

FANMIG MOST 322 Pulse semi-automatic inverter welding



A FANMIG 322 Pulse family is a modern semi-automatic welding inverter machine designed for MIG/MAG welding and MMA coated electrode welding: consisting of FANMIG 322 Pulse, FANMIG 322W Pulse and FANMIG 322 mobil Pulse. Apart from the short arc welding, it enables users to weld with MIG/MAG pulse current. All FANMIG 322 Pulse are compact devices: the power source and wire feeder are placed inside one housing. Thanks to its simplicity in use it is recommended as a first semi-automatic "MIG pulse" welding device in your workshop.

Properties:

- The device is operated synergistically and includes a wide range of programmes for steel, stainless steel and aluminium pulse and short welding current.
- All FANMIG 322 Pulse are also equipped with a program for brazing of galvanized sheets.
- The 4-roll feeder enables welding with 15 or 5 kg spools, the recommended diameter of steel wires is 0,8 mm and 1,0 mm, for aluminium 1,0 mm.
- Includes LED lighting inside the wire feeder chamber.
- FANMIG 322 Pulse - compact with welding torch gas cooling.
- FANMIG 322W Pulse - compact with welding torch water cooling.
- FANMIG 322 mobil Pulse - size reduced to the size of a large wire feeder.

Main advantages of MIG/MAG pulse:

- Non or minimal spatters.
- Smooth face of the seam and seam high aesthetics.
- Essential for welding stainless steel and aluminium.
- Crater filling feature.



FANMIG 322 mobil Pulse

FANMIG 322 Pulse

FANMIG 322W Pulse

Control panel:

- two multifunction knobs,
- displays show parameter and actual values during welding,
- LEDs indicate the parameter units on the display,
- memory for 6 custom programs.



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Model	FANMIG 322 Pulse	FANMIG 322 mobil Pulse	FANMIG 322W Pulse
Electrical power supply	3x400 / 50-60 V/ Hz	3x400 / 50-60 V/ Hz	3x400 / 50-60 V/ Hz
Welding current range			
▪ MIG/MAG	20 A / 15,0 V 315 A / 29,8 V	20 A / 15,0 V 315 A / 29,8 V	20 A / 15,0 V 10 A / 20,4 V
▪ MMA	10 A / 20,4 V 300 A / 32,0 V	10 A / 20,4 V 300 A / 32,0 V	300 A / 32,0 V 315 A / 29,8 V
Idle voltage U₀	63 V	63 V	63 V
Overload protection	16 A slow blow	16 A slow blow	16 A slow blow
Duty cycle X			
▪ MIG/MAG	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%
▪ MMA	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%
Welding current setting	Stepless	Stepless	Stepless
Wire feeder	4-roll	4-roll	4-roll
Wire feeding speed	1-20 m/min	1-16 m/min	1-20 m/min
Welding torch cooling	Gas	Gas	Liquid or gas
Cooling power Q=1 l/min	-	-	0.74 kW
Tank capacity	-	-	4 l
Maximum pressure	-	-	3,5 bar
Maximum flow	-	-	8 l/min
Insulation class	H	H	H
IP Rating	IP 23S	IP 23S	IP 23S
Dimensions	670x911x474 mm	438x650x240 mm	884x902x474 mm
Weight	47,6 kg	26,6 kg	72,5 kg
Catalogue No.	51 00 023910	51 00 023930	51 00 023920

Device assembly:

Device is delivered in cardboard box with power plug included (CEE 16 A). The equipment includes a ground cable, gas hose and user's manual. The wire feeder has rolls for 0,8-1,0 mm steel wire welding. The cooler is filled with coolant (FANMIG 322W Pulse).

Additional welding torches and accessories	FANMIG 322 Pulse	FANMIG 322 mobil Pulse	FANMIG 322W Pulse
	Catalogue No.	Catalogue No.	Catalogue No.
M24 SGRIP Welding Torch	3 m - 55 08 302430 4 m - 55 08 302440 5 m - 55 08 302450	3 m - 55 08 302430 4 m - 55 08 302440 5 m - 55 08 302450	-
M38 SGRIP Welding Torch	3 m - 55 08 303830 4 m - 55 08 303840 5 m - 55 08 303850	3 m - 55 08 303830 4 m - 55 08 303840 5 m - 55 08 303850	-
M240 SGRIP Welding Torch (liquid cooled)	-	-	3 m - 55 08 304243 4 m - 55 08 304244 5 m - 55 08 304245
Welding torch Digimig 355 (LCD operated)	3 m - 55 08 308003 4 m - 55 08 308004 5 m - 55 08 308005	3 m - 55 08 308003 4 m - 55 08 308004 5 m - 55 08 308005	-
Welding torch Digimig 240W UD (LCD operated, fluid cooled)	-	-	3 m - 55 08 308020 4 m - 55 08 308021 5 m - 55 08 308022
0,6-0,8 Roll	51 13 007793	-	51 13 007793
0,8-1,0 Roll	51 13 007808	51 13 007843	51 13 007808
1,0-1,2 Roll	51 13 007865	51 13 007893	51 13 007865
0,8AL-1,0AL Roll	51 13 007809	51 13 007844	51 13 007809
1,0AL-1,2AL Roll	51 13 007885	51 13 007894	51 13 007885

Attention:

While welding with pulse current welding torch heating increases (by approx. 30%). Please apply welding work cycles provided by manufacturer of welding torch. Solution to this issue is a purchase of FANMIG 322W Pulse or for other FANMIG 322, application of cooling for welding torch liquid eg. by connecting Fancool 601-WA as additional cooling unit (cat. no.: 50 03 003805).