

NEW MOBILITY IN MIG/MAG PULSED ARC TECHNOLOGY
MEGAPULS 250



A powerful package – portable and multi-functional



Perfect for handcraft, medium sized companies and industrial use

MEGAPULS 250 is a portable pulse unit with an integrated double pulse function which brings high levels of mobility to the successful MEGAPULS range made by REHM. The new multi-functional pulse welding current source allows you to benefit from the highest of quality and the unique REHM SMC® technology. In short: The MEGAPULS 250 is a must for general maintenance, vehicle repair, and industrial welding fabricators.



Professional mobile pulse welding



**Futuristic SMC[®]
technology. Now!
Exclusively with
MEGAPULS 250**

One unit – six processes

The MEGAPULS 250 is a primary pulse inverter 250 A power source that enables optimum welding results using six different welding processes.

- MIG/MAG pulse welding
- MIG/MAG double pulse welding
- Conventional MIG/MAG welding
- MIG brazing
- TIG-DC welding
- MMA welding

Designed for flexible use in an industrial environment, the MEGAPULS 250 displays high levels of mobility and multi-functionality which make it ideal for the wide range of applications required by workshops and medium sized companies. MEGAPULS 250 – the top quality solution for demanding welding tasks, such as,

- Welding of steel, stainless steel and aluminium
- Processing of thick and thin sheets
- MIG brazing of galvanised or aluminium-coated sheets

The MEGAPULS 250 and its unique REHM SMC[®] technology guarantee excellent welding in all processes as well as highly precise and repeatable results.

MEGAPULS 250 – You benefit from:

- **Simple to use**
You concentrate on the welding and SMC[®] does the rest
- **High duty cycle**
Ideal for a demanding industrial environment
- **High level of mobility**
Portable power source with optional trolley and cooler
- **Revolutionary SMC[®] control technology**
For greater efficiency and quality
- **Established SDI technology**
For better weld seam quality and precision
- **Easy to select welding programs**
Synergic welding programs are stored, as standard, in a comprehensive professional database and can be called up for almost any task.
- **Arc with low heat production**
The basic setting of a MEGAPULS 250 is optimised for a short arc and low thermal input, and thus ideal for the heat-reduced welding of thin sheet or for MIG brazing.

Simple to operate

- 1 Operating modes
- 2 Welding procedure
- 3 Selection switch for energy display
- 4 Work setting
- 5 Display of welding current with hold function
- 6 Incremental sensor for welding energy
- 7 Selection and display of synergistic characteristic curves, job numbers and special parameters
- 8 Display of welding voltage with hold function, arc length correction, choke inductance
- 9 Incremental sensor for voltage
- 10 Selection switch for voltage display, SDI setting, arc length correction
- 11 Saving and recall of jobs (maximum of 100)
- 12 Button for special parameter menu
- 13 Button for wire feed
- 14 Button for gas testing



Unique operating concept

Perfect welding results due to the simplest form of operation – the successfully implemented RMI operating concept makes using the MEGAPULS 250 child's play. The consistently logical structure of the operating interface displays all options at a glance. Welding with synergistic welding programs, welding with individual jobs or working with parameters you define yourself.

- Synergistic welding programs for the most frequently used combinations of material type, wire diameter and shielding gas are available at the touch of a button. Select the program, set the welding energy and experience perfect welding!
- Individual machine settings, for example, for welding tasks that are often repeated, can be saved as jobs and thus make your work easier.
- Welding in manual mode allows the user personal freedom for very individual welding tasks.
- All special parameters, for example, gas pre-flow and post-flow time, starting current or downslope time can be modified and saved individually.

Flexible remote control – unlimited mobility

The various torch systems available make the MEGAPULS 250 more versatile and the remote control option increases the level of efficiency.

- Up-Down torches – enable the selection of jobs and job sequences easily from the torch itself.
- Push-Pull torches of up to 12 meters in length
 - make it easier to access tight areas
 - enable constant wire feed
 - relieve the user, who then only needs to move the torch
 - avoid time-intensive feeding

The MEGAPULS 250 has a standard interface for REHM Up/Down torches. The optional REHM universal Push-Pull interface means that all currently available Push-Pull torches can be used.

MEGAPULS 250



Integrated double pulse function

Double pulse welding with alternating double pulse parameters gives an usually good seam appearance, almost like TIG welding but with up to triple the welding speed. Double pulse welding is particularly suitable for the processing of aluminium or CrNi. Your benefits: No time and cost-intensive post welding work.

MIG brazing

New technologies like brazing of CuSi3 or CuAl8 are the current state of technology for the MEGAPULS 250. The integrated welding parameter database CCM makes this possible. MIG brazing perfection – simple, safe and fast.

MEGAPULS 250 is ideal for thin sheet processing as well as processing of galvanised and aluminium-coated sheets.

MMA welding

With its integrated arc force, automatic hot start and anti-stick function the MEGAPULS 250 also enables flexible welding with stick electrodes.

TIG-DC welding

The TIG-DC welding with lift arc ignition and TIG torch with integrated gas valve is also possible, again, offering wide flexibility for all applications.



All in one



SMC® from REHM is based on the intelligent linking of

- SDI stepless, electronic choke
- RSC digital wire feed regulation
- CCM welding database
- RMI operating interface

The completely new and superior machine control concept guarantees excellent welding results and makes operation simple and absolutely safe.

SDI

STEPLESS DYNAMIC INDUCTION



Stepless Dynamic Induction

The stepless, electronic welding choke with ultra fast regulation ensures excellent arc ignition characteristics and a highly stable arc.

- Optimal stabilised arc in the ignition and welding phase
- Minimisation of spatter-formation in semishort circuiting arc
- Considerably less post welding work
- Optimal adaptation of the welding characteristics to the welding conditions, for example, when welding out of position

RSC



Realtime Speed Control

RSC guarantees constant wire feed by means of the real-time monitoring and the highly precise regulation of the wire feed rate with a digital signal sensor.

- Rapid and efficient balancing of arc length modifications
- Constant wire feed rates

CCM



Characteristic Curve Memory

CCM is the integrated welding parameter database with the consolidated knowledge of practical expert experience. It's like having your very own welding expert on hand to set up your machine.

- Automatic setting of the optimal welding parameters by selecting the material thickness, wire diameter and gas type
- Continuous adjustment of the actual values during welding ensure that what you set on the machine is what you get at the welding arc

RMI



REHM Machine Interface

The consistently logical structure of the operating interface displays all options at a glance.

- Perfectly easy to use
- Rapid and safe setting of the correct welding parameters
- Guarantees no operating errors

Performance options from a single source



MIG-COOL CART 100



MEGAPULS 250 + MIG-COOL CART 100

Robust trolley

REHM offers a robust trolley combined with a water cooling unit especially made for the MEGAPULS 250. The MEGAPULS 250 and a water cooling unit can be mounted on this trolley which holds a 50 l water tank. The MEGAPULS 250 is thus also ready for operation in demanding heavy welding with water-cooled torches. The rapid and simple mounting of the machine on the trolley is ensured by the REHM EASY LOCK connection which can be fixed and released in mere seconds.

| TECHNICAL DATA OF THE MEGAPULS 250 | | |
|---|-------|-----------------|
| Type | | MEGAPULS 250 |
| Setting range, stepless | [A] | 10 – 250 |
| Duty Cycle (DC) at I max. (10 min/40°C) | [%] | 40 |
| Welding current at 100 % DC | [A] | 160 |
| Open circuit voltage | [V] | 63 |
| Power supply (50/60 Hz) | [V] | 3 x 400 |
| Sustained performance at 100 % DC | [kVA] | 7 |
| Fuse (slow-action) | [A] | 16 |
| Torch cooling type | | gas (water) |
| Protection class | | IP 23 |
| Insulation class | | H |
| Wire diameter | [mm] | 0.6 – 1.2 |
| Weight | [kg] | 35 |
| Dimensions L x W x H | [mm] | 645 x 370 x 580 |

We reserve the right to make technical changes to reflect further development. All units carry the CE and S marks and meet EN 60 974.

Equipment options and accessories

Our accessories range meets all requirements

- MIG-COOL CART 100 trolley with water-cooling unit and tank holder
- MIG-COOL 100 water cooling unit (on wheels)
- Up-Down torch
- Push-Pull torch
- Wear parts for the torches
- etc.

| TECHNICAL DATA OF THE MIG COOL CART 100 | | |
|---|---------|-------------------|
| Type | | MIG-COOL CART 100 |
| Supply voltage | [V~] | 400 |
| Power consumption | [A] | 0.3 |
| Cooling performance at 20°C / 1.0 l/min | [W] | 900 |
| Feed rate maximum | [l/min] | 1,3 |
| Pump pressure maximum | [MPa] | 0.6 (6 bar) |
| Tank capacity | [l] | 5.0 |
| Net weight (without coolant) | [kg] | 55 |

Product IDs for the carts:

- Order number 7531800 MIG-COOL CART 100
Cart with water cooling unit
- Order number 7531810 MIG-COOL 100
Water cooling unit on wheels

REHM welding technology – about us!

The REHM performance program

- **REHM MIG/MAG inert gas welding units**
 - SYNERGIC.PRO² gas cooled to 450 A
 - SYNERGIC.PRO² water cooled to 450 A
 - MEGA.ARC stepless regulation to 450 A
 - RP REHM Professional to 560 A
 - PANTHER 200 PULS pulse welding unit with 200 A
 - MEGAPULS pulse welding units to 500 A
- **REHM TIG inert gas welding units**
 - TIGER, portable 100 kHz Inverter
 - INVERTIG.PRO water-cooled TIG units (on wheels)
- **REHM inverter technology**
 - TIGER and BOOSTER 100 kHz electrode inverter up to 210 A
- **REHM plasma cutting units**
- **Welding accessories and additional materials**
- **Welding smoke extraction fans**
- **Welding rotary tables**
- **Technical welding consultation**
- **Torch repair**
- **Service**

Development, construction and production – all under one roof – in our factory in Uchingen. Thanks to this central organisation and our forward-thinking policies, new discoveries can rapidly be incorporated into our production. The wishes and requirements of our customers form the basis of our innovative product development. A multitude of patents and awards represent the precision and quality of our products. Customer proximity and competence are the principles which take highest priority in our consultation, training and service. Our products represent the very best of German technology and engineering.

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Technical alterations are subject to change without notice.

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