

CIGWELD

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PRO
SERIES

Transmig 255i



MIG
STICK
TIG

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OUTPUT CURRENT
255A
DC

INPUT SUPPLY

240V 15A**

INT. WIRE FEEDER

SPOOLS UP TO 300mm

SAFETY DEVICE


SPOOL GUN

COMPATIBLE
WITH SGT250*

STANDARDS
AS

WARRANTY*
3
YEARS

Transmig 255i

MULTI PROCESS WELDING INVERTER

The CIGWELD TRANSMIG 255i is a self contained single phase multi process welding inverter with digital voltage and amperage meters, that is capable of performing MIG (GMAW/FCAW), Stick (MMAW) and Lift TIG (GTAW) welding processes. It is ideal for welding plate thicknesses between 0.8mm and 12mm with a range of wires from 0.6mm-1.2mm (solid), and has the added benefit of running the Tweco SGT 250 Spool Gun for the convenience of your precision aluminium work.

The 255i has adjustable Inductance and Burnback giving the user the ability to customise their MIG preferences, while Hot Start and Anti-Stick will ensure a smooth easy start in Stick mode.

The Transmig 255i is equipped with an integrated wire feed unit to fit 300mm spools, 2T/4T, Down Slope (in TIG), adjustable Arc Force (in Stick), VRD (in Stick), Power Factor Correction, and Fan on Demand which minimises power consumption, noise and dust contaminants. The unit is

compliant to Australian Standard AS 60974.1-2006 and is ideal for indoor / outdoor use with an enclosure rating of IP23S.

The 255i can be upgraded with a 25 Amp plug and 4mm² supply lead which increases your duty cycle so you can run it harder for longer. Ideal for onsite repairs and maintenance, medium industrial workshops, car panel repairs or serious welders that want a single phase inverter they can plug in and use around their own home workshop.

SPECIFICATIONS

| | | |
|---|--|---|
| Power Source Dimensions | H435mm x W266mm x D617mm | |
| Power Source Weight | 27kg | |
| Number of Phases | Single Phase | |
| Nominal Supply Voltage | 240 VAC \pm 15% | |
| Nominal Supply Frequency | 50 / 60Hz | |
| Output Terminal Type | Dinse Style 50mm | |
| Protection Class | IP23S | |
| Open Circuit Voltage (VRD On) | <35V DC | |
| Welding Current Range (MIG Mode) | 30-255A | |
| Welding Current Range (STICK Mode) | 10-230A | |
| Welding Current Range (TIG Mode) | 10-255A | |
| Supply Lead and Plug Rating | 15 Amps Ratings Below Apply to the Factory Fitted 2.5mm ² Supply Lead and 15A Plug | 25 Amps Ratings Below Apply to an Upgraded 4.0mm ² Supply Lead and 25A Plug |
| Effective Input Current (I_{eff}) [Refer Note 2] | 15 Amps | 21 Amps |
| Maximum Input Current (I_{max}) | 33 Amps | 33 Amps |
| Minimum Single Phase Generator Recommendation [Refer Note 4] | 10 kVA (at 0.8 Power Factor) 8 kW (at 1.0 Power Factor) | 10 kVA (at 0.8 Power Factor) 8 kW (at 1.0 Power Factor) |
| MIG (GMAW) Welding Output, 40°C, 10 min | 255A@ 20%, 26.8V 114A@ 100%, 19.7V | 255A@ 40%, 26.8V 160A@ 100%, 22.0V |
| STICK (MMAW) Welding Output, 40°C, 10 min. | 230A@ 20%, 29.2V 103A@ 100%, 24.1V | 230A@ 40%, 29.2V 145A@ 100%, 25.8V |
| TIG (GTAW) Welding Output, 40°C, 10 min. | 255A@ 20%, 20.2V 114A@ 100%, 14.6V | 255A@ 40%, 20.2V 160A @ 100%, 16.4V |



Optional SGT250 Spool Gun ideal for your precision aluminium fabrication, repairs and auto/marine work.



“Great feedability and control over my aluminium welds when using the Tweco Spool gun with my Transmig 255i”

ORDERING INFORMATION

Transmig 255i Plant Part No: W1005255

OPTIONAL ACCESSORIES

| | |
|---|--------------|
| Tweco Professional Fusion 250 MIG Torch, 3.6 metre EURO | OTWF212X3035 |
| Tweco #2, 250A MIG torch, 3.6 metre EURO | OTWX212/3035 |
| Tweco MIG Torch Consumables Organiser Box | W4012300 |
| Tweco SGT 250 Spool Gun | W4011250 |
| TIG Torch 17V with 4m lead (200A@20%)# | W4013801 |
| TIG Torch 17V with 4m lead and remote control (200A@20%)# | W4013800 |
| TIG Torch 26V with 4m lead (240A@20%)# | W4014601 |
| TIG Torch Accessories Kit | BGSAK2 |
| Power Source Trolley with inbuilt cylinder carrier | W4015000 |
| Feed Roll 0.6/0.8mm V groove (hard) | 7977036 |
| Feed Roll 0.9/1.2mm V groove (hard) (fitted) | 7977660 |
| Feed Roll 0.8/0.9mm U groove (soft) | 7977731 |
| Feed Roll 1.0/1.2mm U groove (soft) | 7977264 |
| Feed Roll 0.8/0.9mm V groove knurled (flux cored) | 7977732 |
| Feed Roll 1.2/1.6mm V groove knurled (flux cored) | 704277 |
| Autocraft LW1-6 0.9mm Spool 15kg (300mm) | 720090 |
| Shield-Cor 15 0.9mm Spool 14kg (300mm) | 721929 |
| WeldSkill TIG Welding Gloves | 646754 |
| WeldSkill Heavy Duty Welding Gloves | 646755 |
| Heavy Duty Backpack | W4018001 |
| ProLite Auto-Darkening Welding Helmet - Redback Spider | 454343 |
| ProPlus Digital Auto-Darkening Welding Helmet - Web | 454351 |

*NOTE: Exceeding TIG torch duty cycles may cause overheating and result in damage to the equipment



“Even on 12mm plate the 255i was really easy to tune in, with a nice sweet spot for 0.9mm and 1.2mm gas and gasless wire”

FEATURES



Input Supply
240 Volt, 50/60Hz, 15 Amp Supply
Lead Fitted to Power Source.**



Current Range
Current range for this Power Source is
10 to 255A (MIG Mode) of DC Welding Output.



MIG (GMAW / FCAW):
255A@20%* (255A@40% - Upgraded Plug & Lead**)
0.6-1.2mm: Solid, 0.8-1.2mm: Gasless
0.9-1.2mm: Aluminium, 0.8-1.2mm: S/Steel



STICK (MMAW)
230A@20%* (230A@40% - Upgraded Plug & Lead**)
Power Source suitable for 2.0mm, 2.5mm,
3.2mm & 4.0mm electrodes.



TIG (GTAW):
255A@20%* (255A@40% - Upgraded Plug & Lead**)
Lift TIG provides smooth arc start & characteristics.
Optional remote current control.



Anti-Stick
Helps to prevent the stick electrode
from sticking to the work piece.



Hot Start
Improves the arc start characteristics
of stick electrodes.



Adjustable Burnback Control
Burnback is used to adjust the amount
of wire that protrudes from the MIG
torch after welding (Known as stick out).



Arc Control (Inductance)
The arc control operates in GMAW/FCAW
(MIG) mode only and is used to adjust
the intensity of the welding arc.



Trigger Mode (2T/4T)
Trigger Mode control switches between
2T (normal) and 4T (latch mode).



Arc Force (in Stick)
Provides an adjustable amount of
welding force (or “dig”) control.



Down Slope (in TIG)
Allows the user to select the ramp
down time at the completion of the weld.



**Standards Compliant Voltage
Reduction Device**



Digital Amperage and Voltage Meters



Integrated Wire Feed Unit
Spools up to 15kg or 300mm



Fan on Demand
Fan automatically switches off as required
to minimise power consumption, noise &
dust contaminants.



Euro Torch Connection
Supplied with Tweco Professional
Fusion 250 MIG Torch.



SGT250 Spool Gun Compatible
The optional Tweco SGT250 Spool Gun
is ideal for aluminium fabrication,
repairs & auto/marine work.



Compliance
Fully compliant to AS 60974.1-2006
enclosure rated to IP23S - Designed for
indoors & outdoor use.



Recommended Generator
10 kVA (at 0.8 Power Factor)***



Over Temperature Protection
This protection has been fitted to the
Power Source.



3 Year Limited Warranty***



Wire Type
Suitable for Gas
and Gasless
Wires

* Power Source fitted with 15A Supply Lead & Plug.
** For Maximum duty cycle to be achieved, Supply Plug and
Lead must be upgraded to 4mm² Supply Lead & 25A Supply Plug.
*** Refer to Operating Manual.

CIGWELD

AN ESAB BRAND

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SERIES

Transmig 255i

3^{IN}1
MIG STICK TIG



PACKAGE CONTENTS

Transmig 255i Inverter Power Source 27kg

Tweco Professional Fusion 250 MIG Torch 3m

COMET Professional Argon Regulator / Flowmeter*

Feedrolls: 0.9/1.2mm "V" groove (fitted), 0.6/0.8mm "V" groove, 0.9/1.0mm (U) groove, 0.8/0.9mm "V" knurled

Contact Tips: 0.9mm (fitted) 0.8mm, 0.9mm, 1.0mm

Twistlock Electrode Holder with 4m Lead

Work Clamp with 4m Lead

Shielding Gas Hose Assembly

Operating Manual

*Asia Variant does not include Argon Regulator/Flowmeter

Transmig 255i Plant Part No: W1005255

WE RECOMMEND GENUINE CIGWELD PRODUCTS



THE BIGGEST RANGE AND THE BEST QUALITY, WITH GUARANTEED PERFORMANCE.



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