

FACT SHEET

Picomig 220 - Puls - Synergic - 5kg/D200



all in

Picomig 220 puls

/ MIG/MAG

/ MIG/MAG pulse

/ TIG

/ MMA

Picomig 220 Synergic

/ MIG/MAG

/ TIG

/ MMA



Sample image of a practical combination of a Picomig 220 on a Trolley 54 with option to mount a machine (ON TA TR.21)

TWO VERSIONS AVAILABLE:

Picomig 220 puls TKG:

- Multiprocess pulse inverter welding machine with simple one-knob operation and integrated wire feeder
- GMAW pulsed welding and GMAW standard welding
- Significantly less spatter formation and therefore less finishing work, all thanks to the pulse function
- GMAW pulse welding of aluminium and aluminium alloys
- Characteristics for steel, CrNi, CuSi, aluminium and flux cored wires
- MMA welding and TIG lift arc welding
- Gas-cooled welding torch

Picomig 220 Synergic TKG ¹⁾:

- Multiprocess inverter welding machine with simple one-knob operation and integrated wire feeder
- GMAW standard welding
- Characteristics for steel, CrNi, CuSi, aluminium and flux cored wires
- MMA welding and TIG lift arc welding
- Gas-cooled welding torch

FUNCTIONS

- Infinitely adjustable arc dynamics (choke effect)
- Non-latched/latched operation
- Spot welding
- Interval welding
- Adjustable gas pre-flow and post-flow time
- Superb for welding self-shielded flux cored wires

YOUR BENEFITS!

- High-efficiency current draw thanks to integrated PFC (Power Factor Correction) technology
- No need to purchase additional characteristics – all characteristics for this machine type are included in the scope of delivery ex works
- Portable or mobile with optional transport cart
- Wire spool diameter up to 200 mm/D200
- Sturdy casing suitable for construction sites
- Powerful, high-precision 4-roll wire feeder to reliably feed all solid and flux cored wires Factory fitted for 0.8 mm + 1.0 mm steel wires
- High open circuit voltage for excellent ignition characteristics
- Energy-saving thanks to high efficiency and the standby function
- Simple, tool-free reversal of the welding polarity
- Insulated wire space
- Splash-proof as per IP23
- 3.5 m mains lead with a 16 A earthed plug

¹⁾ Picomig 220 Synergic TKG without pulse function

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HIGHLIGHTS



+ Polarity selection:

Tool-free reversal of the welding polarity (+/-).



+ Park socket:

For secure "parking" of welding current cable for MMA welding.



+ Inspection window:

The wire spool, filling level and drive inlet guide are always in view.



+ Protective rails:

For optimal protection in use.



+ Euro torch connector:

Highly efficient welding torch connector, also suitable for Dinse connector using adapter (ADAP DZA/EZA / 094-016765-00000).



+ Optional dirt and dust filter:

Protects welding machine against extreme contamination. Fast and tool-free mounting and cleaning (ON Filter T.0005 / 092-002553-00000).



+ Wire spool:

wire feeding with a 5 kg/D200 wire spool in a fully insulated wire space is possible with the Picomig 220.

+ 4-roll wire feed mechanism:

Powerful, high-precision 4-roll wire feeder to reliably feed all solid and flux cored wires. Factory fitted for 0.8 mm + 1.0 mm steel wires.



+ ON Trolley Picomig:

The Trolley also allows users to mount a 15 kg/D300 wire spool (ON Trolley Picomig / 092-000312-00000).

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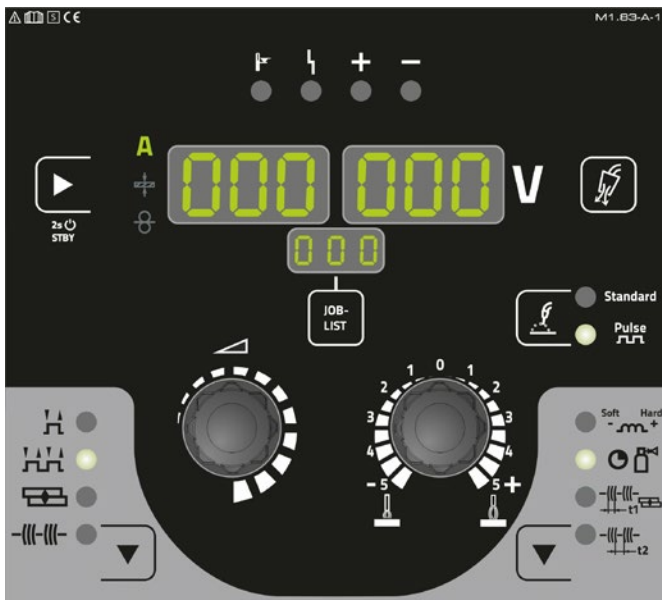
CONTROLS

All welding parameters and functions can be easily and conveniently set using the control. Using the extensive JOB list, users can quickly define and configure all welding tasks.

Quick access to all relevant information, operating instructions, accessories and options for retrofitting using the QR code directly via the control.

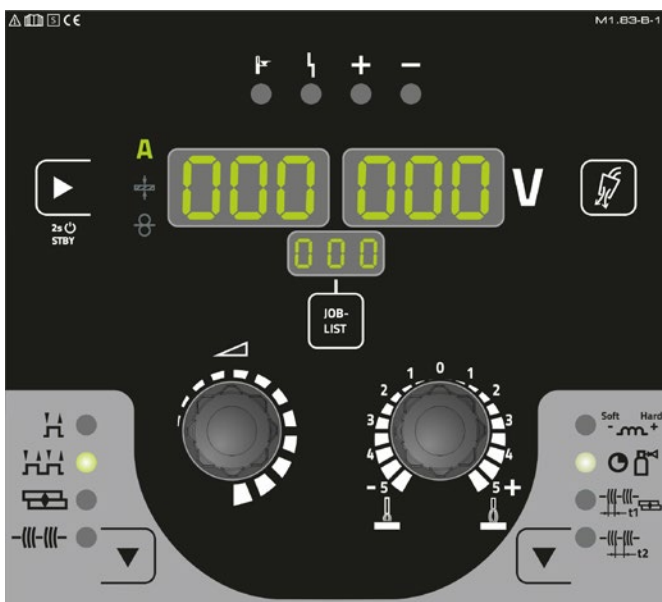


Puls



Operation mode	One-knob operation with pulse function
Welding procedure	MIG/MAG MIG/MAG pulse TIG MMA
Operating modes	Non-latched Latched Spot welding Interval
Parameters in display	Welding current Wire feed speed Material thickness JOB number Error code Polarity display
MMA functions	Hot start Arcforce Antistick

Synergic



Operation mode	One-knob operation
Welding procedure	MIG/MAG TIG MMA
Operating modes	Non-latched Latched Spot welding Interval
Parameters in display	Welding current Wire feed speed Material thickness JOB number Error code Polarity display
MMA functions	Hot start Arcforce Antistick

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TECHNICAL DATA

Versions	Picomig 220 puls TKG	Picomig 220 Synergic TKG
Setting range for welding current	5 A – 220 A	
Duty cycle 40 °C	220 A/30%	
	170 A/60%	
	150 A/100%	
Open circuit voltage	70 V	
Mains voltage/mains tolerance	1 x 230 V (-40% to +15%)	
Mains frequency	50 Hz/60 Hz	
Wire feed speed	1m/min - 18m/min	
	39.37 ipm - 708.66 ipm	
Spool diameter	5 kg/D200	
Protection classification	IP23	
Safety identification		
Dimensions (L x W x H)	559 mm x 276 mm x 340 mm	
Weight	18 kg/39.7 lbs	
Standards	IEC 60974-1, -5 and -10 CL.A	

ITEM NUMBERS

Designation	PU	Item number	PG	Price
Picomig 220 puls TKG	1	090-005680-00502	M3	2920,00 €
Picomig 220 Synergic TKG	1	090-005681-00502	M3	2120,00 €

PACKING UNITS

Designation	PU	Item number	PG	Price
Packing unit: 6 x Picomig 220 puls TKG	6	092-015343-00502	M2	17520,00 €
Packing unit: 6 x Picomig 220 Synergic TKG	6	092-015345-00502	M2	12720,00 €



View the Picomig 220, welding torches, all trollies and other accessories directly in the online shop using the QR code!

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OVERVIEW - SAMPLE COMBINATIONS FOR PICOMIG 220



Trolley 54
+ ON TA TR.21



Trolley 35-1



ON WAK D.09/D.12/T.05



ON Trolley Picomig

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TROLLY TRANSPORT SYSTEMS



+ ON TA TR.21

Trolley 54:

- Transport cart (four wheels) for moving a power source, cooling unit, a tool box and shielding gas cylinder up to 33 l (200 bar)
- Fitted with suspension for cables on the cylinder holder ex works
- Solid, stable design

ON TA TR.21:

- Cross arm for housing a welding machine or wire feeder
- With the ON TA TR.21 (092-004390-00000) cross arm on Trolley 54 (090-008639-00000), only gas-cooled use of the welding machine is possible

Designation	PU	Item number	PG	Price
Trolley 54	1	090-008639-00000	M1	295,00 €
ON TA TR.21	1	092-004390-00000	M1	104,00 €



Trolley 35-1:

- Transport cart (two wheels) for moving a power source and one shielding gas cylinder up to 33 l (300 bar)
- Solid, stable design

Designation	PU	Item number	PG	Price
Trolley 35-1	1	090-008629-00000	M1	554,00 €



ON WAK D.09/D.12/T.05:

- Wheel set – facilitates work at frequently changing welding sites

Designation	PU	Item number	PG	Price
ON WAK D.09/D.12/T.05	1	092-002550-00000	M1	239,00 €



ON Trolley Picomig:

- Trolley Picomig 180 and Picomig 220 with holder for 300 mm wire spool

Designation	PU	Item number	PG	Price
ON Trolley Picomig	1	092-000312-00000	M1	389,00 €

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OPTIONS FOR RETROFITTING



ON CS T.0005/TG.0003/D.0002:

- Crane suspension

Designation	PU	Item number	PG	Price
ON CS T.0005/TG.0003/D.0002	1	092-002549-00000	M1	554,00 €



ON filter T.0005:

- Dirt filter for air inlet

Designation	PU	Item number	PG	Price
ON filter T.0005	1	092-002553-00000	M1	61,50 €

WELDING EQUIPMENT



Proreg Ar/CO2 230bar D:

- Pressure regulator with manometer
- Manufactured in accordance with ISO 2503
- Maximum primary pressure of 230 bar
- Infinite and highly accurate adjustment
- Safety manometer with pressure meter or flow meter (bar/psi or litres per minute)
- With cut-off valve

Versions	Proreg Ar/CO2 230bar 15l D	Proreg Ar/CO2 230bar 30l D
Gas flow	15 l	30 l
Gas type	Argon/CO ₂	
Hose connection	G 1/4"	
Cylinder connection	W21.80 x 1/14"	
Bottle pressure	230 bar	
Standards	ISO 2503	

Designation	PU	Item number	PG	Price
Proreg Ar/CO2 230bar 15l D	1	394-008488-10015	E1	69,50 €
Proreg Ar/CO2 230bar 30l D	1	394-008488-10030	E1	69,50 €



WK25 mm² Ø 9 mm 230 A/60% 4 m/K:

- Workpiece lead with clamp
- 230 A/60%
- Length: 4 m

Designation	PU	Item number	PG	Price
WK25 mm ² Ø 9 mm 230 A/60% 4 m/K	1	092-000016-00000	M12	44,50 €



GH 2 x 1/4" :

- Shielding gas hose
- Equipped with plastic nuts on both sides for tool-free assembly
- Gas type: Argon/H₂/CO₂ (purging gas)
- 6 bar working pressure
- 2 x G1/4" hose connection
- DIN EN ISO 3821
- DIN EN 1256

Designation	Length	PU	Item number	PG	Price
GH 2 x 1/4"	2 m	1	094-000010-00001	E1	19,95 €
	3 m	1	094-000010-00003	E1	28,40 €
	5 m	1	094-000010-00005	E1	38,70 €
	10 m	1	094-000010-00011	E1	57,90 €

WELDING TORCH



PM 221 G M7 :

- Gas-cooled MIG/MAG welding torch with Euro torch connector
- Secure hold thanks to rubber inserts in the grip
- The flexible ball joint makes it comfortable to work with, even in difficult spots
- The torch trigger protection prevents the arc being ignited unintentionally

Equipment as supplied (steel wire Ø 1.0 mm):

- Gas nozzle Ø 13 mm; 66 mm
- Gas diffuser Ø 14 mm; 12.5 mm
- Contact tip M7 x 30 mm; Ø 1.0 mm and contact tip holder M7 x 31.5 mm
- Steel liner blue; Ø 1.5 mm x 3.8 mm



MT 221 G M7 :

- Gas-cooled MIG/MAG welding torch with Euro torch connector
- Robust welding torch with compact, ergonomically shaped grip
- Most suitable for use in tough environments
- Ideal balance between complete robustness and perfect handling

Equipment as supplied (steel wire Ø 1.0 mm):

- Gas nozzle Ø 13 mm; 66 mm
- Gas diffuser Ø 14 mm; 12.5 mm
- Contact tip M7 x 30 mm; Ø 1.0 mm and contact tip holder M7 x 31.5 mm
- Steel liner blue; Ø 1.5 mm x 3.8 mm



UM 24 G M7 :

- Gas-cooled standard MIG/MAG welding torch with Euro torch connector
- Ergonomic grip with ball joint
- Anti-kink spring on both the welding torch and the connection
- Type-related standard consumables

Equipment as supplied (steel wire Ø 1.0 mm):

- Gas nozzle, conical, Ø 12.5 mm; 63.5 mm
- Gas diffuser, 20 mm
- Contact tip M6 x 28 mm; Ø 1.0 mm
- Contact tip holder M6 x 26 mm

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WELDING TORCHES - TECHNICAL DATA

Version	PM 221 G M7	MT 221 G M7	UM 24 G
CO2 duty cycle	250 A / 60%		
M21 duty cycle	220 A / 60%		
M21 pulse duty cycle	150 A / 60%		
Wire Ø	0.8 mm – 1.2 mm		0.6 mm – 1.2 mm
Connection	Euro torch connector		
Thread, contact tip	M7		M6
Lengths	3 m 4 m 5 m		
Torch neck bend angle	45°		
Safety identification	CE EAC UK CA		

WELDING TORCH - ITEM NUMBERS

Designation	Description	Length	PU	Item number	PG	Price
PM 221 G M7	Gas-cooled MIG/MAG welding torch	3 m	1	094-700000-00000	B1	319,00 €
		4 m	1	094-700000-00004	B1	337,00 €
		5 m	1	094-700000-00005	B1	356,00 €
MT 221 G M7		3 m	1	094-500050-00000	B1	307,00 €
		4 m	1	094-500050-00004	B1	325,00 €
		5 m	1	094-500050-00005	B1	346,00 €
UM 24 G	Gas-cooled standard MIG/MAG welding torch	3 m	1	394-600001-00000	B1	97,00 €
		4 m	1	394-600001-00004	B1	109,20 €
		5 m	1	394-600001-00005	B1	120,90 €

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SET

The Picomig 220 is available as a practical and ready-to-weld set in both the Puls and Synergic versions.



Picomig 220 puls TKG set:

- Picomig 220 puls TKG
- MT 221 G welding torch
- Flux cored wire FCW 71T SELFSHIELD 2 kg, Ø 0.9 mm
- Steel wire SW 70S G3 2 kg, Ø 0.8 mm
- Workpiece lead
- Gas hose
- Pressure regulator
- Flux cored nozzle

Designation	PU	Item number	PG	Price
Picomig 220 puls TKG set	1	091-005680-00502	M2	3425,00 €

Picomig 220 Synergic TKG set:

- Picomig 220 Synergic TKG
- MT 221 G welding torch
- Flux cored wire FCW 71T SELFSHIELD 2 kg, Ø 0.9 mm
- Steel wire SW 70S G3 2 kg, Ø 0.8 mm
- Workpiece lead
- Gas hose
- Pressure regulator
- Flux cored nozzle

Designation	PU	Item number	PG	Price
Picomig 220 Synergic TKG set	1	091-005681-00502	M2	2625,00 €