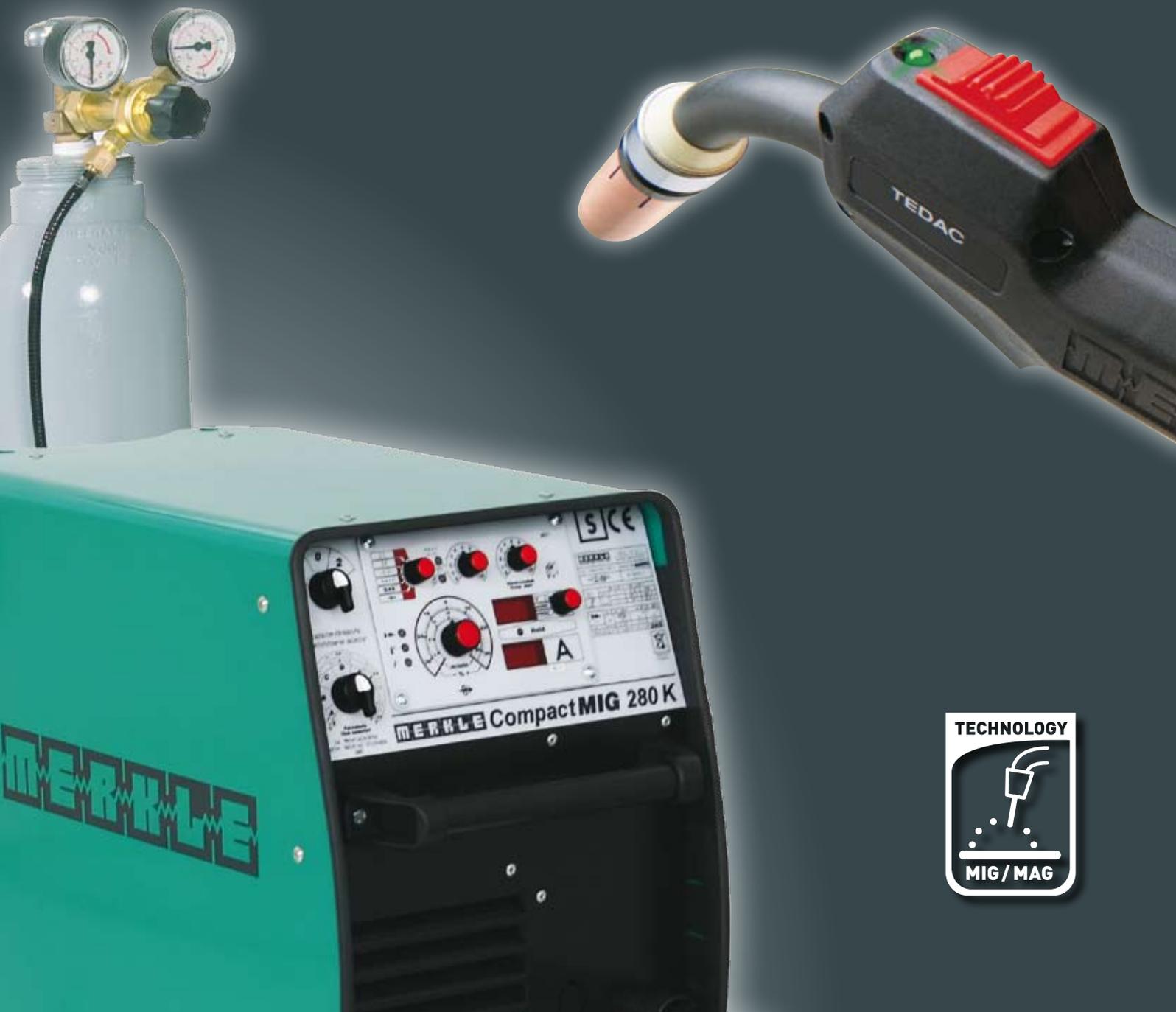




# MERKLE CompactMIG.

The professional MIG/MAG series!



With synergic wire feeding system



## Merkle CompactMIG

### Functionality and ease of operation

- Simple, self explanatory control panel with extra large function controls and LED display.
- Synergic wire feed.
- Setting and display of the wire trim by means of the TEDAC® torch.
- Creep start and wire burn back control are adjustable.
- Mode of operation: 2-stroke/4-stroke/stitch/spot welding.
- Wire feed safety cut-off in 4-stroke operation.
- 4-roller wire feeding system as a standard.
- High speed wire insertion automatic.
- 2-stage choke mounted for reduced spatters (CompactMIG 400).
- Digital read-out of the welding current, welding voltage, wire feed speed and material thickness, with HOLD function.
- Lowered galvanized gas bottle holder.
- Easy handling of the unit due to big and robust swivel and carrier wheels.
- Connection for push-pull torch or remote control (option for CompactMIG 400 D/DW).

# MERKLE CompactMIG.

## The new generation!

Experience the convincing advantages of synergic wire feed and the TEDAC® wire control system. The self explanatory display panel for current, voltage and wire feed speed along with our unique precision DV-26 4-roller wire feed unit are all standard fittings in our MIG/MAG series CompactMIG!

Through the robust and compact design these machines are predestined to be used by craftsmen in vehicle workshops, in the service and repair industry and also in the production industry.

Experience the big plus of functionality thanks to the new control panel with its extra large function control knobs and its modern design.

The controller with Synergic wire feed and TEDAC® wire trim ensures high efficiency and quality.

### The CompactMIG series comprises of 5 machines:

- CompactMIG 220 K:  
Compact machine with a 220 A welding current capability.
- CompactMIG 280 K:  
Compact machine with a 280 A welding current capability.
- CompactMIG 400 K:  
The high performance compact machine with a 400 A welding current capability.
- CompactMIG 400 D:  
As above but with the added bonus of a separate wire feed unit.
- CompactMIG 400 DW:  
As with the 400 D but including a water cooling system for extra performance and durability.



Space saving and neatly arranged buildup.



Simple operation through extra-large function controls and digital displays (CompactMIG 220/280/400).

**Continuous one-button control!**



## Merkle CompactMIGpro

### Functionality and easy operation

- Stepless one-button-control.
- Welding current controllable through our TEDAC® remote control torch.
- Switchable 230/400 V with coarse and fine range selector (CompactMIGpro 210 K).
- Special sheet metal welding range included.
- Perfect, reproducible welding results due to the reliable microprocessor control.
- 4-roller wire feeder as a standard.
- High speed wire insertion automatic.
- MIG brazing as a standard.
- Perfect ignition due to an ignition automatic.
- Welding programmes for mild steel, stainless steel, aluminium.
- Press selector for wire diameter size selection.
- Wire feed safety cut-off in 4-stroke operation.
- 2-stroke/4-stroke/stitch/spot welding.
- Digital read-out of the welding current and the welding voltage with HOLD function. (option for CompactMIGpro 301 K).

# CompactMIGpro 210/301 K.

## Efficiency and high performance!

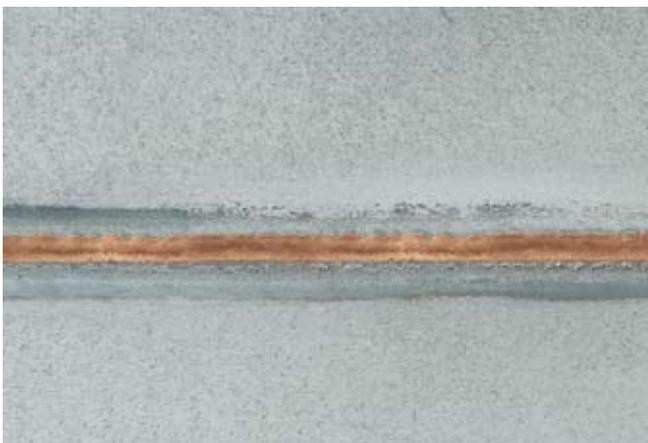
The CompactMIGpro 210/300 K models are the machines for continuous control in the compact class.

With 210 or 300 A welding current capability, MIG brazing, the simplest one-button-control and ignition automatic these machines offer advanced technology and performance for optimal operating efficiency.

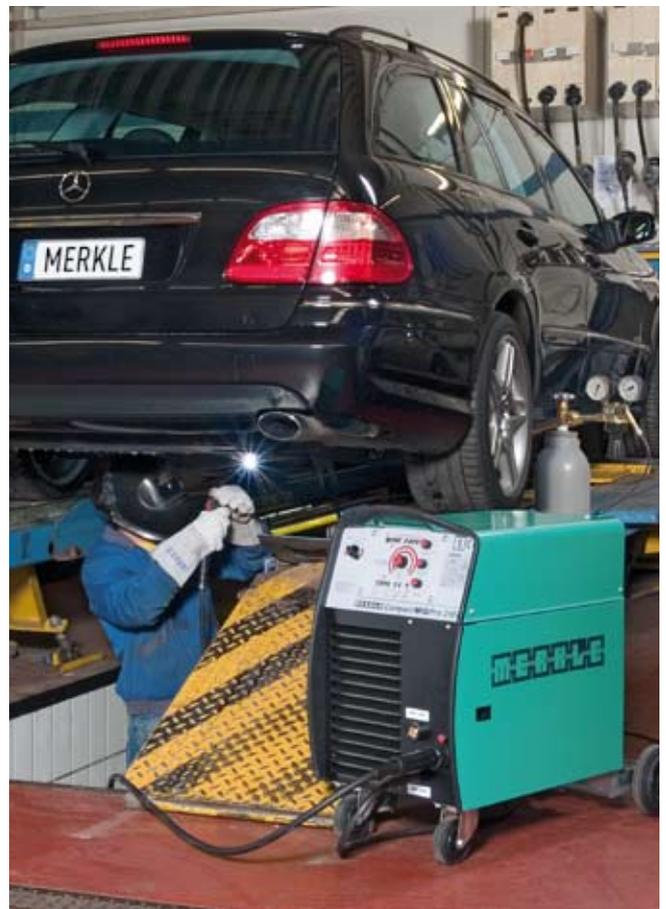
The CompactMIGpro 210 and 300 K are equipped with a simple (Synergic) continuous controller and a remote control mounted on the TEDAC® torch system. These and many other features ensure high efficiency and the prevention of unnecessary extra time being wasted.

### MIG brazing

Galvanized or aluminium coated sheets can be brazed together by the MIG brazing process. When using a wire with a low melting temperature and special welding programs a brazed joint can be achieved without melting the sheets. Due to the low temperatures, the coating will not be burnt in a large area. The weld is resistant against corrosion.



Optimal for MIG brazing of galvanized metal sheets.



Simplest remote control due to our TEDAC® torch.

# MERKLE TEDAC® system.

## Technology in a compact format!

The Merkle TEDAC® system offers continuous energy display and control and wire feed control where it counts – directly on the torch itself.

Using the slide switch mounted on the top of the TEDAC® torch handle, the arc trim (CompactMIG) and the energy (CompactMIGpro) can be manually adjusted during the welding process.

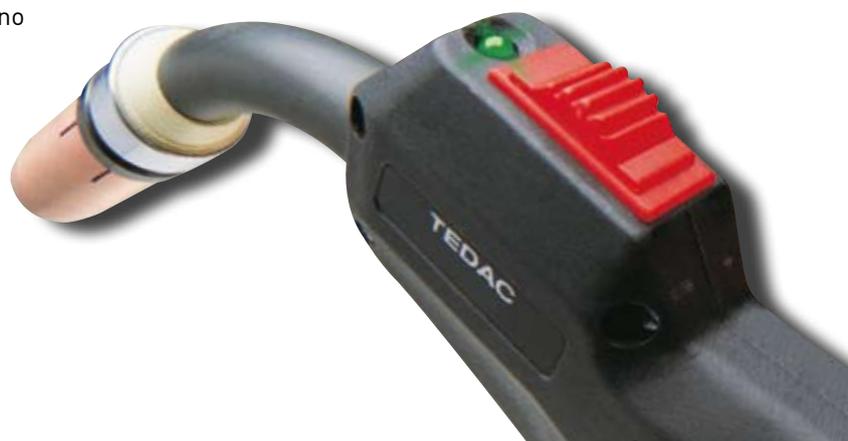
Using a visually good, multicolour LED indicator any arc trim modifications will be shown directly on the TEDAC® torch. The colours will change in a stepless sequence from green (the lowest setting) through yellow (low setting) through orange (medium setting) up to red (maximum setting).

The TEDAC® lends itself very well for any work in hard to reach positions due to the fact that the operator can control the welding process from the TEDAC® system and does not need to return to the power source to change settings. Thanks to the standard EURO torch connector no added control wires are required.

### Continuous arc trim/energy control and indicator:



Precise arc trim/energy control is realized through the slide switch mounted on the top of the torch handle before, during and after the welding process. The present conditions are shown through the stepless multi-coloured LED display mounted on the top of the torch handle.



The multi-coloured LED shows the current arc trim condition selected.



Ergonomically formed handle, torch trigger with a micro switch for guaranteed more than 10 Mio. operations.



Standard Euro-connector, no further control cables are necessary.

**Step controlled units  
with synergic wire feed:**



Technical Data:	CompactMIG 220 K	CompactMIG 280 K	CompactMIG 400 K/D/DW
-----------------	---------------------	---------------------	--------------------------

**Primary:**

Power supply	3 x 400 V	3 x 400 V	3 x 400 V
Frequency	50/60 Hz	50/60 Hz	50 (60) Hz
Continuous power	4.5 kVA	6.2 kVA	10.4 kVA
Continuous power	6.6 A	9 A	14 A

**Secondary:**

No load voltage	17 - 38 V	16 - 42 V	17 - 48 V
Welding voltage	15 - 25 V	15 - 28 V	15 - 34 V
Range	25 - 220 A	25 - 280 A	25 - 400 A
Duty cycle 40% (10 min.)	220 A (40 °C)	280 A (40 °C)	400 A (20 °C)
Duty cycle 50% (10 min.)			350 A (40 °C)
Duty cycle 60% (10 min.)	170 A (40 °C)	210 A (40 °C)	310 A (40 °C)
Protection	IP 21	IP 21	IP 23
Voltage setting	7 steps	14 steps	14 steps
Wire feeder	synergic wire feed		
Operation modes	2-stroke/4-stroke, stitch, spot welding		
Ignition	stepless control		
Wire burn back	stepless control		
Display	current, voltage, wire feed speed, material thickness		
Wire feed system	4-roller drive DV-26		
Norm	EN 60974-1 "S"/CE		
Gas bottle holder	10 l or 20 l gas cylinders	10 l, 20 l, 50 l gas cylinders	
Weight	90 kg	105 kg	K: 140 kg, D: 160 kg DW: 170 kg
Dimensions l x w x h	870 x 480 x 800		K: 940 x 445 x 760 D/DW: 940 x 445 x 1040

Technical details are subject to change.

**Synergic continuously  
controlled units:**



Technical Data	CompactMIGpro 210 K	CompactMIGpro 301 K
----------------	------------------------	------------------------

**Primary:**

Power supply	1 x 230 V	1 x 400 V	3 x 400 V
Frequency	50/60 Hz	50/60 Hz	50/60 Hz
Continuous power	3.9 kVA	4.8 kVA	9.0 kVA
Continuous power	17 A	12 A	13 A

**Secondary:**

No load voltage	42 V	42 V	31 - 37 V
Welding voltage	15 - 22.5 V	15 - 24.5 V	15 - 29 V
Range	25 - 170 A	25 - 210 A	25 - 300 A
Duty cycle 35% (10 min.)	170 A (40 °C)	210 A (40 °C)	
Duty cycle 50% (10 min.)			300 A (40 °C)
Duty cycle 60% (10 min.)	120 A (40 °C)	150 A (40 °C)	280 A (40 °C)
Protection	IP 21	IP 21	IP 23
Main switch	with range 1 and 2		
Setting	Stepless with potentiometer or TEDAC torch		
Operation modes	2-stroke/4-stroke, stitch, spot welding		
Energy control	tip control and LED for setting by TEDAC/machine		
Material selection	tip control and LED for steel/stainless steel/ aluminium/CuSi		
Wire diameter selector	0.6/0.8/1.0 mm	0.8/1.0/1.2 mm	
Display	-	option	
Wire feed system	4-roller drive DV-26		
Norm	EN 60974-1 "S"/CE		
Gas bottle holder	10 l or 20 l gas cylinder	10 l, 20 l, 50 l gas cylinder	
Weight	75 kg	120 kg	
Dimensions l x w x h	870 x 480 x 800		940 x 445 x 760



4-roller precision wire feed unit DV-26.



User-friendly with remote control TEDAC® system.



Create your future successfully.

With Merkle. Your specialist for welding units, welding machines, torches and intelligent quality control systems. With own subsidiaries and Merkle dealers in Germany, Europe and many other countries throughout the world.

Welcome to Merkle.

- MIG/MAG Welding Units
- Synergic Pulse Welding Units
- TIG Welding Units
- MMA / Stick Electrode Welding Units
- Plasma Welding and Cutting Units
- Turntables and Roller Drive Units
- Welding and Cutting Torches
- Automation Components and Solutions
- Merkle Robotics

[www.merkle.de](http://www.merkle.de)