



Miggytrac 3000

The complete small welding automat for Gas Metal Arc Welding

The Miggytrac 3000 is designed to be used together with ESAB's semi-automatic power sources. The compact and efficient design makes it easy to move and to set up the Miggytrac 3000.

General

The Miggytrac 3000 is a small, compact, motor-powered tractor with integrated wire feed and water-cooled welding torch, designed for horizontal MIG/MAG welding of plates and beams.

Miggytrac 3000 is provided with four-wheel drive. The carriage follows the weld joint by means of one front and one rear guide wheel. The wheels are adjusted so as to make the carriage travel diagonally towards the flange or stiffener to be welded.

Handling

Miggytrac 3000 is provided with two different electronic units, one for the carriage motion and one for the wire feed unit. The parameters are set by way of the plus and minus buttons on the front panel. The set value is indicated on the display. The carriage also has a function for intermittent welding. The length of the beads and the distance between them are set in cm (1-99 cm). For optimal efficiency the distance between the beads is run at transport speed (250 cm/min).

If the power source has no crater-fill function, the backfill function can be programmed on the carriage. This means that the carriage goes backwards for a selected number of mm in order to fill the crater formed at the end of the bead.

If the power source have crater-fill function the carriage can be programmed with a waiting time for finishing the crater-filling.

This facility can also be used for creating a cooling pause before the backfill process is executed.



Through separate electronics the following wire feed parameters can be programmed:
Wire feed speed (Welding current), time for Gas pre-flow, Gas post-flow and Burnback. All the settings are to be done on the front panel. The carriage is dimensioned for wire reels up to 20 kg.

Connections

The welding carriage is to be connected to 42 V AC, directly from the power source by help of a connection cable equipped with gas hose, water hose and welding cable with OKC connection.

The carriage is provided with a potentiometer for remote control of the welding voltage. All electric communication with the carriage operating voltage 42V, start and stop signals to the power source and the potentiometer connection are collected in a 23-pole Burndy contact.

Technical data

Wire dimensions (mm)	Unalloyed steel	1.0 - 1.4
	Stainless steel	1.0 - 1.4
	Cored wire	1.0 - 1.4
Connection voltage		36 - 46 V AC
Power		80 W (max)
Welding speed		15 - 150 cm/min
Transport speed		250 cm/min
Lengths at intermittent welding		1 - 99 cm
Crater-fill time		0 - 9.9 s
Backfill		0 - 9.9 cm
Wire feed speed		2 - 25 m/min
Gas pre-flow / post-flow		0 - 9.9 s
Burnback		0 - 9.9 s
Filler wire reel		12"
Dimensions (l x w x h)		370x400-530x520
Slide adjustment		+/- 17 mm
Remote control, max value		2.5 Kohm
Max current over the start relay		5 A
Connection		with straight 23-pin Burndy
Enclosure class		IP23
Weight excl wire reel		17 kg

Accessories

Contact tip M8 x 37 CuCrZr

CO ₂	Mix / Ar	
1.0	-	0468 502 005
1.2	1.0	0468 502 007
1.4	1.2	0468 502 008
Gas nozzle, water-cooled		0449 903 101
Bent swan neck, 15°		0449 903 115
Bent swan neck, 30°		0449 903 130

Cable key diagram

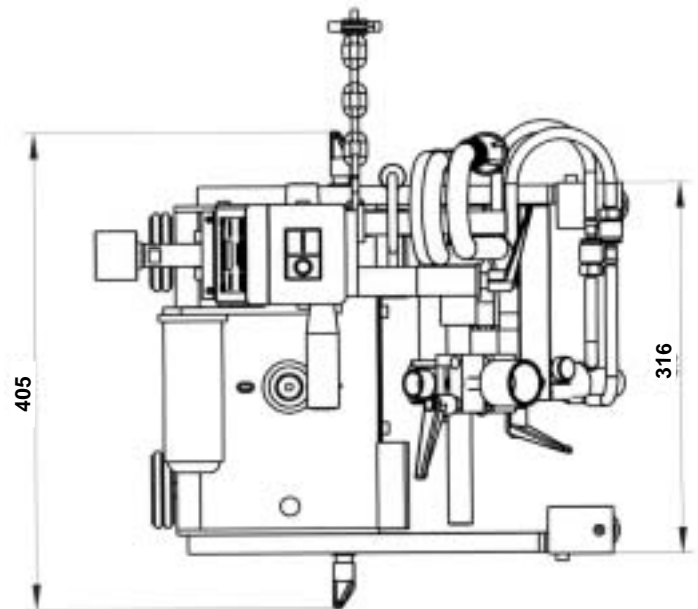
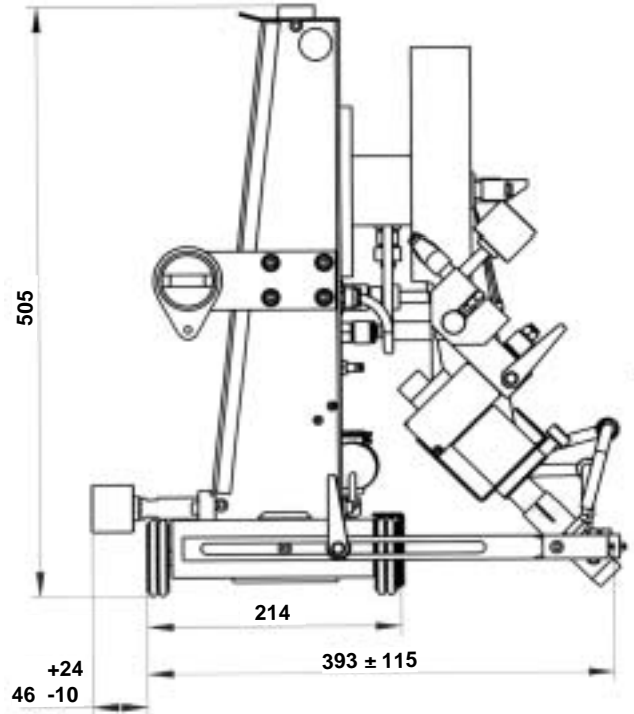
		0469 836 886, 8 m	0469 836 887, 16 m	0469 836 888, 25 m	0469 836 889, 35 m	0469 836 896, 8 m	0469 836 897, 16 m	0469 836 898, 25 m	0469 836 899, 35 m	0414 191 881	Voltage adjustment	Current adjustment	Power	On / off
ESABMig 400tw	ESAB	X	X	X	X						X	X	X	X
ESABMig 500tw						X	X	X	X		X	X	X	X
ESABMig 630tw						X	X	X	X		X	X	X	X
ESABMig 325			X	X	X	X				X		X	X	X
ESABMig 405w			X	X	X	X						X	X	X
ESABMig 505w	23					X	X	X	X		X	X	X	
LAR 630 Magma	23					X	X	X	X	X	X	X	X	
		Connection cable	Connection cable	Connection cable	Connection cable	Connection cable	Connection cable	Connection cable	Connection cable	Water cooling unit OCE 2H				

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Ordering information

Miggytrac 3000, with straight water cooled swan neck 0457 359 880

Delivered without contact tip.
Article numbers for contact tips, see "Accessories"



ESAB reserves the right to alter specifications without prior notice
ESAB is approved according to ISO 9001:2000



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