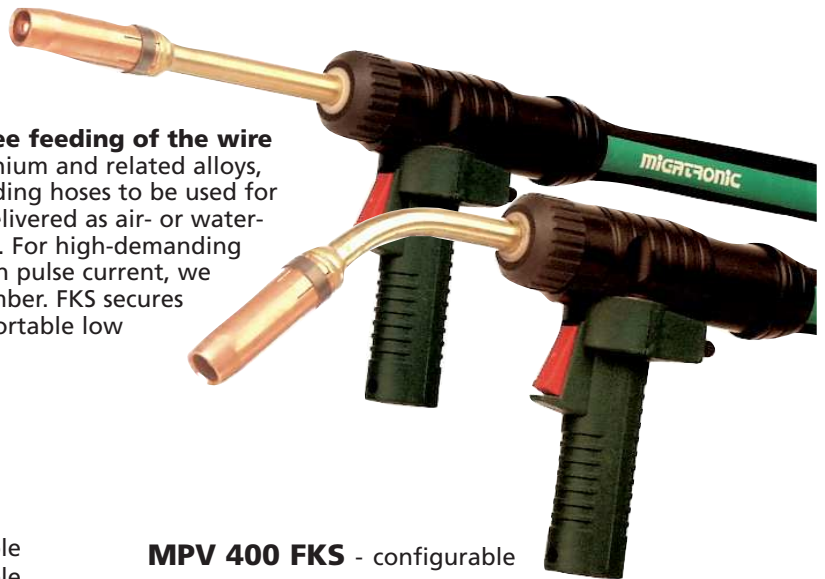


# MIGATRONIC MPL 300 - MPV 400D

## MIG/MAG PUSH PULL WELDING HOSES

### Push pull welding hoses secures a problem free feeding of the wire

With a starting point in an increasing use of aluminium and related alloys, Migatronik has developed a series of Push Pull welding hoses to be used for demanding quality work. The welding hoses are delivered as air- or water-cooled, with straight or turnable curved swan neck. For high-demanding tasks with wide wire diameter or welding with high pulse current, we recommend the FKS type with double cooling chamber. FKS secures extra long endurance of wearing parts and a comfortable low handle temperature for the welder.



## Model MPL 300 - 300D

### Standard models

MPL 300 F	8 m straight	80790302	
MPL 300 F	8 m curved	80790303	
MPL 300D F	8 m straight	80790304	D = turnable
MPL 300D F	8 m curved	80790305	D = turnable

## Model MPV 400 - 400D

### Standard models

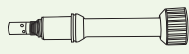

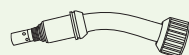

MPV 400	8 m straight	80890402	
MPV 400	8 m curved	80890403	
MPV 400D F	8 m straight	80890404	D = turnable
MPV 400D F	8 m curved	80890405	D = turnable

MPV 400 FKS is configured from standard MPV 400 and →

**MPV 400 FKS** - configurable


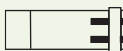

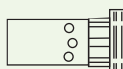
## MPL300/MPV 400

### Swan necks::

	
Straight 80850401 Integrated tip adapter	Straight D KD 80850403 Straight D short KD 80850407
	
Curved 80850402 Integrated tip adapter	Curved D 80850404

D = turnable




### Gas nozzle:

		
Standard: 80240303* 76 mm	80240300 76 mm	80240304 76 mm
Long: 80140700 84 mm	80140701 84 mm	


### Tip adapter:

Short 25 mm M8 Ms	80110401
Long 29 mm M8 Ms	80110402*
Short 25 mm M6 Ms	80110403
Short 25 mm M8 CuCrZr	80110406
Long 29 mm M8 CuCrZr	80110409


### Gas diffuser:

	White 80220309*
	Black 80220306
	Ceramic 80220310

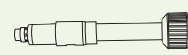

### Insulating disc:

	80220303
	Used with separate tip adapter

### Swan neck


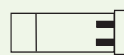
	connecting nut: 80800108
	Used with turnable swan neck

### Swan necks:

	
Straight 80850405	Curved 80850406
Straight D 80850410	

FKS = double cooling system - optimal cooling of gas nozzle.

### Gas nozzle:

		Use 30-38 mm contact tips
80240307* 62 mm	80240308 62 mm	
80240317 67 mm	80240318 67 mm	Use 41 mm contact tips

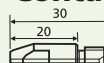
### Tip adapter:

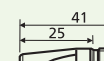
80110408*		24 mm
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FKS models are always delivered with separate tip adapter


## Common for MPV 400 FKS and MPL300/MPV 400

### Contact tip:

	
<b>30 mm E-Cu</b>	
Ø 0.8 M8 80231101	Ø 1.4 M8 80231106
Ø 1.0 M8 80231102	Ø 1.6 M8 80231104
Ø 1.2 M8 80231103*	

	
<b>41 mm CuCrZr</b>	
Ø 0.8 M8 80231400	Ø 1.2 M8 80231402
Ø 1.0 M8 80231401	Ø 1.6 M8 80231404


### Wire liner:

8.5 m	
Kul Ø 2.3 x Ø 4.7	80160705
Rød Ø 2.0 x Ø 4.0	80160135*

### Neck liner:

80160137*	
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### Wire drive roll:

0.8 mm 80700401*	1.2 mm 80700402	
1.0 mm 80700403	1.6 mm 80700404	

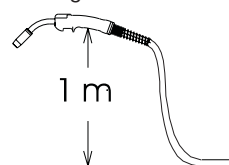
\* = Standard on delivery

# Technical data

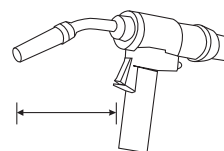
We reserve the right to make changes

Model	MPL 300	MPV 400	MPV400 FKS Configurable
<b>Duty cycle:</b>			
CO <sub>2</sub> 60%		365 A	415 A
CO <sub>2</sub> 100%	275 A	365 A	415 A
Mixgas 60%		325 A	350 A
Mixgas 100%	250 A	325 A	350 A
<b>Technique:</b>			
Cooling	Air	Water	Water
Min. flowrate*			
Watercooling 1 bar ÷		1 l/min.	1 l/min.
Max. Pressure (water) ÷		5 bar	5 bar
Max. Water temp. ÷		70°C	70°C
Gasflow +/-5%	15 l/min.*	18 l/min.*	18 l/min.*
Wire diameter, mm	0.8-1.2	0.8-1.6	0.8-1.6
Cable, mm <sup>2</sup>	60	25	25
Weight **	2 kg	1.7 kg	1.7 kg
Total weight, 8 m	9.5 kg	8.2 kg	8.2 kg
Connection	ZA + 8 pole	ZA + 8 pole	ZA + 8 pole
Length of swan neck ***	Straight 18 cm Curved 16.5 cm	Straight 23 cm Curved 20 cm	Straight 18 cm Curved 17 cm
<b>Norm:</b>			
IEC 60974-7	Yes	Yes	Yes
IEC 60974-10	Yes	Yes	Yes

\*\* Weight



\*\*\* Length of swan neck



\* Minimum gas flow for compliance with maximum performance

## CHOICE OF CONTACT TIPS

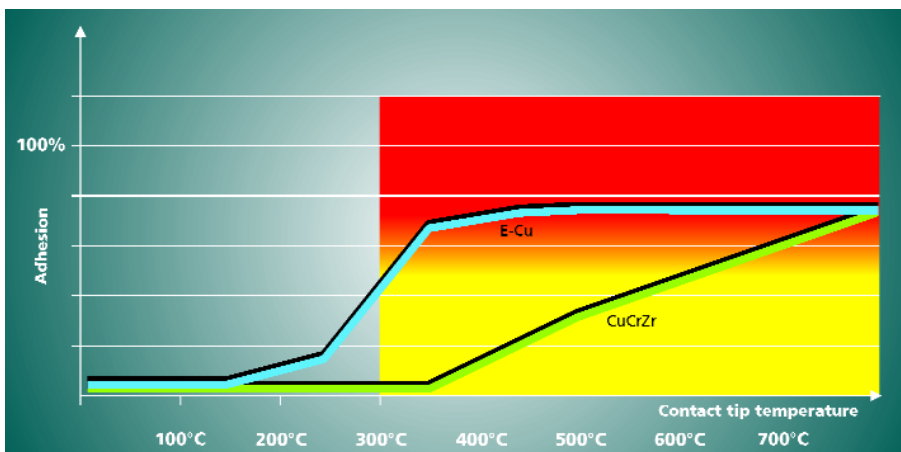
Migatronic ML/MV torches are equipped as standard with E-Cu (copper) contact tips in the most frequently used dimension as well as gas nozzles. In many cases optimization of the nozzle may improve welding properties and/or reduce operating costs.

Contact tips for ML/MV torches are available in different materials and lengths so as to ensure best possible welding result.

For MIG pulse welding and aluminium welding we recommend longer contact

tips, combined with longer gas nozzles, for optimization of welding current and gas shielding.

A slim contact tip will have a lower temperature, as it will receive less radiant heat from the arc. For optimization we recommend CuCrZr (copper, chromium, zirconium) contact tips which are considerably harder and less sensitive to high temperatures contrary to the E-Cu type which will become soft and adhere to the welding wire if the temperature in the contact tip exceeds 300°C (please see the curve below).



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