DIGISTEEL -S RANGE

355S · 425S · 505S

SAF-FRO®

COMPLETE SOLUTION FOR INDUSTRY

DIGISTEEL -S RANGE

Reliable workhorses are coming. They are as solid as always, more convenient than ever, and superbly productive. These products will help you get more things done. Based on modern inverter technology, now which separate wire feeders. This is another, decisive step into the future of professional welding. With a specially designed, rugged construction, which is subjected to a large variety of tests, they are ready to work in even the most demanding environmental and production conditions. The devices are dedicated especially for heavy-fabrication, structural, transportation, shipbuilding and off-shore industries.

The design of **DIGISTEEL** series is the one that truly stands out. It is ergonomic and efficient in every detail. Various configuration systems, separated wire feeding units, intuitive display interface (7″ color TFT), dedicated accessories, and many other features will meet all your industrial welding needs while enhancing your capabilities.

DIGISTEEL -S RANGE

Digisteel 355S
350A@50%

Digisteel 425S
420A@100%

Digisteel 505S
500A@60%

INPUT

OUTPUT

COOLARC® 26

WF 52D

WF 56D

OUTPUT

DIGISTEEL -S RANGE is a brand new range of SAF-FRO products based on the latest inverter platform, combining modularity, ease of use and optimal **MIG/MAG** or **MMA** welding performance with excellent power cost efficiency.

Three power sources: **355S, 425S** and **505S** with a choice of separate wire feeders, standard **WF 52D** for basic use, or the advanced **WF 56D** for more demanding applications, helps customer to fulfill every possible welding needs.

All **DIGISTEEL -S** have the option of water cooling by simply adding the new **COOLARC® 26**.

WARRANTY
3
YEARS

TRUE HD
HEAVY DUTY TEST

ECO FRIENDLY WELDING & CUTTING

CHOOSE SAF-FRO FOR COMPLETE SOLUTION FOR INDUSTRIAL USERS WITH NEW HEAVY DUTY DESIGN

NEW ERGONOMIC DESIGN

Simple navigation
also when using welding gloves

Power Source water cooled ready
(cooler COOLARC® 26 as option)

Practical handle *for effortless gripping even with gloves and safe movement of the machine*

Cable Management System *(option) For easy transportation of the whole welding system even with very long connection cable*

Rotatable wire feeder
Swivel on the power source enabling rotation of the wire feeder and setting it in any position

Heavy duty undercarriage

- Extremely reliable and stable, passed incline stability tests on 15°
- Low gas cylinder entree makes loading very easy
- Quick and easy securing of the shielding gas cylinder

Rubber bumpers *protecting feet and **4 lifting eyes** for easy hook-in and safe transportation*

TRUE RELIABILITY

Cable connections on front (in standard) and **back rear side** (in option)
All cable connections can easily be made without tools

Practical, big storage locker inside the power source
with key lock, internal lights, for accessories like gun, gloves, rolls, contact tips, etc.

Large wheels for easily effortlessly overcome obstacles such as cables or thresholds

Very solid, stable, metal made construction

Intermediate hose packages
Heavy-duty protective hose and military-quality plugs
Strain reliefs on both ends to keep connections well protected
A wide range of lengths to choose (up to 30 m), water or air

RELIABLE WORKHORSES

High duty cycle 420A/100% (425S & 505S)

- High production efficiency
- Digital welding current control
- True HD tested – made for the harsh environmental conditions

Inverter engine technology – ECO Friendly

- Lower power consumption thanks to high efficiency – energy cost saving
- Automatic power-saving modes (standby/shutdown function)
- Generator ready

SAF-FRO Industrial design – ready to use anywhere

- Safety class IP23, potted PCBs and no structural plastics
- 3 Year full parts and labor warranty

TRUE HD
HEAVY DUTY TEST

ECO FRIENDLY WELDING & CUTTING

WARRANTY 3 YEARS

Easy maintenance and servicing
Easy access to all components inside
Software update via laptop or USB (WF 56D)

Intelligent F.A.N. (Fan As Needed) in the inverter
Variable speed controlled fan (energy-saving)
Low pollution and quiet fan noise

AIR FLOW

Cooling tunnel design
– components arranged to protect against dust and dirt

OPTIMIZED ERGONOMICS

Lifting eye – crane suspension
For vertical and suspension operation
For safe and easy transportation

Gun Holder: *always at hand, ready to work*

Front UI protection cover
keep your UI safe

Dust-proof wire spool cover
Inspection window indicates level of wire spool
Simple and comfortable spool change
New locking system – spool cover stays always closed

Professional wire feeding system
Four driven wire feed rolls
Excellent wire feeding on every material
Permanent internal lights
Wire inching gas test toggle switch

Big wheels
as standard for mobility

Flowmeter for shielding gas flow setting (option)
Precise adjustment directly on site
Practical especially with long hose packages

Full access for wire spool installation

STATE OF THE ART TECHNOLOGY IN WIRE FEEDING

Professional wire feeding system – robust and precise

- 4 individually driven rolls for extremely stable wire feeding for various wire types
- Aluminum housing for a long service life
- Big roll diameter (37 mm) for optimal wire feeding
- Simple, tool-free roll change
- Factory-fitted with rolls for 1.0 mm and 1.2 mm steel and stainless steel
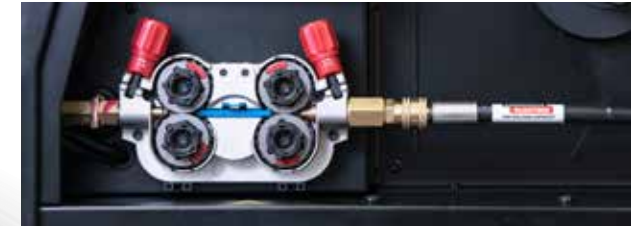
Connection for drum feed (optional adapter).
Less need to change wire spools saves time

Wire feeder pressure set-up

Steel	
Stainless steel	3 ÷ 5
Braze	
Flux cored	2.5 ÷ 3.5
Aluminium	1.5 ÷ 2.5

	Steel
3 ÷ 5	Stainless steel
	Braze
2.5 ÷ 3.5	Flux cored
1.5 ÷ 2.5	Aluminium

Individually adjustable contact pressure for the front and rear roll pair
Differently set-up for aluminium, steel, stainless steel, braze, flux cored wire
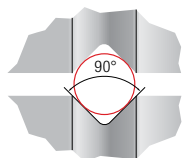
V-groove
for stainless steel, steel
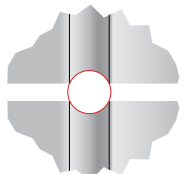
U-groove for aluminium
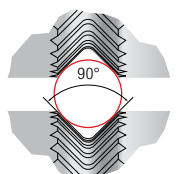
V-groove, knurled for flux cored wire

Color-coded for wire diameter differentiation

New locking system, quick exchange of roll and wire guides
Simple, tool-free roll change
– just few steps

1 Unlock the roll fastener

2 Unlock pressure arm

3 Exchange the roll

DESIGNED TO ENHANCED YOUR WELDING CAPABILITY

INNOVATIVE INTUITIVE INTERFACE

- Two controls, one button for easy navigation
- Icon language for key commands
- Easy process and settings selection
- ARCFX™ – joint visualization
- Work point in material thickness (mm) / WFS / A
- Locking function / Limits / Memories / Jobs
- Interface available in languages: English, German, French, Polish, Finnish, Spanish, Italian, Russian, Dutch, Romanian, Slovakian, Hungarian, Czech, Turkish, Portuguese

EASY COMMUNICATION

NEW

7" COLOR DISPLAY!

Auto **AUTO-SETTINGS**
Preset parameters to increase productivity

USB CONNECTIVITY
Easy software update & diagnostics, weld log for quality monitoring

MORE FUNCTIONS & FEATURES

NEW **SPEAKER**
Product operation (adjusting the encoders or pressing the button) and errors signalled by a sound.

NEW **NEW ENCODERS**
for more precise adjustment

NEW **CLOCK & CALENDAR**
Simple welding quality monitoring as weld log data recording on USB.

Simple navigation also when using welding gloves

www.saf-fro.com

STANDARD USER INTERFACE

BASIC SETTINGS SIMPLE IN USE

User memory programs & welding process change:

- Simple and quick selection by pressing the button of 4 welding programs stored in user memory or 3 welding processes (GMAW, FCAW, SMAW)
- LEDs showing the selected process

Quick and easy access to the most commonly used welding parameters:

- **Arc Controls** (depend on the welding program)
- Torch trigger mode **2-step / 4-step**
- Wire Feed Speed Run-in function
- **Burn-back time**

NEW

SYNERGIC Capability
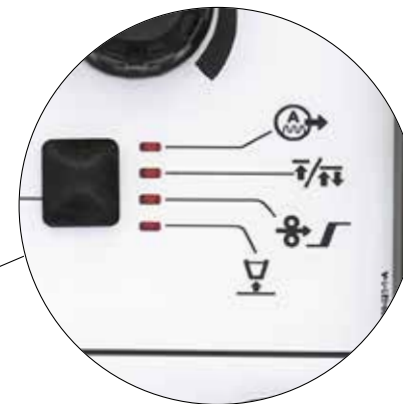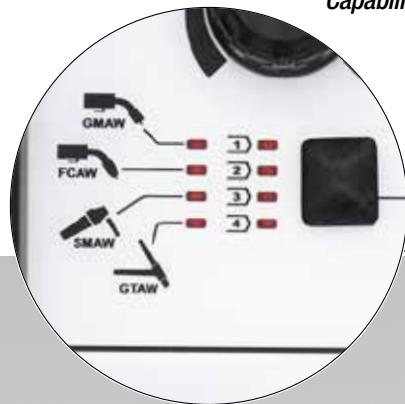
WF 52D

Welding flowchart for easiest setting of all welding parameters

LF 56D VS LF52 D

Different feeders for different needs

LF 56D	Functions and features	LF 52D
7'' Color TFT	UI type	LED's
✓	Speaker	–
✓	Clock and calendar	–
✓	ARC™FX (work point in A/mm)	–
✓	Display view configuration	–
✓	Auto settings	–
49	Memory / Jobs	(3+4)
✓	Limits	–
✓	Locking function	–
✓	Languages selection	–
✓	USB connectivity	–
✓	Media files (Support)	–
✓	Weld logs / History	–
✓	Cross-switch gun	–
✓	Push-Pull gun	–
✓	A/B procedure	–
✓	Quick triger	–
✓	Software version	✓
✓	Factory reset	✓
✓	Arc Control	✓
✓	2T/4T Gun mode	✓
✓	Spot welding	✓
✓	Gas purge test	✓
✓	Cold Inch test	✓
✓	Preflow /Postflow time	✓
✓	Run-in WFS	✓
✓	Start procedure	–
✓	Crater procedure	✓
✓	Burnback time	✓
✓	Hot Start (SMAW)	✓
✓	Arc Force (SMAW)	✓

WELDING PROCESSES

	GMAW / FCAW	Synergic	SMAW	CAG
WF 56D	✓	✓	✓	✓
WF 52D	✓	✓	✓	✓

COOLARC® 26

More functions and features

(Back side view)

Built-in handle
for easy transportation

Cooler fully controlled by power source:
AUTO/ON/OFF for better energy savings and extended service life

Coolant filter
keep coolant clean

LED lights inside reservoir
for better visibility of the coolant level

Flow sensor inside
for gun protection

MAXIMUM LIQUID LEVEL

MINIMUM LIQUID LEVEL

COOL ARC® 26

⚠ WARNING

Simple Connection and Easy Installation

New **COOLARC® 26**
cooler fully controlled
by power source

Cooler Menu is available
when cooler is connected

Settings: 3 Modes of operation available:
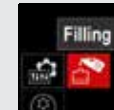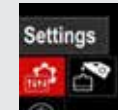
1. AUTO
2. OFF
3. ON
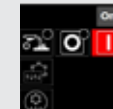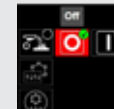
Filling Procedure
step by step detail filling instruction

0 A
0.0 V
11.55 A
29.5 V

PREMIUM MIG WELDING GUNS – LINCGUN® PROMIG™

Nylon base with a fibre glass compound swan neck insulation

Water cooled swan necks

NEW

Mono-bloc nozzle: double nozzle seat insulation with PTFE and silicon glass

NEW

Ergonomic, flexible ball joint handle

TESTED APPROVED &TRUSTED ★★★★★

DOUBLED WARRANTY ✔

NEW

Special handle construction with air pockets which insulate the handle from the heat and extend the life of the gun

NEW

Unfailing power cables designed and engineered to withstand over 1 million bends

NEW

Additional strengthening ring protecting the swan neck against mechanical damage

Firm grip handle, two sizes

SMOOTH WIRE FEEDING ENSURES CONTINUOUS WELDING

Special liners made of higher tensile raw materials produce stiffer liners, provide less friction and last longer

Reliable trigger tested in harsh conditions

AIR-COOLED MODELS

WATER-COOLED MODELS

		LG PROMIG 300	LG PROMIG 400	LG PROMIG 330W	LG PROMIG 400W	LG PROMIG 500W
Duty cycle	CO$_2$	300 A @ 60%	400 A @ 60%	330 A @ 100%	400 A @ 100%	500 A @ 100%
	M21	270 A @ 60%	370 A @ 60%	300 A @ 100%	370 A @ 100%	450 A @ 100%
Wire diameter options		1.0-1.2 mm	1.0-1.6 mm	0.8-1.0 mm	1.0-1.2 mm	1.0-1.6 mm
Original equipment	Contact tip	1.2 mm steel	1.2 mm steel	1.0 mm steel	1.2 mm steel	1.2 mm steel
	Nozzle	Ø 16 mm	Ø16 mm	Ø 14 mm	Ø 16 mm	Ø 16 mm
Handle size, other feature		Large	Large	Small	Small	Large
Typical application		Vessel, manufacture, steel structures, boiler making, structural steelwork	Thick plates, heavy duty welding when water cooling is not possible	Precision and high-intensity applications	Intensive applications such as boiler making, structural steelwork, mechanical welding	Thick plates, heavy duty welding
Reference						
3 m		**W000345066-2**	**W000345072-2**	**W000345063-2**	**W000345069-2**	**W000345075-2**
4 m		**W000345067-2**	**W000345073-2**	**W000345064-2**	**W000345070-2**	**W000345076-2**
5 m		**W000345068-2**	**W000345074-2**	**W000345065-2**	**W000345071-2**	**W000345077-2**

LGS2 MIG GUNS

Simple and reliable, this range is adapted to the most common applications.

Wear parts compatible with the most common standard in Europe.

Easy pivoting handle.
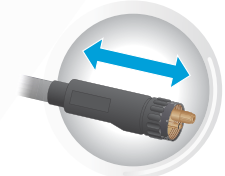
Extra length rear cable support ensures smooth and consistent wire feeding.

Is the European norm requirement for MIG guns.

Extra-flexible cable.

Choose your gun

Rating calculated using CO_2

▬	Air cooled
▬	Water cooled
▬	Dedicated guns

Series	Size	Rate	200A	230A	250A	270A	330A	350A	420A	500A
LGS2	250G	60%	▬▬	▬						
	240G		▬▬	▬▬						
	360G		▬▬	▬▬	▬▬	▬				
	505W	100%	▬▬	▬▬	▬▬	▬▬	▬▬	▬▬	▬▬	▬

TO ORDER

3 m	4 m	5 m
W10429-25-3M	W10429-25-4M	W10429-25-5M
W10429-24-3M	W10429-24-4M	W10429-24-5M
W10429-36-3M	W10429-36-4M	W10429-36-5M
W10429-505-3M	W10429-505-4M	W10429-505-5M

MODEL		AIR COOLING			WATER COOLING
		LGS2-250G	**LGS2-240G**	**LGS2-360G**	**LGS2-505W**
Duty cycle (CO_2 shielding gas)		230 A @ 60%	250 A @ 60%	330 A @ 60%	500 A @ 100%
Applications		Thin plates, light fabrication	Thin plates, light fabrication	Vessel manufacture, steel structures	Heavy duty, high production
Wire diameter		Up to 1.2 mm	Up to 1.2 mm	Up to 1.6 mm	Up to 2.4 mm
Original equipment	Contact tip	1.0 mm	1.0 mm	1.2 mm	1.2 mm
	Conical nozzle	15 mm	12.5 mm	16 mm	16 mm

PREMIUM ARC PERFORMANCE

- **ARC INITIATION** – Repeatable arc ignition with outstanding arc characteristics.
- **ARC STABILITY** – Excellent arc stability, ensuring a smooth droplet transfer, with reduced spatter.
- **ARC DYNAMICS** – Rapid parameter adjustment allowing variability under welding conditions.
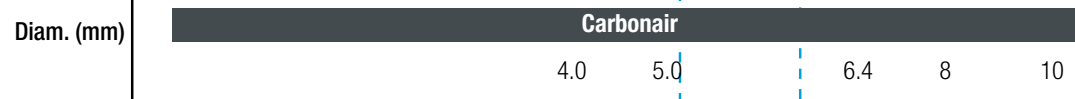
MIG/MAG Wire

Diam. (mm)		355S	425S	505S
1.6	Aluminium: 4043 & 5356 / Metal Cored / Steel: SG2, SG3			
1.4	Metal Cored / Steel: SG2, SG3			
1.32	Steel: SG2, SG3			
1.2	Aluminium: 4043 & 5356 / Metal Cored / Rutile / Stainless Steel: LNM / Steel: SG2, SG3			
1.0	Copper: CuSi3 / Metal Cored / Rutile / Stainless Steel: LNM / Steel: SG2, SG3			
0.8	Copper: CuSi3 / Stainless Steel: LNM / Steel: SG2, SG3			

40A   120A   180A   250A   350A   420A   500A

Stick Electrodes

Diam. (mm) — Rutile (6013) & Basic (7018)

2.0   2.5   3.2   4.0   5.0   6.3

Gouging Electrodes

Diam. (mm) — Carbonair

4.0   5.0   6.4   8   10
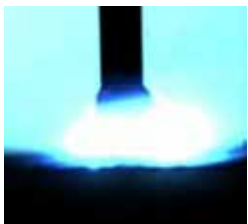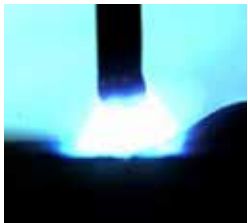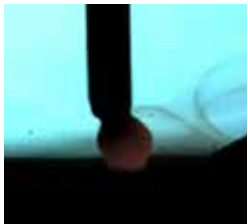
Processes

GMAW
FCAW-G
FCAW-S
SMAW
CAG

Welding of:

Steel
Stainless Steel
Low Alloy Steel
Aluminium
MIG Brazing

CONNECTIONS CONFIGURATION

STANDARD

Connection of the intermediate hose package in **front** of the power source

OPTIONAL

Connection of the intermediate hose package on the **back** of the power source

	Item type	Item desrciption	Item # (Air)	Item # (Water)
1	Machine	CITOSTEEL 355S	W000404457	
		CITOSTEEL 425S	W000404458	
		CITOSTEEL 505S	W000404459	
2	Hose package	Air 1 m	K14198-PG [1]	–
		Air 3 m	K14198-PG-3M	
		Air 5 m	K14198-PG-5M	–
		Air 10 m	K14198-PG-10M	–
		Air 15 m	K14198-PG-15M	–
		Air 20 m	K14198-PG-20M	–
		Air 25 m	K14198-PG-25M	–
		Air 30 m	K14198-PG-30M	–
		Water 1 m	–	K14199-PGW [1]
		Water 3 m	–	K14199-PGW-3M
		Water 5 m	–	K14199-PGW-5M
		Water 10 m	–	K14199-PGW-10M
		Water 15 m	–	K14199-PGW-15M
		Water 20 m	–	K14199-PGW-20M
		Water 25 m	–	K14199-PGW-25M
		Water 30 m	–	K14199-PGW-30M
3	Feeder	WF 52D	W100000176	
		WF 56D	W100000177	
4	Cooler	Coolarc® 26	–	K14182-1
5	MIG gun	LG PROMIG	see accessoriess	
		LGS2		
6	Option	Cable Management KIT	K14201-1	
7	Option	Gas flow meter KIT	K14175-1	
		Output connection KIT (355S)	K14196-1	
8	Option	Output connection KIT (425S / 505S)	K14202-1	
9	Option	Water connection KIT	–	K14208-1 [2]

[1] only for connection on the back and requires the installation of the option 8
[2] option requires only for water hose package longer than 1 m

ACCESSORIES

		DIGISTEEL		
		355S	425S	505S
		W000404454	W000404455	W000404456
WF 52D	W100000176	•	•	•
WF 56D	W100000177	•	•	•
Coolarc® 26	K14182-1	•	•	•
Freezcool 9.6l	W000010167	•	•	•
Output socket connection kit (355S)	K14196-1	•	–	–
Output socket connection kit (425S / 505S)	K14202-1	–	•	•
Cable management kit	K14201-1	•	•	•
Gas supply heater kit	K14176-1	•	•	•
Ground cable 400A – 70 mm² – 5 / 10 / 15 m	GRD-400A-70-xM*	•	–	–
Ground cable 600A – 95 mm² – 5 / 10 m	GRD-600A-95-xM*	•	•	•
Remote control RC-7 advanced	K14203-1	•	•	•
Intermediate hose package AIR				
Cable pack 5-pin G – 70 mm² – 1 m	K14198-PG	•	•	•
Cable pack 5-pin G – 70 mm² – 3 / 5 / 10 m	K14198-PG-xM*	•	•	•
Cable pack 5-pin G – 95 mm² 15 / 20 / 25 / 30 m	K14198-PG-xM*	•	•	•
Intermediate hose package WATER				
Cable pack 5-pin W – 95 mm² – 1 m	K14199-PGW [1]	•	•	•
Cable pack 5-pin W – 95 mm² – 3 / 5 / 10 / 15 / 20 / 25 / 30 m	K14199-PGW-xM*	•	•	•
Water connection kit	K14208-1 [2]	•	•	•

[1] only for connection on the back and requires the installation of the K14196-1 or K14202-1
[2] option requires only for water hose package longer than 1 m

		Wire Feeder	
		STANDARD	ADVANCED
		WF 52D	WF 56D
		W100000176	W100000177
LINCGUN®			
LG PROMIG 300 – MIG gun air cooled – 3 / 4 / 5 m	W000345066-2 / W000345067-2 / W000345068-2	•	•
LG PROMIG 400 – MIG gun air cooled – 3 / 4 / 5 m	W000345072-2 / W000345073-2 / W000345074-2	•	•
LG PROMIG 330W – MIG gun water cooled – 3 / 4 / 5 m	W000345063-2 / W000345064-2 / W000345065-2	•	•
LG PROMIG 400W – MIG gun water cooled – 3 / 4 / 5 m	W000345069-2 / W000345070-2 / W000345071-2	•	•
LG PROMIG 500W– MIG gun water cooled – 3 / 4 / 5 m	W000345075-2 / W000345076-2 / W000345077-2	•	•
LGS2 360 G – MIG gun air cooled – 3 / 4 / 5 m	W10429-36-xM*	•	•
LGS2 505 W – MIG gun water cooled – 3 / 4 / 5 m	W10429-505-xM*	•	•
Options			
Gas flow meter kit	K14175-1	•	•
Wire feeder drum quick adapter	K14204-1	•	•
Remote control RC-7 advanced	K14203-1	•	•
Cart HD for feeders	K14350-1	•	•
Sling with hook	K14378-1	•	•

* x = length (m)

COOLARC® 26
K14182-1

**REMOTE CONTROL
RC-7 ADVANCED**
K14203-1

**CABLE
MANAGEMENT KIT**
K14201-1

**WATER
CONNECTION KIT**
K14208-1 [2]

**INTERMEDIATE HOSE
PACKAGE**

AIR
K14198-PG (1 m)
K14198-PG-xM*

WATER
K14199-PGW (1m)
K14199-PGW-xM*

ACCESSORIES

Wire Guides

Wire Guide Set Blue 0.6-1.6	**0744-000-318R**
Wire Guide Set Red 1.8-2.8	**0744-000-319R**
Euro Wire Guide 0.6-1.6	**D-1829-066-4R**
Euro Wire Guide 1.8-2.8	**D-1829-066-5R**

Roll Kit for solid wires

Roll Kit 0.6 / 0.8VT FI37 4 rolls (green/blue)	**KP14150-V06/08**
Roll Kit 0.8 / 1.0VT FI37 4 rolls (blue/red)	**KP14150-V08/10**
Roll Kit 1.2 / 1.6VT FI37 4 rolls (orange/yellow)	**KP14150-V12/16**
Roll Kit 1.6 / 2.4VT FI37 4 rolls (yellow/grey)	**KP14150-V16/24**
Roll Kit 0.9 / 1.1VT FI37 4 rolls	**KP14150-V09/11**
Roll Kit 1.4 / 2.0VT FI37 4 rolls	**KP14150-V14/20**

Roll Kit for aluminium wires

Roll Kit 0.6 / 0.8AT FI37 4 rolls (green/blue)	**KP14150-U06/08A**
Roll Kit 0.8 / 1.0AT FI37 4 rolls (blue/red)	**KP14150-U08/10A**
Roll Kit 1.0 / 1.2AT FI37 4 rolls (red/orange)	**KP14150-U10/12A**
Roll Kit 1.2 / 1.6AT FI37 4 rolls (orange/yellow)	**KP14150-U12/16A**
Roll Kit 1.6 / 2.4AT FI37 4 rolls (yellow/grey)	**KP14150-U16/24A**

Roll Kit for cored wires

Roll Kit 1.2 / 1.6RT FI37 4 rolls (orange/yellow)	**KP14150-V12/16R**
Roll Kit 1.4 / 2.0RT FI37 4 rolls	**KP14150-V14/20R**
Roll Kit 1.6 / 2.4RT FI37 4 rolls (yellow/grey)	**KP14150-V16/24R**
Roll Kit 0.9 / 1.1RT FI37 4 rolls	**KP14150-V09/11R**
Roll Kit 1.0 / 1.2RT FI37 4 rolls (–/orange)	**KP14150-V10/12R**

Each item # contains:
- metal wire guide for Euro socket
- 4 rolls
- plastic wire guide set

SPECIFICATIONS

Product	Item Number	Primary Voltage	Max Input Power (kVA)	Input 1max (A)	Fuse size (A)	Rated Output	Efficiency	Idle Power	Weight (kg)	Dimensions H x W x D (mm)	Protection Class	Item contains
Digisteel 355S	W000404454	400V/3Ph 50/60Hz ± 15%	15	21	25	350A@50% 300A@100%	> 85%	< 35W	68	932 x 560 x 925	IP23	USB with operator's manual Ground cable with clamp (3 m) Gas hose (2 m) Chain (for gas cylinder protection) Slow-blow fuse 2A (2pcs)
Digisteel 425S	W000404455		19	27	32	420A@100%			78			
Digisteel 505S	W000404456		23	34	32	500A@60% 420A@100%			79			

Product	Item Number	Rated Output	Feeding System	WFS Range (m/min)	Solid Wires (mm)	Aluminum Wires (mm)	Cored Wires (mm)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class	Item contains
WF 52D (Standard)	W100000176	500A@60% 420A@100%	4 Rolls Ø37mm	1.5-22	0.8-1.6	1.0-1.6	0.9-1.6	17	516 x 302 x 642	IP23	USB with operator's manual Rolls 1.0/1.2 for solid wire
WF 56D (Advanced)	W100000177							17.7			

Product	Item Number	Input (V)	Cooling power @1L/min (kW)	Reservoir capacity (l)	Maximum Pressure (MPa)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class	Item contains
COOLARC® 26	K14182-1	230/400V ± 15% 50/60 Hz	0.84	4	0.47	18	260 x 150 x 680	IP23	USB with operator's manual Blue and Red water hoses Black hose for filling procedure

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