

WARRANTY
YEARS
2



IRON-MIG 201

IRON-MIG 221-221P

Made in ITALY



- Compact lightweight and practical design makes this portable 'go anywhere' 230V 1Phase range of IRON MIG 201- 221 - 221P ideally suited for all site-work and workshop applications.
- A large clear user-friendly Digital Screen provides the operator with coherent parameter information.
- All machines are extremely compact, reliable and lightweight, with a built-in wire feeding system for 5 and 15 kg spools.
- The IRON-MIG 221P digital operating concept, incorporating Stepless Synergic Technology allowing for simple selection of PULSE MIG/MAG welding for Stainless Steel, Mild Steel, Aluminiums and Cusi 3 Brazing.
- The IRON-MIG 221P also include **PAW™** programs for thin material thicknesses from 1 to 2mm.

UNLIMITED CONTROL

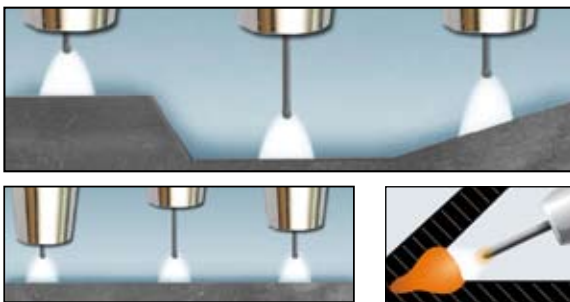
ST-ARC™ is the intelligent control of the Short Arc process, capable of handling automatically all variations within the welding process.

The result is a short concentrated and stable arc 100% easier to control. The dynamic cold welding characteristics significantly lower the heat input reducing distortion, spatters, re-working and cleaning plus less weld time.

ST-ARC™ is a standard feature of all Stel MIG / MAG Stel welders.

AUTO - COMPENSATION:

Automatically compensates for any variation in welding conditions caused either by irregularities of the workpiece or the movements of the operator's hand. Ideal for awkward angles.



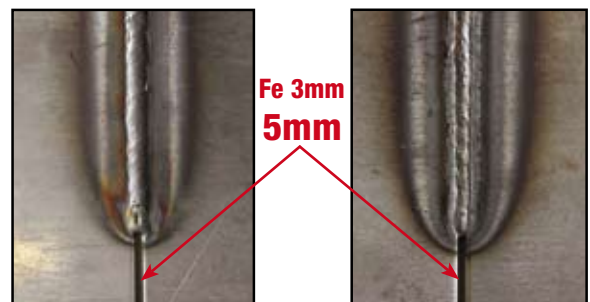
START CONTROL:

The approach speed of the wire to the piece and welding dynamics are synergic and provide limit spatters at the start with every material. The dynamic synergic technology provides for an extremely smooth, spatter free Arc Ignition with all materials.



GAP BRIDGING:

The Short-Arc ST-ARC characteristics of the IRON-MIG welding process is perfect for root passes, or where gaps are needed to be bridged.



LIGHT GAUGE MATERIALS:

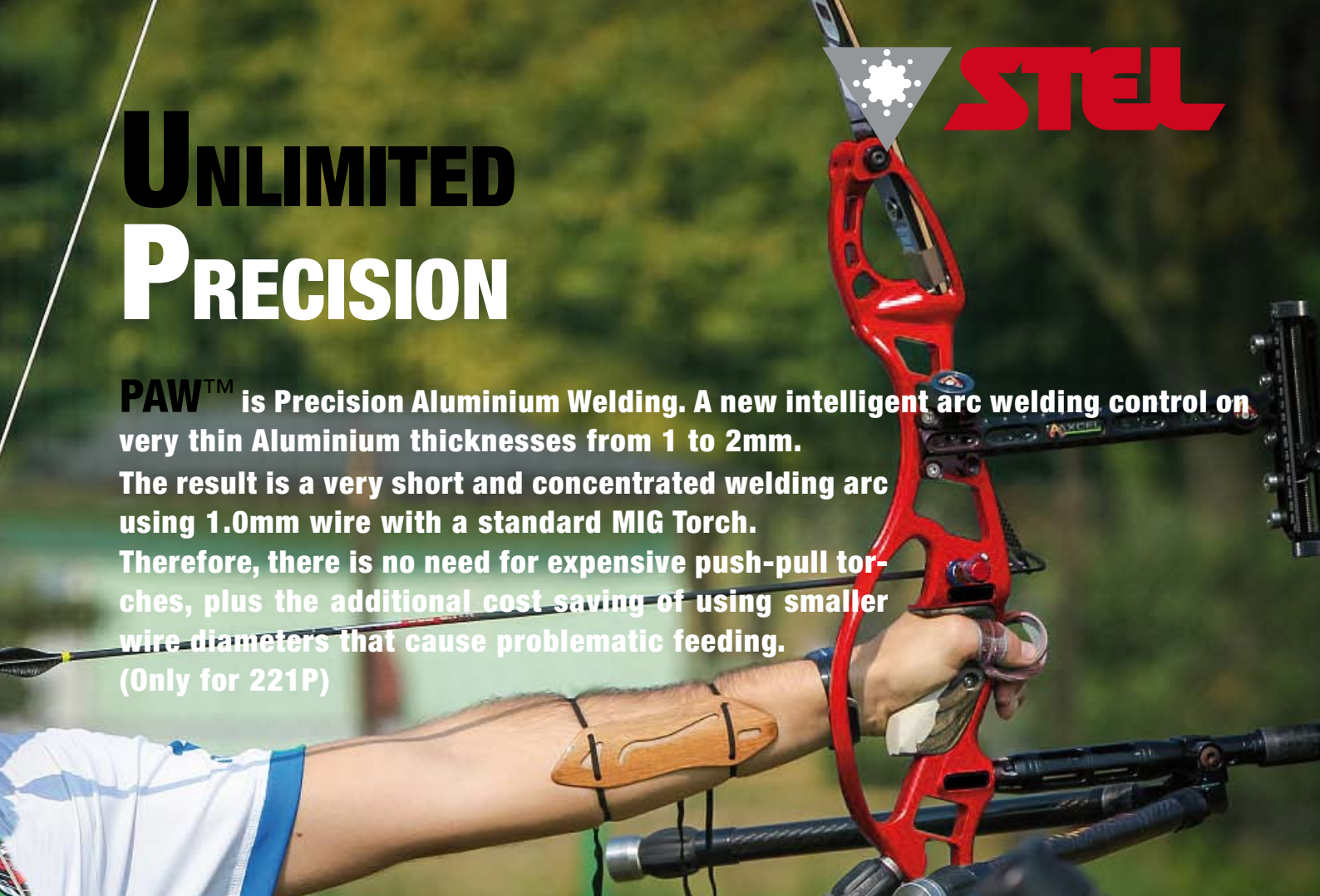
The Short-Arc Dynamics result in excellent arc control, minimal spatter levels, reduced Heat Affected Zone and distortion, uniformed bead appearance, solid penetration, and almost no re-working.





UNLIMITED PRECISION

PAW™ is Precision Aluminium Welding. A new intelligent arc welding control on very thin Aluminium thicknesses from 1 to 2mm. The result is a very short and concentrated welding arc using 1.0mm wire with a standard MIG Torch. Therefore, there is no need for expensive push-pull torches, plus the additional cost saving of using smaller wire diameters that cause problematic feeding. (Only for 221P)



P.A.W.™

PROGRAMS:

There are 12 programs dedicated to aluminum. Programs are synergic and pulsed. Two PAW™ programs (AlMg5 and AlSi5) are available for thin material thicknesses from 1 to 2mm.

MIG SYNERGIC WIRE LIST 7-12				
AlMg5	1.0mm	Ar100%	PULS	<
AlMg5	1.0mm	Ar100%	DoublePULS	
AlMg5	1.2mm	Ar100%		
AlSi5	1.0mm	Ar100%	PAW	
AlSi5	1.0mm	Ar100%	PULS	
AlSi5	1.0mm	Ar100%	DoublePULS	

SELECT ↑ ↓

PULSE:

Preset synergic pulse programs greatly assists the operator with welding materials such as aluminum.



SHORT ARC:

The PAW™ programs offer a short highly concentrated arc that provide the operator with easy control during welding of thin materials. Weld appearance is excellent with absence of spatters.



ALUMINUM:

Owing to PAW™ technology, the IRON-MIG 221P power source can weld AlMg5 and AlSi5 aluminum wires avoiding the use of expensive push-pull torches and smaller diameter wires.



Technical Data: IRON-MIG 201 IRON-MIG 221/221P

Main Voltage	230/240 V	230/240 V	Earth Cable	16 mm ²	25 mm ²
Phase	1	1	Degree of Protection	IP 23	IP 23
Frequency	50/60 Hz	50/60 Hz	Insulation Class	H	H
No Load Voltage	85 V	76 V	Cooling	Air	Air
Efficiency	80 %	83%	Work Temperature	40°C	40°C
Current Range	20-190 A	15-200 A	Length/Width/Height (mm)	500x250x390	500x250x390
Wire Feed Rollers	2	2	Weight	18 Kg	19,5 Kg
Welding Current 25% (40°C)	180 A (20%)	200 A			
Welding Current 60% (40°C)	110 A	140 A			
Welding Current 100% (40°C)	90 A	120 A			

The date is measured at an environment temperature of 40 °C

MAIN ACCESSORIES



TROLLEY MPL
 The practical Trolley allows the movement of the Power Source in every condition of soil in safety and ease.
 Cod. 600514000L



ALUMINIUM KIT
 Complete Set-up Kit for welding aluminium.
 Cod. 6013910000L



SPOOL GUN KIT
 Ideal for the use of soft wires (aluminum).
 Cod. 600513000L



FLUX CORED ROLLERS
 Cod. 6349800000



SPOOL FLUXED CORED
 5Kgs Spool of flux cored no gas wire.
 Cod. 6085800000



SPOOL HOLDER 2,5KG D.100MM
 Cod. 601411000L



SPOOL HOLDER 5KG D.200MM
 Cod. 601412000L



REMOTE FOOT CONTROL WITH 4M CABLES
 Cod. 600102000L



TIG TTSE Torch
 Cod. 6060900000



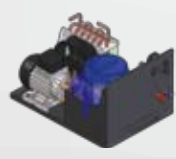
MIG/MAG TORCH
 Mig/Mag professional Torch
 Cod. 6099600000



EARTH CLAMP 25MM
 Earth Clamp with 3m 25mm² rubber cable
 Cod. 602040000L



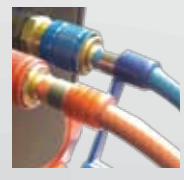
TORCIA MIG/MAG H2O
 Mig/Mag professional Torch
 Cod. 6006950000



WATER COOLER MP
 Cooling System for TIG and MIG/MAG water torch.
 Cod. 600342000L



WATER COOLER PLUG
 Water Cooler Plug KIT. Schuko Plug to ILME connections 4 pin.
 Cod. 601413000L



WATER EXTENSIONS TUBE
 Water Extensions Tube
 Cod. 601408000L



GAS REGULATOR 2 GAUGES
 Gas Regulator with 2 Gauges (Italian Gas Connection)
 Cod. 6055900000