

# ***MINICITO 2000i***

A multi-process inverter for all welding applications, used in construction, maintenance and repair industries.



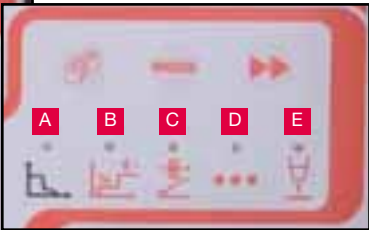
# MINICITO 2000i



Compact and easy to use, this multi-process machine has a front panel designed to allow quick adjustment of the process and parameters selected by the operator.



- 1** Welding process selector
- 2** Welding mode selector
- 3** Welding power regulator
- 4** Wire speed regulator
- 5** Parameter regulation potentiometer
- 6** Digital meter amps & volts
- 7** Euro torch connector
- 8** Arc ignition indicator
- 9** Over voltage protection indicator



## A Arc/trim inductance

The adjustment of the inductance will give a precise weld condition which allows a quality weld with excellent bead appearance and reduced spatters.

## B Soft start

Set as a percentage of the main current which slows the wire until contact is made with the work piece to reduce irregular arc initiation.

## C Slope up time

Sets the slope up time to avoid weld spatter at the start of the weld.

- A** Arc/trim inductance
- B** Soft start
- C** Motor slope up
- D** Spot welding time
- E** Burn back control

## Features:

- Portable (29 kg).
- Multi process:
  - MIG to weld “gas” and “no gas” wires,
  - TIG (lift) with valve torch,
  - MMA (up to diam. 4.0 mm).
- Reverse polarity to allow welding of “no-gas” welding wires.
- 20 Programs:
  - 11 preset,
  - 9 recordable.
- Digital display giving amps and volts.
- Torch connector: Euro.
- Precise control of welding parameters.
- Excellent maintenance and repair machine.



	Min value	Max value	Unit
Electronic Inductance	100	30	%
Soft start	100	000	%
Motor slope up time	00.1	1.50	sec.
Spot welding time	00.1	10.0	sec.
Burn-back time	0.01	1.00	sec.



A portable, single phase multi-process inverter: the ideal solution for repair, maintenance and thin sheet metal welding.

## MINICITO 2000i

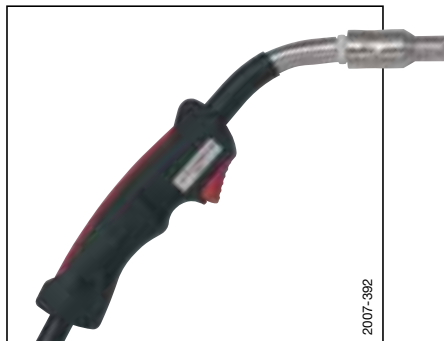
Power source only:

**Cat. no. W 000 261 976**

Package including  
(for French market):

- power source,
- CITORCH M 181 4 m,
- earth cable,
- argon regulator.

**Cat. no. W 000 265 571**

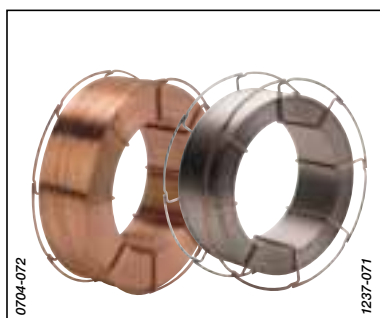


Technical characteristics:	MMA	TIG	MIG
Input data			
Single phase supply	230 V (± 10%)		
Frequency	50 - 60 Hz		
Effective consumption	23 A	16 A	21 A
Maximum consumption	35 A	27 A	35 A
Output data			
Open circuit voltage	70 V	25 V	50 V
Welding current	20 A - 180 A	5 A - 200 A	30 A - 200 A
Duty cycle 35 %	180 A (40 %)	200 A	200 A
Duty cycle 60 %	140 A	155 A	155 A
Duty cycle 100 %	115 A	125 A	125 A
Protection class	IP 23		
Insulation class	H		
European standards	EN 60974.1 / EN 60974.10		
Dimensionnal characteristics			
Dimensions (L x w x h)	570 x 235 x 470 mm		
Net weight	29 kg		
Option			
15 kg spool support	W 000 253 322		

	Wire feeder parts	
<b>Diameter</b>	<b>0.6 - 0.8</b>	<b>1.0 - 1.2</b>
<b>Feed rolls</b>	W 000 352 037	W 000 352 036
<b>Inlet wire guide</b>	W 000 227 907	

Air Liquide Welding offers a wide range of wires available in steel, stainless steel and alloys.

For more details, consult us.



	Wear parts for CITORCH			
	Steel and stainless steel			Aluminium
<b>Diameter</b>	<b>0.6</b>	<b>0.8</b>	<b>1.0</b>	<b>1.0</b>
<b>Contact tip M 141T</b>	W 000 345 612	W 000 345 613	W 000 345 614	-
<b>Contact tip M 181</b>	-	W 000 345 615	W 000 345 616	W 000 345 617
<b>Diameter</b>	<b>11</b>	<b>14</b>	<b>SPOT</b>	
<b>Nozzle M 141T</b>	W 000 345 403	W 000 345 404	W 000 345 405	-
<b>Nozzle M 181</b>	W 000 345 408 (12)	W 000 345 409	-	-

	CITORCH torches			
<b>Length</b>	<b>Duty cycle at 60%</b>	<b>3 m</b>	<b>4 m</b>	<b>5 m</b>
<b>M 141T</b>	150 A	W 000 345 079	W 000 345 080	W 000 345 081
<b>M 181</b>	180 A	W 000 345 082	W 000 345 083	W 000 345 084



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