



IMPULS



STANDARD

**NEW**  
Available for delivery from  
**1st Quarter '08**

**PHOENIX® 333 PULS forceArc®**

**MIG/MAG**

## Maximum mobility

for use on construction sites and assembly work



PHOENIX 330 PULS forceArc

PHOENIX 400, 500 PULS forceArc



MIG/MAG  
pulse welding



EWM forceArc welding



MIG/MAG  
standard welding



MMA welding



TIG welding  
Liftarc

### HIGHLIGHTS

- Maximum efficiency thanks to low-spatter welding with all materials and applications
- Perfect ignition and welding properties with 100 % reproducible results and the highest quality thanks to the fully digital inverter machines
- Maximum flexibility thanks to the modular and future-oriented machine system: Upgrade to fit the need – no additional tools or specialist staff required
- *EWM-forceArc®* – with optimised technology to shorter production times and higher quality – up to 50 % cost saving
- Optimised control interface for every application: PROGRESS with simplest possible operation
- Optimum preset welding tasks (JOBS) and synergic operation – so that you can concentrate fully on your welding task

### AREA OF APPLICATIONS

- Unalloyed, low-alloy and high-alloy steels, aluminium alloys, copper and its alloys, special alloys
- Solid and fluxed-core wire electrodes (0.8-2.4 mm), coated electrodes: Rutile, basic, PHOENIX 500 also suitable for cellulose
- Production and repair work: Chemical and food industries, machine and plant construction, vehicle, automobile, railway vehicle and ship construction, container, closed container and equipment construction, steel and metal construction work, offshore, etc.



**EWM** / **HIGHTEC®**  
**WELDING**

**SIMPLY MORE**

SELF-EXPLANATORY, INTUITIV SYNERGIC OPERATING CONCEPTS FOR EVERY USER

## Welding machine



## PROGRESS

- 115 optimum pre-programmed JOBS (welding tasks) – everything immediately accessible, 16 welding programs
- PowerControl - Up/Down torch

## TECHNICAL DATA

CE IP23 S IEC/EN 60974 EN 50199 PG CB

Welding machine, gas / watercooled	PHOENIX 333 PULS <i>forceArc</i>	
Setting range Welding current	5 A-330 A	
Duty cycle (dc) at 40 °C ambient temperature		
25 % dc	330 A	
60 % dc	250 A	
100 % dc	210 A	
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %) / 3 x 415 V (-25 % - +15 %)	
Mains frequency	50/60 Hz	
Mains fuse (safety fuse, slow-blow)	3 x 16 A	
Max. connected power	13,0 kVA	
Recommended generator rating	17,5 kVA	
Wire feed speed	0,5 m/min - 20 m/min	
Dimensions welding machine L x W x H [mm]	605 x 335 x 520	
Weight welding machine approx.	42,5 kg	
<b>Cooling unit</b>	<b>COOL71 U42</b>	<b>COOL71 U43</b>
Cooling capacity at 1 l/min	1500 W (2/min)	1200 W (1/min)
Max. flow rate	20 l/min	5 l/min
Max. output pressure	4,5 bar	3,5 bar
Tank capacity	7 l	7 l
Dimensions LxWxH [mm]	685 x 370 x 255	685 x 370 x 255
Weight [kg]	25 kg	25 kg
<b>Transport vehicle</b>	<b>Trolley 75 B1</b>	
Dimensions LxWxH [mm]	980 x 505 x 990	
Weight [kg]	34	

Sales, Advice, Service

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**EWM/HIGHTEC**<sup>®</sup>  
**WELDING**  
**SIMPLY MORE**