The Merkle ColdMIG Process

As much as 30% heat reduction!

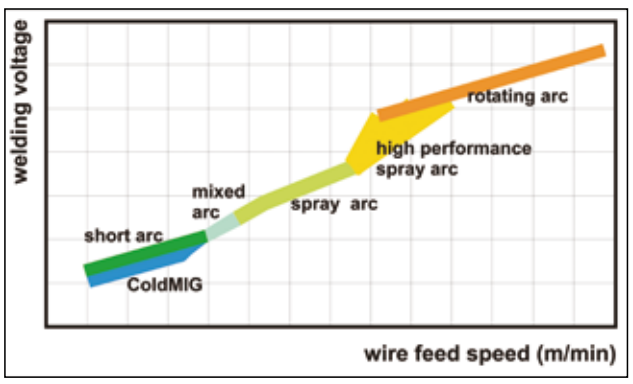
ColdMIG

Application:

- Welding of thin sheet metals 0.6 – 3.0 mm
- High gap bridging capacity
- MIG brazing at low heat input
- Welding of mixed materials
- Welding of coated sheet metals

The Merkle ColdMIG process sets new standards in welding. With as much as 30% less heat input thin metal sheet welding (0.6 – 3.0 mm) is achieved to perfection. Its high gap bridging capacity and optimum welding facility of mixed materials and coated sheet metals are other world class features.

Arc sections

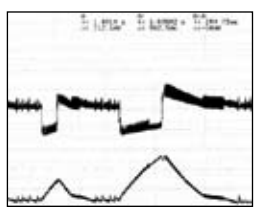


Welding current: 20 – 140 A
Arc voltage: 13.5 – 20 V
Wire feed speed: 0.7-5 m/min

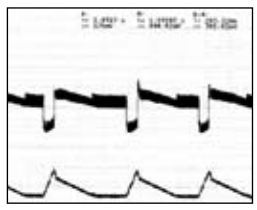
The ColdMIG process principle:

The characteristic curve is controlled in the up- and downslope cycle by an ultrafast digital signal processor.

- Steep controlled upslope in the short-circuit cycle
- Steep (almost vertical) downslope of the current after drop transfer
- Constant frequency of the drop transfer



short arc

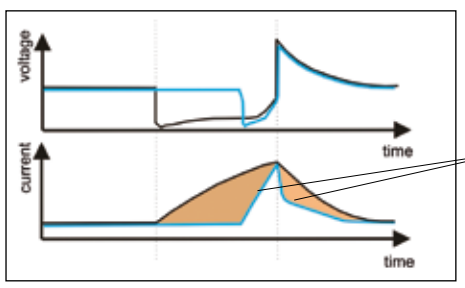


ColdMIG

Process benefits:

Comparison of heat inputs

20-30% less heat input in comparison to conventional short arc welding.



Gap bridging capability

The high gap bridging capability sets new standards even with complex requirements and applications.

MIG brazing of galvanised sheet metals

MIG brazing of galvanised sheet metals to perfection thanks to 30% less heat input.

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