

Gala Mig 4000 i DP + D-4R i

Synergic modular multiprocessing equipment Pulsed

Ref.: 42800000

Code: FT-42800000K5M v1

Data: 25/09/2024



Currents/Duty cycle: 350 A / 100%

Power supply: 3Ph. 400V –50/60Hz

Main technical characteristics

Technical Characteristics	GALA MIG 4000 i DP
Input voltage U1 (50/60hz)	(3 Ph) 400V ±10%
Maximum input current I1max	22 A
Effective input current I1eff	22 A
Technology Power source	INVERTER IGBT
Efficiency	88 %
Welding processes	MIG-MAG / MMA
Adjustment range I2min÷ I2max	30÷350 A
Welding current I2 100%	350 A / 100 %
Welding voltage U2min-U2max	10 – 40 V (continuous reg.)
Weldable wire diameters	0.8 – 1.0 – 1.2
Winding system	Independent - 4 roulettes
Maximum wire speed	24 m/min
Ventilation	FORCED
Welding connector type	HEMBRA 35-50
Overall dimensions (↑ → ↗) mm	1335-938x551X924
Total weight	85 Kg
Power source weight (without winder)	62 Kg

ACCORDING TO UNE-EN 60974 STANDARDS



Description:

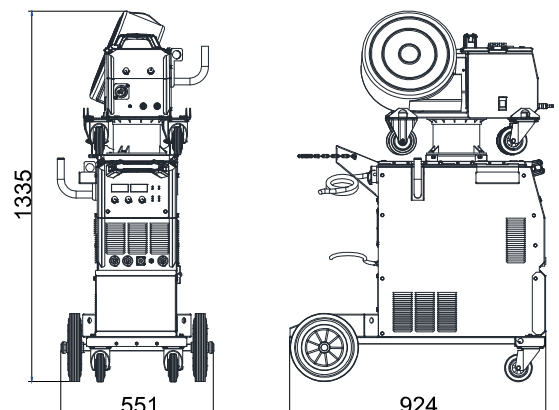
Multiprocess MIG/MAG – MMA welding power source. Synergic-Pulsed Inverter Modular system with independent wire feeder.

Use:

Industrial use. MIG/MAG welding of normal steels, stainless steels and aluminum. Recommended for high performance work with 1.2 mm steel wires. Welding mode with covered electrode (MMA).

Main characteristics:

- Modular system. Heavy Duty: 350 A / 100% – 400 A / 60%.
- Independent winder with high robustness and portability
- MIG-MAG welding of solid wires Ø 0.8-1.0-1.2 mm.
- MIG-MAG flux cored wire welding.
- MMA welding. VRD function
- Synergic power regulation. Ease of operation
- Synergic-pulsed welding programs for steels
- Digital display for regulation and reading of parameters
- Drive motor with 4 rolls system
- Water-cooled option.



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WELDING

Integrated standard accessories		Dry	Refrigerated
Reference	Description		
42800000	GALA MIG 4000 i	X	X
65800000	REFRIGERATION WCS-500i		X
66800000	WIRE FEEDER D-4R i	X	X
43912063	GROUND CABLE 1x50 mm ²	X	X
43512018	CONNECTION MACHINE-GAS(2M)/FITTING	X	X
42416121	2 Roulettes 0.8-1.0 mm "V"	X	X
42416122	2 Roulettes 1.0-1.2 mm(V)	X	X
63800000i	WIRE FEEDER CONNECTION D-4R i (5MT)	X	
63900000i	WIRE FEEDER CONNECTION D-4R i W (5MT)		X

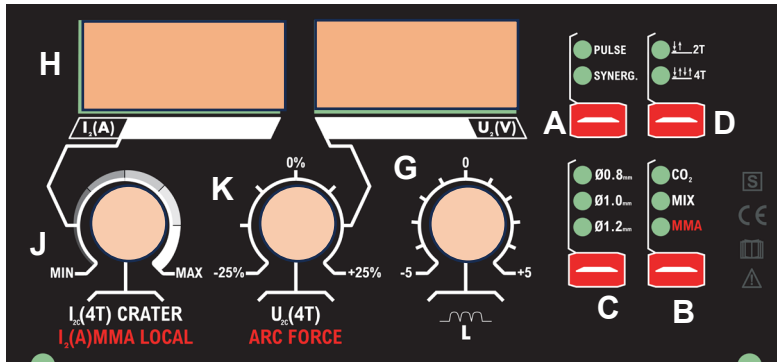
Ref.	Description
63881000i	WIRE FEEDER CONNECTION D-4R i (10MT)
63884000i	WIRE FEEDER CONNECTION D-4R i (15MT)
63882000i	WIRE FEEDER CONNECTION D-4R i (20MT)

Refrigerated winder connection options	
Ref.	Description
63981000i	WIRE FEEDER CONNECTION D-4R i W (10MT)
63984000i	WIRE FEEDER CONNECTION D-4R i W (15MT)
63982000i	WIRE FEEDER CONNECTION D-4R i W (20MT)

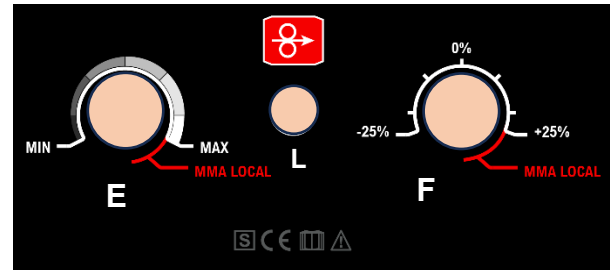
Recommended accessory items	
Reference	Description
880036P	MIG 36 M8 torch
EMIG	Consumables for MIG 36 Torch in case
PK4012	MIG 400 torch - 4 METERS
PK5012	MIG 500 torch - 4 METERS
EMIGPK 400-500	Consumables MIG Torch 400-500 in case
37600000	EN-2 Ar-CO ₂ (315 Kg. /cm ² 28 L/min.)
35500000	ECONOGALA (Gas economizer)
5998F	GASWELD DARK SCREEN
42416127	1.0-1.2 mm "U" roulettes
42416128	1.0-1.2 mm "Estriada" roulettes

DIGITAL CONTROL

Digital power supply control



Control in wire feeder



Function or characteristic	GALA MIG 4000 i DP
MIG-MAG selection manual-synergic-pulsed	Pushbutton A
MAG Fe CO ₂ /Fe Ar-CO ₂ program selection	Pushbutton B
Wire diameter selection	Pushbutton C (0.8 – 1.0 - 1.2 mm)
MIG-MAG welding current I ₂ (A) control	Wire feeder machine control E
Reading of I ₂ (A) set MIG-MAG setpoint	Display H
U ₂ (V) regulation MIG-MAG manual mode	Control F
U ₂ correction (V) MIG-MAG synergic mode)	F control of the wire feeder
I ₂ (A) Crater intensity control (4T mode)	Control J
Reading of I ₂ (A) of set crater current	Display H
Adjustment / correction of U ₂ (V) of crater voltage	Control K
Reading of U ₂ (V) set point	Display I
Electronic control/correction of welding dynamic	Control G
2T-4T cycle control	Control D
Polarity change system	SI (Reversing by connection)
Digital voltmeter-ammeter	Displays (H-I)
Wire purging	Button L
MMA Welding Process	Selection with Control B
I ₂ (A) Regulation of MMA Welding Int.	Control E or J
Reading of I ₂ (A) setpoint MMA	Display H