



## Merkle welding torches.

45 years of production expertise!

Merkle has been designing and producing welding and cutting torches for over 45 years. Merkle torches offer compelling technology in every detail.

Optimal welding results with the step controlled MIG/MAG welding machines is realized through the use of the gas cooled welding torches SB 157 G and SB 307 G.

### Functionality and ease of use

- The torch packet has built-in kink protection.
- Hammer and shock protected hand grip, held in place using screws.
- Optimal torch cooling through the double gas guide system (SB 307 G).
- Optional 3 or 4 meter torch lengths.
- Service friendly through the interchangeable tip holders.
- Isolated torch body construction with the SB 307 G.
- Screw fit gas nozzels.
- Our own cost effective consumable production.



**SB 157 G** mixed gas: 150 A 60% duty cycle  
CO<sub>2</sub>: 180 A 60% duty cycle



**SB 307 G** mixed gas: 280 A 60% duty cycle  
CO<sub>2</sub>: 300 A 60% duty cycle



Create your future successfully.

With Merkle. Your specialist for welding units, welding machines, torches and intelligent automation 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)

## MERKLE RedMIG.

The economical MIG/MAG series!





**Merkle RedMIG**

**Functionality and easy operation:**

- Precise setting of the welding current due to 7 or 14 steps.
- Operation modes: 2-stroke/4-stroke/stitch and spot welding.
- Stepless control of welding and intermission time.
- Precise wire feeding unit.
- Euro connector as a standard.
- Wire burn back as standard.
- Thermal protection of the main transformer and rectifier.
- Lowered galvanized gas bottle holder assures a safe positioning of the cylinders.
- Approved for operation in confined areas, S-symbol.
- Easy handling of the unit due to big and robust swivel and carrier wheels.

**MIG/MAG series RedMIG.**

**Quality at a bargain price!**

Through its compact construction, its classic control panel and its robust, stable technology, the RedMIG machines are the perfect answer to any craftsman employing the machine in trade work, vehicle workshops or in the service and repair field.

The product line consists of 5 machines:

**RedMIG 1600 K:**  
Ideal for sheet steel work up to 5 mm. Powered by standard 230 V supply.

**RedMIG 2000 K:**  
The universally adaptable machine with a 200 A welding capability.

**RedMIG 2800 K:**  
Ideal for production, workshops and agricultural use with a 280 A welding current.

**RedMIG 3000 K:**  
The ideal high performance compact machine.

**RedMIG 4000 DW:**  
Solid power with a 400 A welding current capability, a separate wire feed unit and an integrated water cooling system for improved performance.



**The precise flange mounted 4-roller wire feed unit DV-26**

- Comes as a standard in RedMIG 2800/3000 K and RedMIG 4000 DW.
- Big rollers with 2 wire diameters.
- No tools needed for roller changes.
- Easy access at wire insertion.
- Directly flanged EURO torch connector.
- Precise and reproducible wire feed pressure adjustment.



The wire feed system and wire spool mounting points are both open and easy to access.

**Functionality and performance.**

**Well-engineered technology!**

The Merkle RedMIG is the high performance entry class into the MIG/MAG world of Merkle. Attractive pricing, solid configuration and high performance technology set the standard for this product line.



Technical data	RedMIG 1600 K	RedMIG 2000 K	RedMIG 2800 K	RedMIG 3000 K	RedMIG 4000 DW
Power supply	1 x 230 V	3 x 400 V	3 x 400 V	3 x 400 V	3 x 400 V
Frequency	50/60 Hz	50/60 Hz	50/60 Hz	50/60 Hz	50 (60) Hz
Continuous power	3.0 kVA	4.2 kVA	6.2 kVA	8.3 kVA	10.4 kVA
Continuous current	13 A	6 A	9 A	12 A	14 A
Secondary:					
No load voltage	19 - 35 V	17 - 39 V	16 - 42 V	16 - 42 V	17 - 48 V
Welding voltage	15 - 22 V	15 - 24 V	15 - 28 V	15 - 28 V	15 - 34 V
Welding current	25 - 160 A	25 - 200 A	25 - 280 A	25 - 280 A	25 - 400 A
Duty cycle 35 % (10 min.)	160 A (20 °C)	200 A (20 °C)	280 A (20 °C)	280 A (40 °C)	400 A (40 °C)
Duty cycle 40 % (10 min.)					400 A (20 °C)
Duty cycle 60 % (10 min.)	130 A (40 °C)	140 A (40 °C)	210 A (40 °C)	240 A (40 °C)	330 A (20 °C) 310 A (40 °C)
Duty cycle 100 %				200 A (40 °C)	250 A (20 °C) 230 A (40 °C)
Protection class	IP 21	IP 21	IP 21	IP 23	IP 23
Isolation class	H	H	H	H	H
Cooling	AF	AF	AF	AF	AF
Voltage setting	7 steps	7 steps	14 steps	14 steps	14 steps
Wire feed speed	potentiometer	potentiometer	potentiometer	potentiometer	potentiometer
Operation mode	2-stroke/4-stroke stitch/spot welding	2-stroke/4-stroke stitch/spot welding	2-stroke/4-stroke stitch/spot welding	2-stroke/4-stroke stitch/spot welding	2-stroke/4-stroke stitch/spot welding
Spot welding time	potentiometer	potentiometer	potentiometer	potentiometer	adjustable
Intermission time	potentiometer	potentiometer	potentiometer	potentiometer	adjustable
Wire burn back	preset	preset	preset	preset	adjustable
Torch cooling	gas	gas	gas	gas	water
Torch connection	EURO connector	EURO connector	EURO connector	EURO connector	EURO connector
Wire feeding	2-roller drive DV-21 0.7 - 20 m/min.	2-roller drive DV-21 0.7 - 20 m/min.	4-roller drive DV-26 0.7 - 25 m/min.	4-roller drive DV-26 0.7 - 25 m/min.	4-roller drive DV-26 0.7 - 25 m/min.
Norm	EN 60974-1 „S“ / CE	EN 60974-1 „S“ / CE	EN 60974-1 „S“ / CE	EN 60974-1 „S“ / CE	EN 60974-1 „S“ / CE
Gas bottle holder	10 - 20 l gas cylinder	10 - 20 l gas cylinder	10 - 20 l gas cylinder	10 - 20 - 50 l gas cylinder	10 - 20 - 50 l gas cylinder
Weight	65 kg	70 kg	80 kg	120 kg	155 kg
Dimensions l x w x h	800 x 460 x 620	800 x 460 x 620	800 x 460 x 620	940 x 445 x 760	940 x 445 x 1040

Technical details are subject to change.