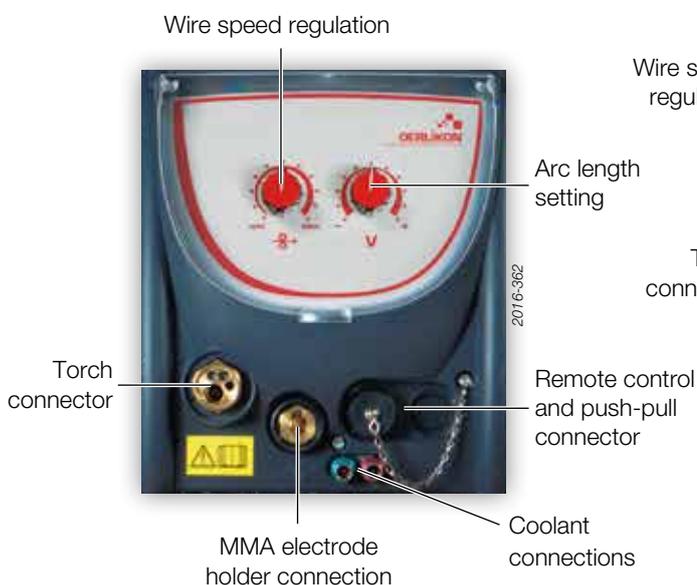


Simple

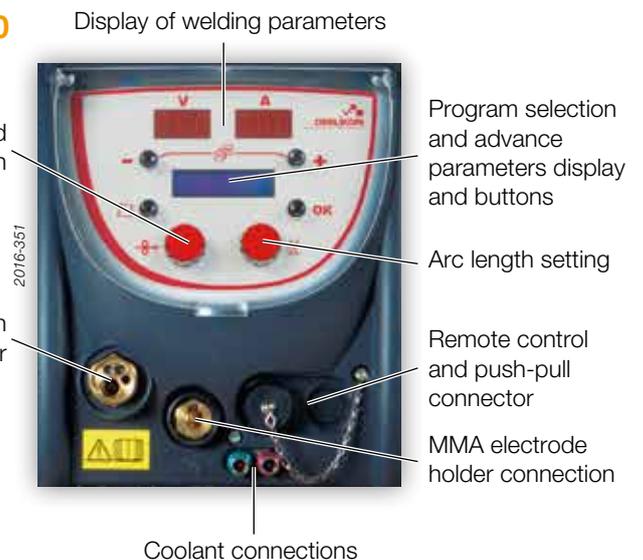


Wire feeders

DMU P400



DMU P500



Technical characteristics



Power source	CITOPULS III 420 CITOSTEEL III 420	CITOPULS III 520 CITOSTEEL III 520
PRIMARY		
Power supply – 3 Phases - 50/60 Hz	400 V (+ 20% / - 20%)	
Maximum primary consumption (100%)	26 A	33,9 A
Temporised fuses	25 A	32 A
Power factor	0.96	0.94
Efficiency	87%	89%
SECONDARY		
Open circuit voltage	73 V	
Welding range	15 A - 420 A	15 A - 500 A
Duty cycle 60%	420 A*	500 A
Duty cycle 100%	350 A	450 A
APPLICATION		
Processes	MIG-MAG / Speed Short Arc™ / MIG-MAG pulsed / High Penetration Speed (HPS) / Cold Double Pulse / MIG Brazing / MMA / Gouging / Soft Silent Puls (SSP)	
Programs	99 (with expert wire feeder or RC JOB)	
GENERAL		
Standard	EN 60974-1 - EN 60974-10	
Protection index	IP 23	
Dimensions (l x w x h)	720 x 295 x 525 mm	
Weight	34 kg	40 kg

Wire feeder	DMU P400	DMU P500 expert
Rollers	4 drive rollers	
Wire speed	1 to 25 m/min	
Wire Ø - Carbon steel - Stainless steel	0.6 / 0.8 / 1.0 / 1.2 / 1.4 / 1.6 mm	
Wire Ø Cored wires	1.0 / 1.2 / 1.4 / 1.6 mm	
Wire Ø Aluminium	1.0 / 1.2 / 1.4 / 1.6 mm	
Regulation	2 potentiometers	2 encoders
Additional feature	-	Program management
Display	-	3 LCD displays
GENERAL		
Protection / Insulation	IP 23S - H	
Standards	EN 60974-5 - EN 60974-10	
Dimensions (l x w x h)	265 x 590 x 383 mm	
Weight	17.5 kg	

Cooling unit	COOLER III
Cooling power	1.3 kW
Maximum pressure	4.5 bar
Dimensions (l x w x h)	720 x 280 x 270 mm
Weight	16 kg

* CITOSTEEL III 420 (420A @ 40%)

To order

The modular concept of CITOPULS III / CITOSTEEL III allows you to build the perfect configuration for your requirement. From offshore & shipbuilding to boiler makers, train production and small workshops.



1 Power sources



420 A @ 60 %	CITOPULS III 420	W000383663
500 A @ 60 %	CITOPULS III 520	W000383664

420 A @ 60 %	CITOSTEEL III 420	W000383618
500 A @ 60 %	CITOSTEEL III 520	W000383619

2 Cooling unit



COOLER III	W000273516
Safety device for cooler	W000376539

3 Wire feeders



Standard

Expert

DMU P400 (Standard)	W000275265
DMU P500 (Expert)	W000275915

- 100 programs
- possibility to lock welding parameters
- LCD display

4 Trolley for installation



TROLLEY II	W000383000
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5 Trolley On site



Trolley On site	W000372274
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6 Trolley for wire feeder



TROLLEY WF II	W000275908
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7 Support for wire feeder in vertical suspension



W000377985

8 Harnesses

Length	Air	Water	
		Standard	Aluminium
2 m	W000275894	W000275898	W000371044
5 m	W000275895	W000275899	W000371045
10 m	W000275896	W000275900	W000371175
15 m	W000275897	W000275901	W000371174
25 m	W000276901	W000276902	W000371239
30 m	W000371246	-	-
40 m	W000371245	-	-
50 m	W000371244	-	-



9 Push-pull Puls II electronic circuit



Push-pull puls II	W000275907
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Allowing to connect a push-pull torch or gun.

10 Flowmeter to measure gas flowrate

Flowmeter

W000275905



11 Remote control



RC JOB (10 m)	W000273134
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RC SIMPLE (10 m)	W000275904
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12 Anti-dust filter for power source protection

W000373703



13 Aluminium welding kit

ALUKIT DMU 1.0-1.2	W000277622
ALUKIT DMU 1.2-1.6	W000277623

A composition of wire guides and rollers for perfect aluminium welding



www.oerlikon-welding.com

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