Pulsed MIG/MAG Line

The great advantages of digital welding
Selco speaks your language

Welding professionals that, with listening, taking care of quality, passion and commitment, create services and products able to deliver growth and innovation opportunities to customers, opening new path to travel. Our strength is a continuous and active dialogue with customers to identify the suitable welding solutions, in line with technology and market evolution. A brand-new way of talking about welding, without empty words or slogans, but enriched with action and results. The Selco welding language.
Selco Pulsed MIG/MAG

A history of innovation

Since it was formed in 1979, Selco has always specialised in electric arc welding. Today, Selco leads the field in supplying equipment and solutions capable of improving the welding process and exploiting the latest technology. Selco has continuously developed and extended its range of products and services over the years to become one of the top names in European welding today. Selco offers a complete range of solutions for MIG/MAG welding, capable of satisfying all industrial and technological needs. Selco welding systems are reliable and efficient and incorporate highly innovative technical solutions, many of which are protected by international patents.
Pulsed MIG/MAG

- PulsDrive
  - QuickPulse 2.0
  - CladPulse
- Welding programs
- MIG/MAG functions
- Accessories
- WPS EN 1090
- Genesis
  - PMC/PME
  - MTE/GSM
- After Sales
- Welding Advisor Training
- Industry 4.0
  - Weld@Net
- Welding Advisor Training
As soon as you start welding with PulsDrive, you get an instant impression of being in complete control. Arc maneuverability is truly extraordinary thanks to high-speed feedback, and guarantees excellent results in manual welding. PulsDrive lets you express your own welding style while achieving the best possible results.

**CHARACTERISTICS**

- New waveform developed entirely by Selco and controlled by proprietary software.
- 100% digital control of the welding arc: extremely rapid response and tuning of welding parameters for consistently excellent results.
- **PulsDrive** can be used with excellent results in all applications and environments.

The Digital Welding technology represents a whole new approach to welding and guarantees consistent and repeatable performance in pulsed MIG/MAG applications.
PulsDrive offers a large number of advantages, in terms of maneuverability, excellent finish and optimised metallurgical properties of the weld bead.

**ADVANTAGES**

- Extremely stable welding arc thanks to uniform, pulsed transfer of material in tiny, constant-size droplets.
- Almost total absence of spatter, meaning less reworking.
- Marked decrease in heat input and resulting reduction of the heat-affected zone.
- Optimal solution for welding thin materials.
BRILLIANT ON ALL
The right PulsDrive process for all materials

STAINLESS STEEL
Metal commonly used in all applications demanding high resistance to corrosion and oxidation. PulsDrive guarantees excellent results in terms of appearance and metallurg.

ADVANTAGES
• Increased “spreadability” and resulting easy-to-weld.
• Marked decrease in heat input and resulting reduction of the heat-affected zone.
• Good-looking result of the weld bead in appearance and coloring.

COPPER ALLOYS
Fine droplet size and pulse speed control ensures the deposit of a consistent and uniform overlay.

NICKEL ALLOYS
With PulsDrive, cladding with nickel and Cr-Co based alloys is impressively stable and precise. A highly regular arc, ensures no spatter and excellent deposition with limited dilution of the base metal.

selco
THE WELDING LANGUAGE
ALUMINIUM ALLOYS

Light weight, mechanically resistant metal common in many applications. Aluminium welding with PulsDrive delivers the perfect combination of productivity and appearance.

ADVANTAGES

- Low heat-input for excellent results with thin metals.
- Transfer in uniform, small droplets limits surface smoke formation.
- Excellent spreadability and thanks to the Double Pulse function it is no longer necessary to use the “oscillation” welding style.

CARBON STEEL

Material common to many areas of industry. PulsDrive welding is the perfect solution for maximum cleanliness and flexibility and also increases productivity.

ADVANTAGES

- Spatter-free welding that drastically reduces reworking.
- Excellent results over a wide range of thicknesses; perfect welding even with sheet and pipe.
QuickPulse 2.0
Getting faster

QuickPulse 2.0 has been designed and developed by Selco to maximise productivity and speed. Thanks to an improved wave form and more precise arc control, welding speed is faster than ever.

**ADVANTAGES**

- A very stable and focused arc, even at high welding speed.
- Easy welding control and noise reduction.
- Reduced heat input that ensures less deformation and eliminates undercutting.
- Thanks to a more concentrated arc, the welding speed is up to **50% faster than in a standard pulsed MIG/MAG process**
- Good-looking weld bead and no welding spatters.
- Reduction of welding time and costs.

Standard pulsed MIG/MAG process

+50%

MIG/MAG
QuickPulse 2.0
CladPulse
Specially developed for the cladding professional

Selco’s R&D department has developed and perfected a special pulsed MIG/MAG process for industrial cladding. The result is CladPulse, a process that combines the high standards of safety, reliability and competitiveness that industry demands. The CladPulse process has been awarded ASME certification by an accredited body.

ADVANTAGES

- High-Deposition rate welding arc.
- Minimal penetration and an extremely low percentage of dilution.
- No lack of fusion.
- High corrosion resistance.
- ASME certification by accredited body.
Selco has developed quick and easy synergic welding parameter settings for its machines to satisfy a wide range of needs. Settings are determined automatically on the basis of welding conditions (material, thickness, gas, wire, speed) and are dynamically controlled and balanced by a microprocessor control system throughout the welding process. This solution delivers excellent results in terms of productivity, quality and finish in all conditions and all applications.

Selco provides a range of synergic programs as standard and can also develop new programs to meet specific user requests.
### CARBON STEEL

<table>
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### STAINLESS STEEL

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### QUICKPULSE 2.0

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THE RIGHT SOLUTION FOR ALL WELDING JOBS
Exploring pulsed MIG/MAG

Decades of experience and know-how have allowed Selco to develop specific functions to make the welding work easier, better and more effective in different situations. These functions provide effective welding solutions that speed up the flow of the entire production process. Functions can be activated simply and intuitively from the control panels of Selco welding machines.

A complete list of available MIG/MAG functions can be found in the operating manuals of Selco equipment.

CRATER FILLER
This function modifies welding current at the start and end of a weld bead.
- This means excellent finish at both ends of the weld.
- The function also optimises the transition between the heating and welding phases.

ARC DYNAMIC
This special function allows to adapt the “arc dynamic” to your own needs.
- It lets you choose your own style of welding.
- More aggressive arc for a root pass or greater penetration.
- Softer arc for finishing or facing.

DOUBLE PULSE
In this mode, users can activate arc “pulsing” and select the desired amplitude.
- Extremely useful function for welding thin metals.
- Creates a particularly attractive welding bead.
- An excellent solution for welding the edges of aluminium alloy sheets thanks to the special heating/cooling effect.
SOFT START

Lets users set the welding speed at the start of the work.

- Trouble-free, regular arc ignition.
- Reduced spatter at the start of welding.

MIG BILEVEL

Another interesting function that lets you set a secondary current to complement the main current (lower or higher), easily activated from the torch button.

- Great flexibility for welding joints of different shape and thickness.
- Increased productivity with no stops to adjust the system.
European directives impose the requirement of CE marking even on fabricated steel structures. To simplify the certification process, Selco supplies welding equipment that incorporate procedures conforming to EN 1090-2. These procedures refer to the most common execution conditions (EN 1090-2, Table 12, Execution Class EXC2) and cover most used welding needs in the field of steel fabrication. Selco welding equipment come complete with a well-ordered collection of applicable documentation and standards (WPS, WPQR, certificates).

ADVANTAGES

- Lower certification costs.
- Simplified certification process.
- Wide range of procedures (WPS) available.
## WPS Information

**WPS No:** 346135

**Process:** MIG/MTG

### Welding Procedure Specifications

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<td>Travel speed</td>
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<tr>
<td>Welding speed</td>
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<tr>
<td>Shielding gas</td>
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</tbody>
</table>

### Material

- **Base material:** Stainless steel, carbon steel
- **Base material thickness:** 4 mm

### Welding parameters

- **Current:** 180-200 A
- **Voltage:** 20-23 V
- **Feed rate:** 0.8 m/min
- **Linestop:** 100 mm

#### Welding procedure

- **Preparation:** Clean and dry the weld area
- **Postwelding:** Immediately after welding, the weld area is cooled to room temperature.

#### Welding defects

- **Surface defects:** No defects expected
- **Roots:** Clean and sound
- **Welding areas:** Full penetration

### Diagram

![Diagram of welding procedure](image)

### Symbols

- **1:** Welding defects
- **2:** Welding procedure

### EN 1090

This document conforms to EN 1090, ensuring compliance with the latest standards.
EQUIPMENT FOR ANY WELDING NEEDS

Selco has been designing, developing and producing inverters for arc welding applications for over 30 years. Selco has also applied its vast expertise and practical experience to the development of welding control software that is efficient and precise in all working conditions.

Green Welding

Genesis are equipped with green@wave® patented technology for extremely high efficiency in mains current absorption (PF~1), according to European Standard EN61000-3-12.

Robot Ready

Selco Genesis can be used in automatic and/or robotised welding systems by installing the dedicating operating software. Selco’s automatic welding power sources are complete with all the hardware and software components needed for use in any application.

A complete range of inverters offering different configurations, power and accessories, for MIG/MAG, pulsed MIG/MAG, TIG DC Lift and electrode (MMA) welding processes.
PATENTED INVERTER

The key component in Selco’s welding power sources is Selco’s own, patented, Multiline Three Level inverter. This modern and technically advanced inverter delivers unbeatable performance and reliability over time.

It also gives significant advantages in terms of arc control speed, complete function management, adaptability to different processes and applications, accuracy and repeatability.

Selco pulsed MIG/MAG inverter power sources are available in the PMC, PME, MTE and GSM Genesis series, both offering the characteristics and performance needed to satisfy all industrial welding needs.

Genesis power sources are equipped with Selco iPanel control panels incorporating graphic displays and an intuitive user interface that are unique in their field.

Selco’s exclusive Weld@net® Production Control Monitor software lets you control a number of power sources simultaneously from your PC, as well as display and adjust all their welding parameters. Weld@net® PCM also lets you calculate and verify the quality and productivity of automatic and manual welding systems using an advanced production and cost reporting system.

Inverter power sources line capable of welding in all arc processes: MIG/MAG, pulsed MIG/MAG, TIG DC HF and electrode (MMA). Selco’s multifunctional power sources are highly practical solutions whenever welders have to use a number of different processes and therefore demand flexibility as well as high performance.
By pressing this button, pre-installed synergic welding programs become available for the most common materials (carbon steel, stainless steel, aluminum, cored wire).

In the basic control system, two practical knobs let you set wire feed speed and welding voltage, with values shown on displays alongside.

Another important function is the one for customization of welding programs. With this button you can store your own programs and recall them when needed in an extremely simple way.
This unique interface incorporates a generous, high visibility, 3.5" display. Operation is simple and intuitive, with a single menu structure for all Selco equipment.

Large, sensitive buttons and an encoder knob let you access and change welding parameters quickly and easily under all conditions, recall useful functions for the job in hand and activate special and WPS welding programs according to customer specifications.

There’s plenty of room for customisation too: users can easily store settings for specific jobs and recall them instantly when needed.
GET YOUR MIG/MAG ON LINE

Hardware & software system for the control and management of industrial welding

TEAMWORK

Modern industrial welding requires complete and detailed supervision and management in order to ensure efficiency, reliability, low costs and high returns on investment for the entire production cycle. In response to the fundamental needs of advanced industrial users, Selco has designed, developed and implemented Weld@Net, a complete system of hardware and software components for controlling and managing arc welding processes.

ADVANTAGES

• Full control of complete welding lines and individual stations from a single terminal ensures uniform and repeatable conditions and parameters for all welding operations.
• Clear and complete recording and summary of welding process parameters, with reports and charts to ensure effective performance evaluation and rapid corrections if needed.
• A precise and reliable tool for measuring and calculating welding costs. Indispensable for obtaining the precise industrial cost of welding.
GLOBAL PARTNER

All Selco system components, welding programs and processes, welding power sources, peripherals like wire feeders and cooling units, accessories and interfaces are designed and made to dialogue one with the other and to form a single, efficient system in the hands of our customers. All parameters and values are monitored in a simple, intuitive manner and can be accessed remotely from any point in the network. A reliable, global partner for all your Industry 4.0 projects.

ADVANTAGES

- PC monitoring of all welding process parameters and the option of interfacing with company ERP/MES Equipment.
- Selco products and services are the result of constant research and technical innovation and conform perfectly to the guidelines for developing Industry 4.0 systems.
- ICIM, a leading notified body, certifies that Selco products and services are suitable for integration in industrial systems to which Industry 4.0 apply.
A COMPLETE RANGE OF ACCESSORIES

Whatever your MIG/MAG welding requirements, Selco has everything you need for more efficient, modern welding. Our offer is based on a complete range of components, accessories, kits and tools for making the welder’s work easier and more efficient.

Wire feeders

Remote controls

MIG/MAG torches
Cooling units

Trolleys

Accessories
## PULSED MIG/MAG SOLUTIONS

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<tr>
<th>GENESIS 2200 PMC</th>
<th>WELDING</th>
<th>Arc Drive</th>
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- Standard
- Optional
WE UNDERSTAND YOUR WELDING NEEDS

We use our know-how and experience to help customers find the most suitable welding solution for their specific quality and productivity objectives. We also have the organisation and competence to offer training and continuous learning courses on welding technology and our own products.
• Support for the development and optimisation of welding lines
• Training in the understanding and use of welding technologies and Selco welding equipment
• Training courses for welding technicians
Welding your own products in your own workshop is always the best way to assess the advantages and features of welding equipment and processes.

Get in touch with your nearest Selco Service Point and book a weld-drive session with Selco equipment or write to:

weld-drive@selcoweld.com
Even after your Selco welding system has been installed, you can count on our staff to help with any requirement, whether simple maintenance or the upgrading or expansion of your equipment.

- 5 year warranty
- Scheduled maintenance plans
- System validation/calibration
- Predictive and cognitive maintenance
- System updates and upgrades
FIELD EXPERIENCE

Application
Power industry

Process
PulsDrive

Material
Stainless steel

Equipment
Genesis 3200 PME

Settings
240A / 28V

User feedback
Full penetration welding

Application
Food industry

Process
PulsDrive

Material
Stainless steel

Equipment
Genesis 4000 GSM

Settings
200A / 24V

Function enabled
Soft Start

User feedback
A visible reduction in spatter
PULSED MIG/MAG

Application
Railways

Process
PulsDrive

Material
Aluminium alloy

Equipment
Genesis 4000 PME

Settings
150A / 20V

Function enabled
Double Pulse

User feedback
Significant improvement in productivity

Application
Storage tanks

Process
QuickPulse 2.0

Material
Carbon steel

Equipment
Genesis 3200 PME

Settings
220A / 28V

User feedback
Regular, well spread and without defects weld bead
EVERYTHING FOR YOUR SAFETY
The importance of a job well done

Selco welding processes and equipments are designed to ensure maximum safety for welders in their places of work. Fume emission is minimal and welding equipment are equipped with all the latest control devices to ensure the health and wellbeing of operators under all conditions. Selco also offers customers an annual check-up service, complete with the testing and validation of safety devices, to ensure that welding quality and efficiency remain as high as they were on the first day of use.
Pulsed MIG/MAG Line

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