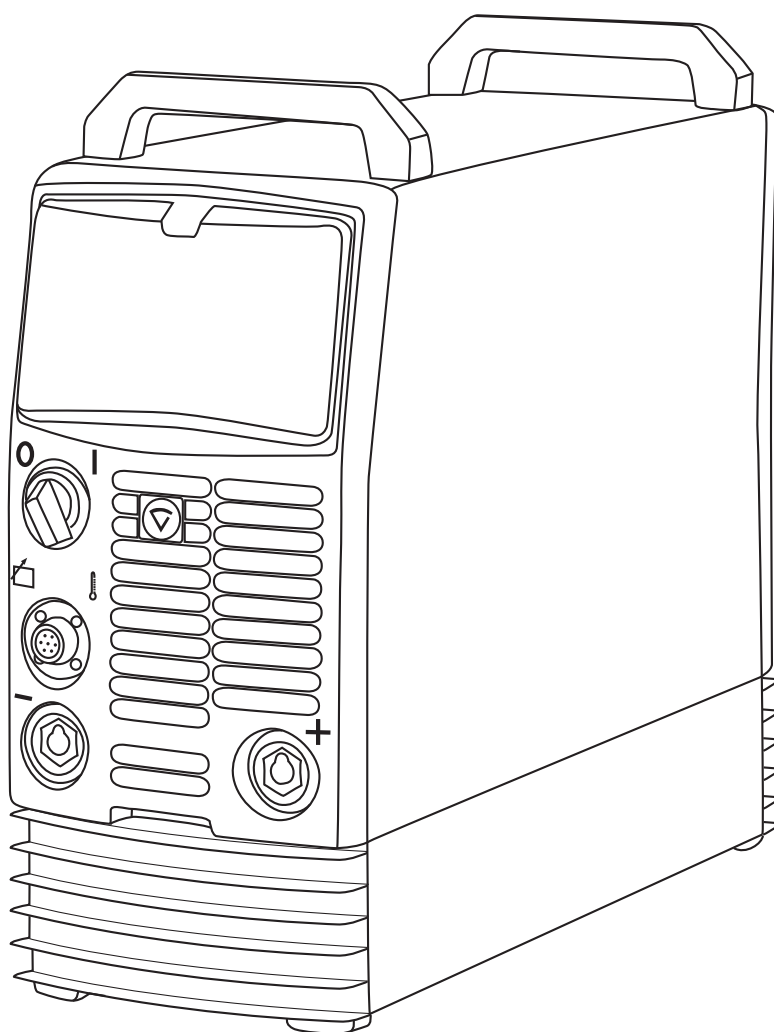


FastMig

M 420MV



Operating manual **EN**

Brugsanvisning **NO**

Manual de instrucciones **ES**

Manual de utilização **PT**

OPERATING MANUAL

English

CONTENTS

1.	Introduction	3
1.1	General	3
1.2	About FastMig M 420MV	4
1.2.1	Operation control and connectors	4
1.3	Accessories	4
1.3.1	Remote control devices	4
1.3.2	Cables	5
2.	Installation	6
2.1	Positioning of the machine	6
2.2	Distribution network	6
2.3	Connection to the mains supply	7
2.4	Welding and earth return cables	7
3.	Operation controls	8
3.1	Main switch I/O	8
3.2	Pilot lamps	8
3.3	Operation of cooling fan	8
4.	Manual metal arc welding	8
5.	Maintenance	9
5.1	Daily maintenance	9
5.2	Periodic maintenance	9
5.3	Service Workshop maintenance	9
6.	Operation disturbances	10
7.	Disposal of the machine	10
8.	Ordering numbers	11
9.	Technical data	12

1. INTRODUCTION

1.1 General

Congratulations on choosing the FastMig welding equipment. Used correctly, Kemppi products can significantly increase the productivity of your welding, and provide years of economical service.

This operating manual contains important information on the use, maintenance and safety of your Kemppi product. The technical specifications of the equipment can be found at the end of the manual.

Please read the manual carefully before using the equipment for the first time. For your own safety and that of your working environment, pay particular attention to the safety instructions in the manual.

For more information on Kemppi products, contact Kemppi Oy, consult an authorised Kemppi dealer, or visit the Kemppi web site at www.kemppi.com.

The specifications presented in this manual are subject to change without prior notice.

Important notes

Items in the manual that require particular attention in order to minimise damage and personal harm are indicated with the '**NOTE!**' notation. Read these sections carefully and follow their instructions.

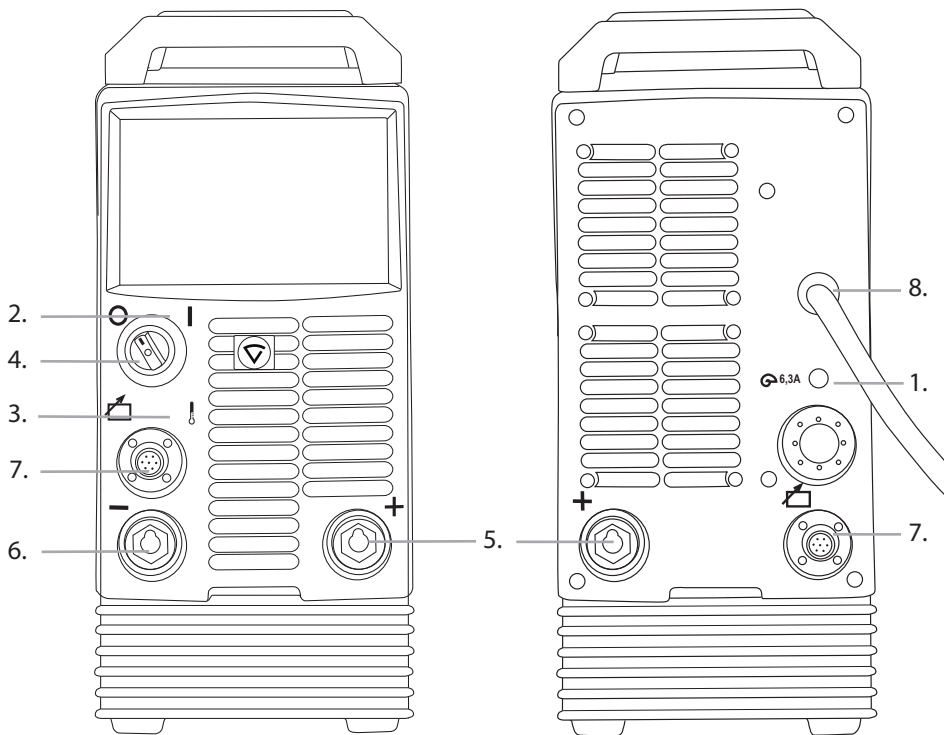
Disclaimer

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. Kemppi reserves the right to change the specification of the product described at any time without prior notice. Do not copy, record, reproduce or transmit the contents of this guide without prior permission from Kemppi.

1.2 About FastMig M 420MV

FastMig M 420MV is multi-operator power source designed for demanding professional use. It is suitable for MMA and MIG welding in DC.

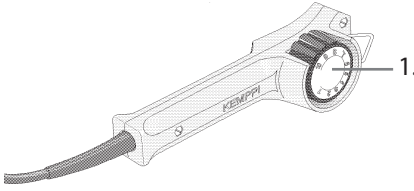
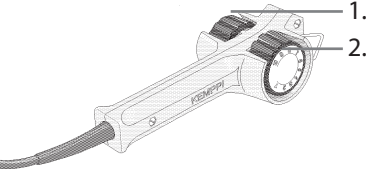
1.2.1 Operation control and connectors



1. Fuse (delayed 6.3 A)
2. Signal lamp
3. Warning lamp for thermal protection
4. Main switch
5. Welding connection
6. Earth connection
7. Control cable connection
8. Inlet of mains cable

1.3 Accessories

1.3.1 Remote control devices

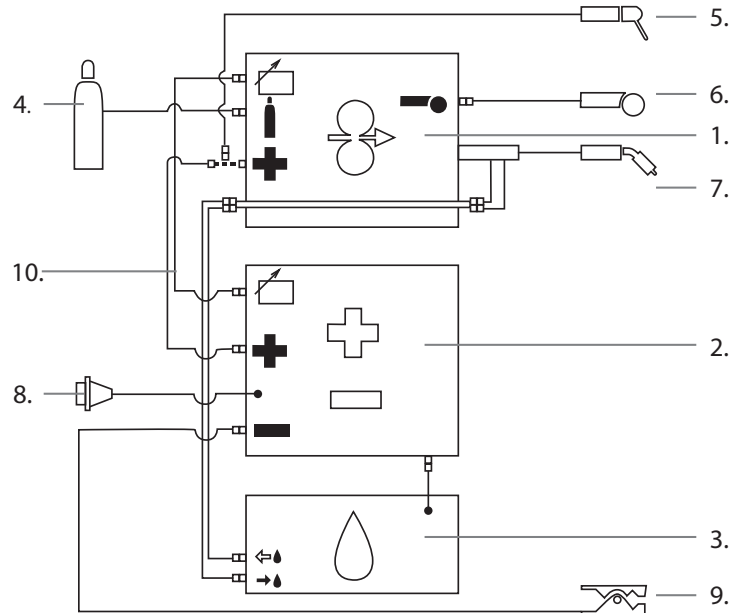
R10		1. Control of MMA/TIG welding current, reference scale 1 ... 5.
R20		1. Wire feed adjustment, electrode current adjustment. 2. Voltage adjustment.

MIG-MAG remote control device with controls for wire feed and voltage, memory scales 1 ... 5. You can use control device also for control of MMA current.

1.3.2 Cables

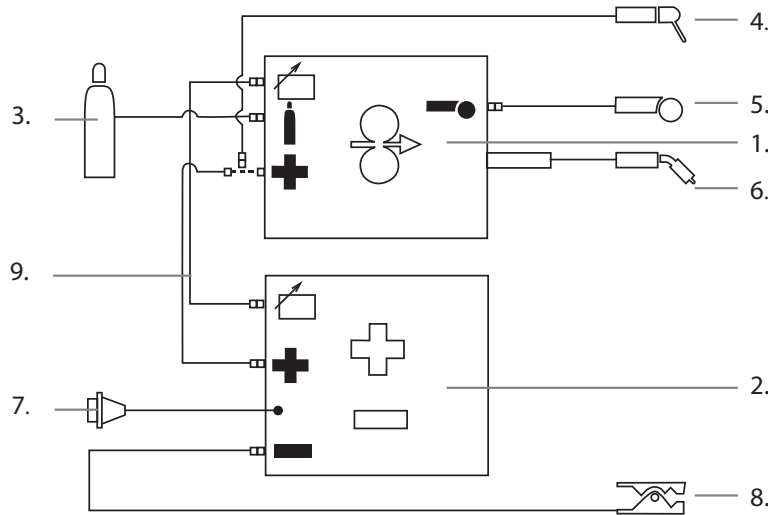
NOTE! Always check before use that the mains cable, earth return cable and its clamp, interconnection cable and shielding gas hose are in a serviceable condition. Ensure that connectors are correctly fastened. Loose connectors can impair welding performance and damage connectors.

Liquid-cooled system: FastMig power source + MXF + FastCool 10



1. MXF wire feed unit
2. FastMig power source
3. FastCool water cooler and power connection
4. Gas supply
5. MMA electrode holder
6. Remote control device
7. Liquid cooled welding Gun
8. Power cable
9. Earth return cable and clamp
10. Control cable

Air-cooled system: FastMig power source + MXF



1. MXF wire feed unit
2. FastMig power source
3. Gas supply
4. MMA electrode holder
5. Remote control device
6. Air cooled welding Gun
7. Power cable
8. Earth return cable and clamp
9. Control cable

2. INSTALLATION

2.1 Positioning of the machine

Place the machine on a firm, dry and level surface. Where possible, do not allow dust or other impurities to enter the machines cooling air flow. Preferably site the machine above floor level; for example on a suitable carriage unit.

Notes for positioning the machine

- The surface inclination should not exceed 15 degrees.
- Ensure the free circulation of the cooling air. There must be at least 20 cm of free space in front of and behind the machine for cooling air to circulate.
- Protect the machine against heavy rain and direct sunshine.

NOTE! The machine should not be operated in the rain as the protection class of the machine, IP23S, allows for outside preserving and storage only.

NOTE! Never aim metallic grinding spray/sparks towards the equipment.

2.2 Distribution network

All regular electrical devices without special circuits generate harmonic currents into distribution network. High rates of harmonic current may cause losses and disturbance to some equipment.

This equipment complies with IEC 61000-3-12 provided that the short-circuit power S_{sc} is greater than or equal to 5.6 MVA at the interface point between the user's supply and the public supply network. It is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the equipment is connected only to a supply with a short-circuit power S_{sc} greater than or equal to 5.6 MVA.

NOTE! The above applies only when connected to the mains supply of 380...440 V 3~.

2.3 Connection to the mains supply

FastMig power sources are delivered equipped with 5 m mains cable without plug.

If local electricity regulations of operating country are stating otherwise, the mains cable should be replaced in conformity with the local regulations.

Connection of the mains cable, mounting and change of the plug should only be carried out by a competent electrician.

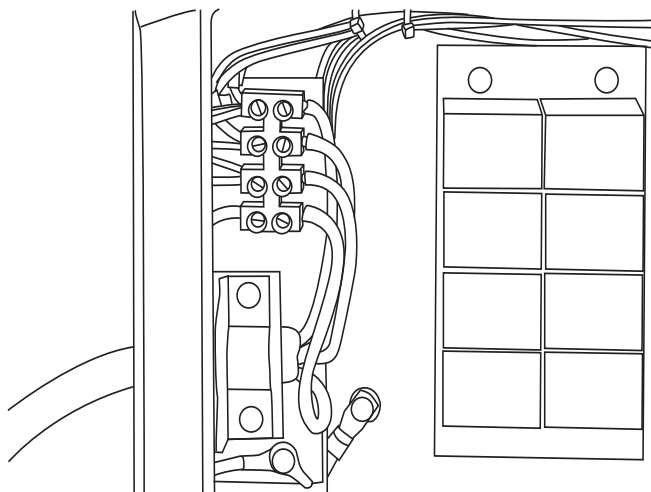
Remove the machine's right side plate to enable the mounting of a mains cable.

M 420MV power source can be connected to the mains supply of 220...230 V 3~ or 380...440 V 3~.

If changing the mains cable take into consideration the following:

The cable is entered into the machine through the inlet ring on the rear panel of the machine and fastened with a cable clamp (05). The phase conductors of the cable are coupled to connectors L1, L2 and L3. The earth protection coloured green-yellow is coupled to connector.

NOTE! If you are using 5-lead cable, do not connect neutral conductor.



Sizes of the mains cables and fuse ratings for the machine at 100 % duty cycle are specified in the table below:

Rated voltage	Fuses, slow-blow	Connection cable *) mm ²
380...440 V 3~	35 A	H07RN-F 4G10 (10 mm ²)
220...230 V 3~	50 A	H07RN-F 4G10 (10 mm ²)

*) In cables of S type there is a protective grounding conductor coloured green-yellow.

2.4 Welding and earth return cables

Recommended copper cables with cross-sectional area are as follows:

FastMig M 420MV 70 ... 95 mm²

In enclosed table are shown typical load capacities of rubber insulated copper cables, when ambient temperature is 25° C and lead temperature is 85° C.

Cable	Duty cycle ED			Voltage loss / 10 m
	100 %	60 %	30 %	
50 mm ²	285 A	370 A	520 A	0,35 V / 100 A
70 mm ²	355 A	460 A	650 A	0,25 V / 100 A
95 mm ²	430 A	560 A	790 A	0,18 V / 100 A

Do not overload welding cables due to voltage losses and heating.

NOTE! Always check the serviceability of the earth return cable and clamp. Ensure the metal surface to which the cable is connected is clean from metal oxide or paint. Check the connector to the power source is fastened correctly.

3. OPERATION CONTROLS

3.1 Main switch I/O

When you turn the switch into I-position, pilot lamp H11 on the front face is illuminated and the machine is ready for use.

NOTE! Always turn the machine on and off with the mains switch, never use the mains plugs as a switch.

3.2 Pilot lamps

The pilot lamps of the machine report the electric operation:

The green pilot lamp H11 when lit indicates that the machine is on and ready for use and it is connected to the mains supply with the main switch in the I-position.

H12 indicates when lit that the thermal protection of the machine has been activated due to over heating. The cooling fan will continue to run and cool the machine down and when the lamp is off the machine is ready to weld.

3.3 Operation of cooling fan

In FastMig power sources there are two simultaneously operating fans.

- The fan is started for a moment when main switch is placed into position I.
- The fan will start during welding as the machine heats up and it will run for 1 to 10 minutes after the welding has stopped.

4. MANUAL METAL ARC WELDING

The FastMig power source can be used in electrode welding by connecting a FastMig MXF 63, MXF 65 or MXF 67 wire feeder to it. The power source can be made suitable for electrode welding without a wire feeder by connecting an R10 or R20 remote control to the X14 or X15 terminal at the back of the power source for welding current adjustment, and the welding power cable connected to the power source's (+) connector X11 or X12.

5. MAINTENANCE

When considering and planning routine maintenance, please consider the frequency of machine use and the working environment.

Correct operation of the machine and regular maintenance will help you avoid unnecessary downtime and equipment failure.

NOTE! *Disconnect the machine from the mains before handling the electrical cables.*

5.1 Daily maintenance

- Check the overall condition of the welding gun. Remove welding spatter from the contact tip and clean the gas nozzle. Replace worn or damaged parts. Only use original Kemppi spare parts.
- Check the condition and connection of the welding circuit components: welding gun, earth return cable and clamp, sockets and connectors.
- Check the condition of the feed rolls, needle bearings and shafts. Clean and lubricate bearings and shafts with a small quantity of light machine oil if necessary. Assemble, adjust and test function.
- Check that the feed rolls are suitable for the filler wire you are using, and that their pressure adjustment is correct.

5.2 Periodic maintenance

NOTE! *Periodic maintenance should only be carried out by a suitably qualified person. Disconnect the plug of the machine from the mains socket and wait about 2 minutes (capacitor charge) before removing the cover plate.*

Check at least every half year:

- Electric connectors of the machine – clean any oxidized parts and tighten loose connections.

NOTE! *You must know the correct tension torques values before starting the reparation of the loose joints.*

Clean the inner parts of the machine from dust and dirt e.g. with a soft brush and vacuum cleaner. Also clean the ventilation net behind the front grill.

Do not use compressed air, there is a risk that the dirt will compact even more tightly into gaps of cooling profiles.

Do not use pressure washing devices.

Only an authorized trained electrician should carry out repairs to Kemppi machines.

5.3 Service Workshop maintenance

Kemppi Service Workshops complete maintenance according to their Kemppi service agreement.

The major points in the maintenance procedure are listed as follows:

- Cleaning of the machine
- Checking and maintenance of the welding tools
- Checking of connectors, switches and potentiometers
- Checking of electric connections
- Checking of mains cable and plug
- Damaged parts or parts in bad condition are replaced by new ones
- Maintenance testing.
- Operation and performance values of the machine are checked, and when necessary adjusted by means of software and test equipment.

Software loading

- Kemppi Service Workshops can also test and load firmware and welding software.

6. OPERATION DISTURBANCES

Should you experience a malfunction from your machine, please consult the basic troubleshooting text above first, and complete some basic checks.

If the machine malfunction cannot be corrected with these measures, contact your Kemppei maintenance service workshop.

Operation of the overload protection

Yellow thermal protection lamp is lit when the thermostat is operating due to loading beyond the stated duty cycle.

The thermostat will operate, if machine is continuously loaded over rated values or cooling air circulation is blocked.

Internal fans will cool the machine, and when the pilot lamp is not lit the machine is automatically ready for welding.

Control fuses

Fuse, 6.3 A delayed, on the rear wall of machine provides protection for auxiliary devices.

Use the same type and rating of fuse as marked beside the fuse adapter. Damage caused by incorrect fuse selection is not covered by the guarantee.

Under and over voltages in the mains supply

Primary circuits of the machine are protected against sudden, transient overvoltages. The machine is designed to withstand 3 x 440 V voltage continuously. Ensure that voltage is kept within this permissible limit, especially when the mains supply is provided by a combustion engine generator. If the mains has under voltage or overvoltage, machine control stops operation automatically.

Loss of a phase in the mains supply

Loss of a mains power phase causes noticeably poor welding properties. In some cases the machine won't start at all. Loss of a phase can be due to following:

- Blowing of mains supply fuse
- Defective mains cable
- Bad connection of mains power cable on machine terminal block or plug of machine.

7. DISPOSAL OF THE MACHINE



Do not dispose of electrical equipment with normal waste!

In observance of European Directive 2002/96/EC on waste electrical and electronic equipment, and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and taken to an appropriate environmentally responsible recycling facility.

The owner of the equipment is obliged to deliver a decommissioned unit to a regional collection centre, per the instructions of local authorities or a Kemppei representative. By applying this European Directive you will improve the environment and human health.

8. ORDERING NUMBERS

FastMig M 420MV		6132423
Wire feeders		
MXF 65 EL	To be used with MS panels	6152100EL
MXF 67 EL	To be used with MS panels	6152200EL
MXF 63 EL	To be used with MS panels	6152300EL
MXF 65	To be used with MR panels	6152100
MXF 67	To be used with MR panels	6152200
MXF 63	To be used with MR panels	6152300
Panels for wire feeders		
FastMig MR 200		6136100
FastMig MR 300		6136200
FastMig MS 200		6136300
FastMig MS 300		6136400
Accessories		
Return current cable	5 m, 50 mm ²	6184511
Return current cable	5 m, 70 mm ²	6184711
Cable for MMA welding	5 m, 50 mm ²	6184501
Cable for MMA welding	5 m, 70 mm ²	6184701
R10		6185409
AS KIT		6264263
Remote controlled interconnecting cable	10 m	6185481
Cooling unit FastCool 10		6068100
Transport unit PM 500		6185291
Gun holder GH 30		6256030

9. TECHNICAL DATA

FastMig™ M 420MV			
		230 V range	400 V range
Connection voltage	3~, 50/60 Hz	220 V -10 %...230 V +10 %	380 V -10 %...440 V +10 %
Rated power	60% ED	21 kVA	22 kVA
	100% ED	18 kVA	19 kVA
Connection cable	H07RN-F	4G6 (5 m)	4G6 (5 m)
Fuse (delayed)		50 A	35 A
Output 40 °C	60 % ED	420 A	420 A
	100 % ED	380 A	380 A
Welding current and voltage range	MMA	15 A/20 V...420 A/48 V	15 A/20 V...420 A/44 V
	MIG	20 A/12 V...420 A/48 V	20 A/12 V...420 A/44 V
Max. welding voltage		48 V	44 V
Open circuit voltage	MMA	U ₀ = 48...53 V U _{av} = 50 V	U ₀ = 48...53 V U _{av} = 50 V
	MIG/MAG	U ₀ = 60...65 V	U ₀ = 53...58 V
Idle power		25 W	25 W
Efficiency at max. current		87 %	87 %
Power factor at max. current		0.85	0.82
Operating temperature range		-20...+40 °C	-20...+40 °C
Storage temperature range		-40...+60 °C	-40...+60 °C
Degree of protection		IP23S	IP23S
EMC class		A	A
Minimum short circuit power S _{sc} of supply network*		N/A	5.6 MVA
External dimensions	L x W x H	590 x 230 x 580 mm	590 x 230 x 580 mm
Weight		49 kg	49 kg
Voltage supply for auxiliary devices		50 V DC	50 V DC
X14, X15		fuse 6.3 A delayed	fuse 6.3 A delayed
Operating voltage (for cooling unit)		380 V -10 %...440 V +10 %	380 V -10 %...440 V +10 %

* See paragraph 2.2.

KEMPPI OY

Kempinkatu 1
PL 13
FIN-15801 LAHTI
FINLAND
Tel +358 3 899 11
Telefax +358 3 899 428
export@kempfi.com
www.kempfi.com

Kotimaan myynti:

Tel +358 3 899 11
Telefax +358 3 734 8398
myynti.fi@kempfi.com

KEMPPI SVERIGE AB

Box 717
S-194 27 UPPLANDS VÄSBY
SVERIGE
Tel +46 8 590 783 00
Telefax +46 8 590 823 94
sales.se@kempfi.com

KEMPPI NORGE A/S

Postboks 2151, Postterminalen
N-3103 TØNSBERG
NORGE
Tel +47 33 346000
Telefax +47 33 346010
sales.no@kempfi.com

KEMPPI DANMARK A/S

Literbuen 11
DK-2740 SKOVLENDE
DANMARK
Tel +45 4494 1677
Telefax +45 4494 1536
sales.dk@kempfi.com

KEMPPI BENELUX B.V.

NL-4801 EA BREDA
NEDERLAND
Tel +31 765717750
Telefax +31 765716345
sales.nl@kempfi.com

KEMPPI (UK) LTD

Martti Kempfi Building
Fraser Road
Priory Business Park
BEDFORD, MK44 3WH
UNITED KINGDOM
Tel +44 (0)845 6444201

Telefax +44 (0)845 6444202
sales.uk@kempfi.com

KEMPPI FRANCE S.A.S.

65 Avenue de la Couronne des Prés
78681 EPONE CEDEX
FRANCE
Tel +33 1 30 90 04 40
Telefax +33 1 30 90 04 45
sales.fr@kempfi.com

KEMPPI GMBH

Perchstetten 10
D-35428 LANGGÖNS
DEUTSCHLAND
Tel +49 6 403 7792 0
Telefax +49 6 403 779 79 74
sales.de@kempfi.com

KEMPPI SPÓŁKA Z O.O.

Ul. Borzymowska 32
03-565 WARSZAWA
POLAND
Tel +48 22 7816162
Telefax +48 22 7816505
info.pl@kempfi.com

KEMPPI AUSTRALIA PTY LTD

13 Cullen Place
P.O. Box 5256, Greystanes NSW 2145
SMITHFIELD NSW 2164
AUSTRALIA
Tel. +61 2 9605 9500
Telefax +61 2 9605 5999
info.au@kempfi.com

ООО КЕМПИ

Polkovaya str. 1, Building 6
127018 MOSCOW
RUSSIA
Tel +7 495 240 84 03
Telefax +7 495 240 84 07
info.ru@kempfi.com

ООО КЕМПИ

ул. Полковая 1, строение 6
127018 Москва
Tel +7 495 240 84 03
Telefax +7 495 240 84 07
info.ru@kempfi.com

KEMPPI, TRADING (BEIJING) COMPANY LTD

Unit 105, 1/F, Building #1,
No. 26 Xihuan South Rd.,
Beijing Economic-Technological Development
Area (BDA),
100176 BEIJING
CHINA
Tel +86-10-6787 6064
+86-10-6787 1282
Telefax +86-10-6787 5259
sales.cn@kempfi.com

肯倍贸易 (北京) 有限公司

中国北京经济技术开发区
西环南路26号
1号楼1层105室(100176)
电话 : +86-10-6787 6064/1282
传真 : +86-10-6787 5259
sales.cn@kempfi.com

KEMPPI INDIA PVT LTD

LAKSHMI TOWERS
New No. 2/770,
First Main Road,
Kazura Garden,
Neelankarai,
CHENNAI - 600 041
TAMIL NADU
Tel +91-44-4567 1200
Telefax +91-44-4567 1234
sales.india@kempfi.com

KEMPPI WELDING SOLUTIONS SDN BHD

No 12A, Jalan TP5A,
Taman Perindustrian UEP,
47600 Subang Jaya,
SELANGOR, MALAYSIA
Tel +60 3 80207035
Telefax +60 3 80207835
sales.malaysia@kempfi.com