

# X3S Power Source Syn 420 G



## OVERVIEW

The power source for manual and synergic MIG/MAG, MMA, and gouging processes provides 420 A at 60% duty cycle. X3S Power Source includes over 40 factory-installed welding programs for Fe, Ss, AISi5, AlMg5, Fe Metal, Fe Rutil, FC-CrNiMo, and Fe Metal filler wires.

### List of welding programs included in the power source:

Wprog. No	Process	Wire material	Diameter	Shielding gas	Description
A01	1-MIG	AlMg5	1	Ar	Standard
A02	1-MIG	AlMg5	1,2	Ar	Standard
A03	1-MIG	AlMg5	1,6	Ar	Standard
A11	1-MIG	AISI5	1	Ar	Standard
A12	1-MIG	AISI5	1,2	Ar	Standard
A13	1-MIG	AISI5	1,6	Ar	Standard
C01	1-MIG	CuSi3	0,8	Ar	Standard: Brazing
C03	1-MIG	CuSi3	1,0	Ar	Standard: Brazing
F01	1-MIG	Fe	0,8	Ar+18%CO2	Standard
F02	1-MIG	Fe	0,9	Ar+18%CO2	Standard
F03	1-MIG	Fe	1	Ar+18%CO2	Standard
F04	1-MIG	Fe	1,2	Ar+18%CO2	Standard
F05	1-MIG	Fe	1,4	Ar+18%CO2	Standard
F06	1-MIG	Fe	1,6	Ar+18%CO2	Standard
F11	1-MIG	Fe	0,8	Ar+8%CO2	Standard
F12	1-MIG	Fe	0,9	Ar+8%CO2	Standard
F13	1-MIG	Fe	1	Ar+8%CO2	Standard
F14	1-MIG	Fe	1,2	Ar+8%CO2	Standard
F21	1-MIG	Fe	0,8	CO2	Standard

F22	1-MIG	Fe	0,9	CO2	Standard
F23	1-MIG	Fe	1	CO2	Standard
F24	1-MIG	Fe	1,2	CO2	Standard
F25	1-MIG	Fe	1,4	CO2	Standard
F26	1-MIG	Fe	1,6	CO2	Standard
M04	1-MIG	Fe Metal	1,2	Ar+18%CO2	Standard
M05	1-MIG	Fe Metal	1,4	Ar+18%CO2	Standard
M06	1-MIG	Fe Metal	1,6	Ar+18%CO2	Standard
M24	1-MIG	Fe Metal	1,2	CO2	Standard
M26	1-MIG	Fe Metal	1,6	CO2	Standard
R04	1-MIG	Fe Rutil	1,2	Ar+18%CO2	Standard
R06	1-MIG	Fe Rutil	1,6	Ar+18%CO2	Standard
R14	1-MIG	Fe Rutil	1,2	CO2	Standard
R16	1-MIG	Fe Rutil	1,6	CO2	Standard
R56	1-MIG	Fe	1,6		InnerShield
R57	1-MIG	Fe	2,0		InnerShield
S01	1-MIG	Ss	0,8	Ar+2%CO2	Standard
S02	1-MIG	Ss	0,9	Ar+2%CO2	Standard
S03	1-MIG	Ss	1	Ar+2%CO2	Standard
S04	1-MIG	Ss	1,2	Ar+2%CO2	Standard
S05	1-MIG	Ss	1,6	Ar+2%CO2	Standard
S82	1-MIG	FC-CrNiMo	0,9	Ar+18%CO2	Standard
S84	1-MIG	FC-CrNiMo	1,2	Ar+18%CO2	Standard

## TECHNICAL SPECIFICATIONS

### X3S Power Source Syn 420 G

Product code	X3S420G
Connection voltage 3~ 50/60 Hz	380...415 V ±10 %
Fuse	25 A
Output 60% ED	420 A
Output 100% ED	350 A
Rated power at max. current	20 kVA
Recommended generator power (min)	25 kVA
Welding current and voltage range, MIG	15 A/12 V...420 A/40 V
Welding current and voltage range, MMA	15 A/10V...400 A/41 V
External dimensions LxWxH	698 x 251 x 361 mm
Weight (no accessories)	35.0 kg
Degree of protection	IP23

**X3S Power Source Syn 420 G**

Standards	IEC 60974-1, -10
EMC class	A
Operating temperature range	-20...+40 °C
Storage temperature range	-40...+60 °C