

MPi 180

**MIG/Stick/TIG (Multiprocess)
Arc Welding Power Source**



Quick Specs



Industrial Applications

Light Fabrication
Maintenance and Repair
Auto Body
Farm/Home

Processes

MIG (GMAW)
Stick (SMAW)
TIG (GTAW)
Flux Cored (FCAW)

Input Power

230 VAC, 50/60 Hz, Single-Phase

Rated Output

MIG: 90 Amps at 18.5 VDC, 100% Duty Cycle
Stick: 80 Amps at 23.2 VDC, 100% Duty Cycle
TIG: 90 Amps at 13.6 VDC, 100% Duty Cycle

Amp/Volt Range

MIG: 30–180 A, 15.5–23 V
Stick: 5–175 A, 20.2–27 V
TIG: 5–175 A, 10.2–17 V

The Power of Blue.®

Portability is number one when you have to go to the job — because it can't come to you. The MPi 180 contains all you need to MIG weld in one small lightweight package. With the flip of a switch, all processes are available to meet the application at hand.

Synergic user interface with digital display to simplify set up and offer precise settings for welding a variety of materials.

Full weld process capability. MIG/MAG, Stick, and TIG are available to meet the demand of current applications.



Industrial 2-gear-driven system features no-tool, quick-change reversible drive rolls (0.8/1.0 mm) and an easy-to-set tension adjustment knob.

Thermal overload protection shuts down unit and activates **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.

Manual mode allows simple adjustment of parameters for welding on a broad range of applications.



Excellent arc characteristics! The MPi 180 offers positive arc starts and an extremely stable arc with minimal spatter on both mixed gases and straight CO₂.



Easy access to output studs provides **convenient polarity changeover** when changing from solid or flux cored wires.

Synergic welding mode offers the simplicity of knobs control. The machine will select the correct voltage and amperage based on the wire feed speed (WFS) set by the operator.

Adjustable Hot Start™ for Stick arc starts. Adjust the optimal start current for the application. The current automatically increases the output amperage at the start of a weld.

Adjustable slope time and burnback controls allow operator to optimise arc starts and stops with a variety of wire sizes, and reduce wire stubbing or wire burning back into the contact tip.



Warranted for 3 years, parts and labour.



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Specifications (Subject to change without notice.)



Model	Input Power	Welding Mode	Rated Output (Duty Cycle)			Max. Open-Circuit Voltage	Amperage/Voltage Range DC	IP Rating	Dimensions	Weight
			100%	60%	35%					
MPi 180	230 VAC, 50/60 Hz, Single-phase	MIG	90 A 18.5 V	115 A 19.8 V	180 A 23.0 V	30 V	30–180 A 15.5–23.0 V	IP22S	L: 548 mm (21.6 in) W: 237 mm (9.3 in) H: 365 mm (14.4 in)	15.2 kg (33.5 lb)
		Stick	80 A 23.2 V	100 A 24.0 V	175 A 27.0 V	58 V	5–175 A 20.2–27.0 V			
		TIG	90 A 13.6 V	115 A 14.6 V	175 A 17.0 V	58 V	5–175 A 10.2–17.0 V			

Drive Roll Kits

Drive Roll and Wire Guide Kits for MPi 180

Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. U-Grooved rolls for soft and soft-shelled cored wires.
3. U-Cogged rolls for extremely soft-shelled wires (usually hard-surfacing types).
4. V-Knurled rolls for hard-shelled cored wires.

Wire Size	Drive Roll	Type	Wire Guide Inlet
0.6/0.8 mm (.023/.030 in)*	156 053 051	V	156 090 022
0.8/1.0 mm (.030/.035 in)*	156 053 109	V	156 090 022
0.8/1.0 mm (.030/.035 in)*	156 053 121	U	156 090 022
0.8/1.0 mm (.030/.035 in)**	156 053 053	U	156 090 022
1.0/1.2 mm (.035/.045 in)*	156 053 110	V-K	156 090 022

*Available in steel, 30 mm diameter. **Available in nylon, 30 mm diameter.

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
MPi 180	#059 016 009	230 VAC, 50/60 Hz, single-phase. Includes work clamp		
Accessories				
TIG Torch	WTC9AA4AG CS130AGA4CG-I	125 Amps DC, 100 Amps AC, 60% duty cycle 130 Amps DC, 100 Amps AC, 60% duty cycle		
MIG/MAG Torch	Q2010A08DE	200 Amp Q-Gun with 3 m (10 ft) cable		

Date: Total Quoted Price:



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