

SAW series



Products' components and functions may be subject to change.

MZ 1000 M311II

MZ 1250 M312II



Dust-Free sealed air passage



On-demand fan



Hi-Def digital display



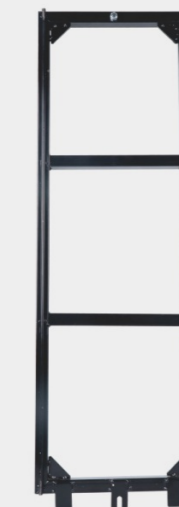
Products' components and functions may be subject to change.

Excellent Arc Start, Stable Welding, No Wire Sticking

- Excellent arc ignition performance, specially for stainless steel
- Limited fluctuation of welding current and voltage, ensuring stable wire feeding
- Precise preset welding current for CV mode welding
- No wire sticking by unique weld crater technology
- With SAW, MMA, and Gouging functions
- Rich function settings(secondary menu) and protection mechanism

Standard Accessories

- MK-3 control box + carriage
- 15 meters of 70mm² welding cable x2/ 5 meters of 70mm²
- 5 meters of 70mm² earth cable x2/ 15 meters of control cable x1/ 1 meter of guide rail x2



		MZ 1000 M311II	MZ 1250 M312II
Input	Input voltage(V)	3ph AC380V±15% 50Hz	3ph AC380V±15% 50Hz
	Rated input power capacity (kVA)	54.5	67.2
	Power factor	0.89	0.9
Output	Rated no-load voltage(V)	83	83
	Rated max. output of SAW (A/V)	1000/44	1250/44
	Rated max. output of SAW (A/V)	1000/44	1250/44
	Welding voltage range (V)	20~50	20~50
	Welding current range (A)	50~1010	50~1250
	Wire feed speed range(cm/min)	30~300	30~300
Others	Travel speed range of carriage(cm/min)	10~150	10~150
	Rated duty cycle (@40°C)	100%	100%
	Efficiency	90%	90%
	Cooling method	Air cooling	Air cooling
	Insulation class	H	H
	Protection class	IP23	IP23
	Weight(kg)	96	96
	Dimensions(mm)	820*370*765	820*370*765

Stable Welding Process

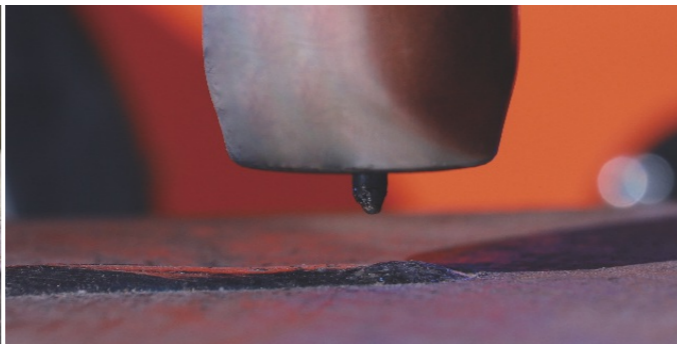
- Stable welding with wires of various diameters and materials
- Limited fluctuations of welding current and voltage



Excellent Arc Ignition Performance No Wire Sticking When Arc Stops

Excellent arc ignition performance, solving the problem of difficult arc ignition specially for stainless steel welding

No wire sticking by unique weld crater control technology, improving arc ignition success rate



Standard Carriage



Items	Values
Rated input voltage of control box	AC110V±15%
Rated input voltage of traveling mechanism	Servo motor DC110V (permanent magnet)
Rated input voltage of wire feeding mechanism	Servo motor DC110V (permanent magnet, reserved interface of excitation)
Wire feeding method	Variable feeding speed or constant feeding speed by feedbacks of arc voltage
Welding speed range	10~150cm/min
Wire feed speed range(m/min)	30~300cm/min
Applicable welding power source (rated value)	630A, 1000A, 1250A
Applicable welding wire diameter	Ø2.0mm~Ø6.0mm (Other wire diameter ranges are optional)
Flux hopper capacity	6L
Wire spool weight	25kg
Dimensions(L*W*H)	1020*480*740mm
Weight(kg)	55kg(without wire)

MK-3 Control Box

- Compact design for high operation flexibility
- Digital control for optimal welding performance
- High protective performance, capable of working in harsh environment
- Equipped with sync start interface for automatic equipment
- Built-in CP characteristic changeover function, simulating the welding characteristics of SCR welding machine
- Touch-stop function, ensuring that the wire stops at the determined position
- Capable of using handheld operation box near working sites with optional extension cable
- Handheld box attached on the main control box by strong magnet, ensuring high mobility and safety



MK-4 Control Box For Automatic Equipment (Optional Carriage)



- Analog operation panel with easy and practical functions
- Suitable to use with automatic equipment such as column and boom welding manipulator, H beam auto welding machine, etc.
- The control terminal of control board for automatic equipment is open to users, convenient for users to transfer signals such as start, stop, preset value, display, etc.

Function Description

No.	Advanced functions	Adjustment range	Factory default values	Remarks
P01	Arc ignition current	100A~1000/1250A	1000/1250	Welding current in arc starting phase. Max. value varies according to different models
P02	Arc ignition time	0.0~2.0S	0.0	Duration of arc ignition current
P03	Wire drawing/inching speed	0.2~2.2m/min	0.80	Get higher speed by increasing value, and get max. speed automatically after pressing and holding for 10s.
P04	Slow wire feed speed	0.03~2.0m/min	0.25	Get higher speed by increasing value
P05	Crater current	200~1000/1250A	300	Welding current in crater phase. max. value varies according to different models
P06	Crater voltage	20~50V	28.0	Welding voltage in crater phase
P07	Crater time	0.0~10.0S	0.0	Duration of crater phase
P08	Burn back time	0.0~2.0S	0.0	Arc burning time after wire feeding stops
P09	Motor rotation speed selection	3000/6000	3000	Using rotation speed in accordance with that of the used wire feeding motor
P10	CC characteristics selection	0/1	0	Select different constant current SAW characteristics according to users' demands on site
P11	Voltage feedback wire break detection device	on/off	on	ON: detect voltage feedback wire, and show E90 when wire breaks OFF: no detection