

# MPi 220P

## MIG/Stick/TIG (Multiprocess) Arc Welding Power Source



### Quick Specs



#### Industrial Applications

Light fabrication  
Maintenance and repair  
Auto body  
Farm/home

#### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
Stick (SMAW)  
TIG (GTAW)  
Flux-cored (FCAW)

**Input Power** 230 V, single-phase, 50/60 Hz

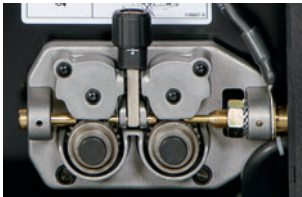
**Amp/Volt Range** MIG: 20–200 A, 15–24 V  
Stick: 5–200 A, 20.2–28 V  
TIG: 5–200 A, 10–18 V

**Rated Output** MIG: 110 A at 17.5 VDC, 100% duty cycle  
Stick: 100 A at 24 VDC, 100% duty cycle  
TIG: 100 A at 14 VDC, 100% duty cycle

**Portability is number one** when you have to go to the job — because it can't come to you. The MPi 220P contains all you need to MIG weld in one small lightweight package. With the flip of a switch, all processes are available to meet the application at hand.

**Large graphical display** guides user through process and parameter setup with ease and high visibility.

**Full weld process capability.** MIG/MAG, pulse, stick, and TIG are available to meet the demand of current applications.



**Durable cast aluminum feedhead** incorporates dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make set up easier and faster.

**Thermal overload protection** shuts down unit and activates **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.



**Excellent arc characteristics!** The MPi 220P offers positive arc starts and an extremely stable arc with minimal spatter on both mixed gases and straight CO<sub>2</sub>.



Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

**Synergic welding mode** offers the simplicity of single knob control. The machine will select the correct voltage and amperage based on the wire feed speed (WFS) set by the operator.  
*Note: Complete material library to select from for the targeted market segment.*

**Adjustable Hot Start™ for stick arc starts.** Adjust the optimal start current for the application. The current automatically increases the output amperage at the start of a weld.

**Built-in upslope/downslope function for TIG** helps provide better arc starts and reduces craters.

**Built-in run-in/crater/burnback function for MIG** helps provide better arc starts and reduces craters.

**Adjustable preflow and postflow** gives operator better control of the gas parameters affecting weld zone.

**Selectable trigger configuration** allows the operator to choose standard or 2T trigger method.



Warranted for three years, parts and labour.



#### ITW Welding – BV

Edisonstraat 10  
P.O. Box 1551  
NL-3261 LD Oud-Beijerland,  
Netherlands  
TEL: +31 (0) 186 641 444  
FAX: +31 (0) 186 640 880

#### ITW Welding – Italy S.r.l.

Via Privata Iseo 6/e  
20098 San Guiliano M.se  
Milano – Italia  
TEL.: +39 02 982901  
FAX: +39 02 98281552  
ITW-Welding.com

#### International Headquarters Miller Electric Mfg. Co.

An Illinois Tool Works Company  
1635 W. Spencer Street  
Appleton, WI 54914 USA  
TEL. : +1 920 735 4554  
FAX : +1 920 735 4125  
MillerWelds.com

# Specifications (Subject to change without notice.)



Input Power	Welding Mode	Amperage/ Voltage Range DC	Rated Output (Duty Cycle)			Max. Open-Circuit Voltage	IP Rating	Dimensions	Net Weight
			100%	60%	35%				
230 V, 1-phase, 50/60 Hz	MIG	2–200 A 15–24 V	110 A 17.5 V	140 A 21.0 V	180 A 23.0 V	35 V	IP22S	L: 548 mm (21.6 in.) W: 237 mm (9.3 in.) H: 365 mm (14.4 in.)	16 kg (35 lb.)
	Stick	5–200 A 20.2–28 V	100 A 24.0 V	130 A 25.2 V	170 A 26.8 V	65 V			
	TIG	5–200 A 10–18 V	100 A 14.0 V	130 A 15.2 V	180 A 17.2 V	65 V			

## Drive Rolls and Wire Guides

Wire Size	V-Grooved Drive Roll*	U-Grooved Drive Roll**	V-Knurled Drive Roll*	Wire Guide Inlet
0.6/0.8 mm (.023/.030 in.)	156053051	—	—	156090026
0.8/1.0 mm (.030/.040 in.)	156053109	156053053	—	156090026
1.0/1.2 mm (.040/.045 in.)	156053052	—	156053110	156090026
1.2/1.6 mm (.045/.065 in.)	—	156053054	—	156090026

\*Available in steel, 30 mm diameter. \*\*Available in nylon, 30 mm diameter.

Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. V-Knurled rolls for hard-shelled cored wires.
3. U-Grooved rolls for soft and soft-shelled cored wires.
4. U-Cogged rolls for extremely soft-shelled wires (usually hard surfacing types).

## Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
<b>MPi 220P</b>	<b>059016014</b>	230 V, single-phase, 50/60 Hz. Includes work clamp		
<b>Accessories</b>				
TIG Torch	<b>WTC9AA4AG</b> <b>CS130AGA4CG-I</b>	125 amps DC, 100 amps AC, 60% duty cycle 130 amps DC, 100 amps AC, 60% duty cycle		

Date: Total Quoted Price:

Distributed by:

