

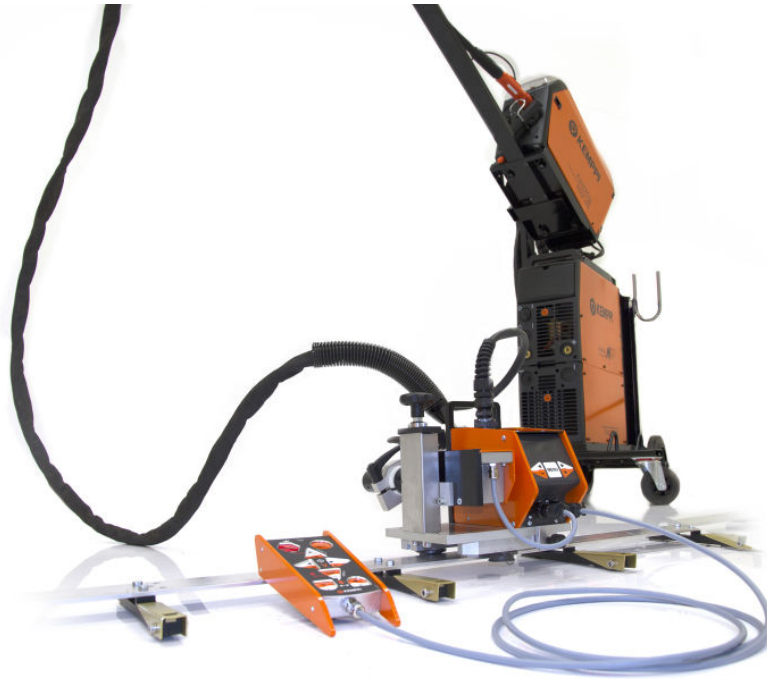
# A5 MIG Rail System 2500

MECHANIZED MIG WELDING MADE EXTREMELY EFFICIENT  
AND EASY





## A5 MIG Rail System 2500



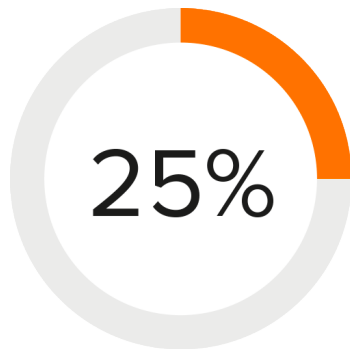
### MECHANIZED MIG WELDING MADE EXTREMELY EFFICIENT AND EASY

A5 MIG Rail System 2500 is the most cost efficient way to improve productivity in mechanized MIG/MAG welding. The system has an inbuilt weaving and rail fastening mechanism with magnets or with vacuum suction cups. With the system you can achieve significant savings for all applications where the weld lengths exceed 2 m or in case of multi-layer welds.

In mechanized welding, the welding carriage carries the gun (instead of being held in the operator's hand), making the arc movement accurate and steady. The setup includes the FastMig M 420, a top of the line welder with unique WISE welding application software. The smart WISE processes provide significant improvements in welding production efficiency.

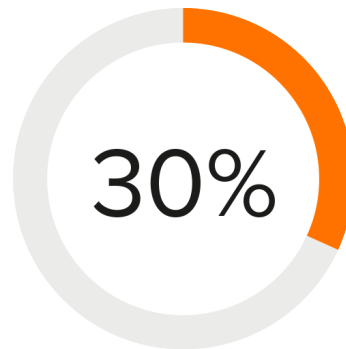


## KEY BENEFITS



### SAVINGS IN TIME

Additional increases in welding speed with the Kempki WiseFusion process.



### FILLER SAVINGS

With combined use of WiseFusion and WisePenetration processes

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## BENEFITS

- Fewer human errors affecting the arc movement
- Increased welding productivity
- Light and durable Remote Control Unit makes operation simple and fast
- Easy to use and quick to set up. Save time, costs, and repair work with the easy-to-use user interface and integrated power supply.
- Fast setup time with light, strong, and flexible 2.5 m aluminum rails that can be bent to any curved surfaces, including pipes.
- Magnetic fixing of rails significantly saves set up and reinstallation time Vacuum suction cups available for non-magnetic materials.
- Multiple weaving patterns possible with integrated Weaving Unit
- Can be used in any welding position.
- Flexible adjustment of the tilt and push/pull angle enabled by the welding gun holder
- Significant savings with Kempki Reduced Gap Technology (RGT), more information [www.kemppi.com](http://www.kemppi.com)



## PRODUCT OPTIONS



### FastMig M 420 Power source

The FastMig M 420 is a top performance multi-purpose power source, suitable for many applications. This unit is made for those who are looking to optimize welding productivity and quality.



### MXF 65 EL Wire feeder

EL wire feeder versions are suitable for synergic MS control panels. Flexibility and performance for all welding applications in today's medium and heavy industries. This unit is compatible with 300 mm spool and is covered in an aluminum casing.



### WiseFusion

A welding function that ensures consistent weld quality in all positions by automatically regulating arc length. Creates and maintains an optimal short-circuit characteristic in pulsed MIG/MAG and spray-arc welding.

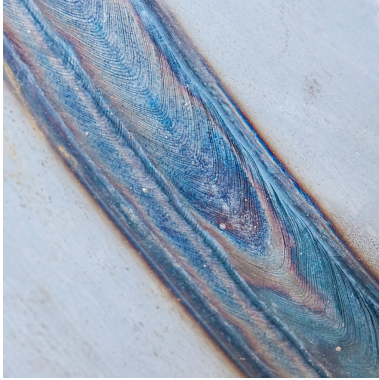


### WisePenetration

A welding function for ensured penetration in synergic MIG/MAG welding. Delivers constant power to the weld pool regardless of changes in welding gun orientation or distance between the welding gun and work piece.



## FEATURES



### Weld 25% more per year

WiseFusion makes it possible to weld at a significantly higher speed, providing the same quality level and throat thickness as with a conventional spray and pulse arc. Synergic fusion is 20% faster than 1-MIG and pulsed fusion, and even 38% faster than conventional pulse welding.



### 30% savings on labor and filler costs by using WiseFusion and WisePenetration simultaneously

When combined, the WiseFusion and WisePenetration processes can save up to 30 % in filler material and welding time because a narrower groove angle can be used for butt joints up to 25 mm plate thickness from one side.





## ACCESSORIES



### MMT MN 32C

MMT MN 32C is a 5 m gas-cooled multi-neck, 320A welding gun for mechanized welding.



### MT51MWC

MT51MWC is a 500A water cooled welding gun for mechanized welding. Two length options 4,5 m (6255162) or 6,0 m (6255163).



### FastCool 10

The FastCool 10 is a cooling unit designed for FastMig M welding equipment and is used for cooling the welding gun.



### Rail 2500

Flexible high quality aluminum rails with extra strong magnets. Flexible 2.5 m long rails can be used on different kind of surfaces from flat, curved to round up from 1500 OD onwards.



### A5 MIG Rail quick extension bracket



### A5 MIG Rail magnet attachment 8 PCS



### A5 MIG Remote Control Unit

Light and durable remote controller for welding parameter control and immediate change of program. Seamlessly integrated with Kempfi power sources. Starting, stopping, and changing the welding parameters is very quick and simple. Easy to learn and use.



### FastMig MS 300 control panel

MS control panel, which includes easy-to-use synergic functionality and a rich selection of additional features for optimizing your welding work. These packages are suitable for professional use in more demanding industrial applications. This panel is for MXF 65 EL and MXF 67 EL wire feeders.



### A5 weaving tilt bracket



A5 weaving turn bracket



A5 torch floating head



A5 carriage carrying and storage box

Wooden storage box for A5 MIG Carriages.



A5 Rail vacuum attachment 4 PCS



A5 MIG carriage transformer



A5 MIG carriage control cable



A5 Stiffener bar for flex rail



## TECHNICAL SPECIFICATIONS

### POWER SOURCES

#### FastMig M 420 Power source

|  |  |
|--|--|
| Product code                                   | 6132420  |
| Connection voltage 3~ 50/60 Hz                 | 400 V -15...+20%                                   |
| Fuse (delayed)                                 | 35A  |
| Minimum generator power                        | 20kVA (60%)<br>18kVA (100%)                        |
| Welding range                                  | U <sub>0</sub> = 50 - 58 V                         |
| Output 60% ED                                  | 420 A  |
| Output 100% ED                                 | 380 A  |
| Rated power 60% ED                             | 20 KVA   |
| Rated power 100% ED                            | 18 kVA   |
| Max. welding voltage                           | 45 V   |
| Open circuit voltage MMA                       | U <sub>0</sub> = 48 – 53 V, U <sub>av</sub> = 50 V |
| Open circuit voltage MIG/MAG                   | U <sub>0</sub> = 80–98V                            |
| Welding current and voltage range, Stick (MMA) | 15 A/20 V – 420 A/44 V                             |
| Idle power                                     | 25 W   |
| Efficiency at max. current                     | 89 %   |
| Power factor at max. current                   | 0.87   |
| Welding current and voltage range, MIG         | 20 A/12 V – 420 A/44 V                             |
| Operating temperature range                    | -20 ... +40 °C                                     |
| External dimensions LxWxH                      | 590 × 230 × 430 mm                                 |
| Weight (no accessories)                        | 35 kg  |
| Degree of protection                           | IP23S  |
| Standards                                      | IEC 60974-1, IEC 60974-5, IEC 60974-10             |
| Storage temperature range                      | -40 ... +60 °C                                     |





## WIRE FEEDERS

### MXF 65 EL Wire feeder

|                           |                    |
|---------------------------|--------------------|
| Product code              | 6152100EL          |
| Output 60% ED             | 520 A              |
| Output 100% ED            | 440 A              |
| Wire feed mechanism       | 4-roll             |
| Filler wires, Ss          | 0.6 – 1.6 mm       |
| Filler wires, Al          | 1.0 – 2.4 mm       |
| Filler wires, Fe          | 0.6 – 1.6 mm       |
| Wire feed speed           | 0 – 25 m/min       |
| Diameter of feed rolls    | 32 mm              |
| Filler wires, Cored wire  | 0.8 – 2.0 mm       |
| Wire spool weight, max.   | 20 kg              |
| Wire spool diameter, max. | 300 mm             |
| External dimensions       | 620 × 210 × 445 mm |
| Weight                    | 11.1 kg            |

## SOFTWARE

### WiseFusion

|              |   |
|--------------|---|
| Product code | 9991014 (FastMig M, FastMigX)<br>X8500000 (X8 MIG Welder)<br>A7500000 (A7 MIG Welder) |
|--------------|---|

### WisePenetration

|              |   |
|--------------|---|
| Product code | 9991000 (FastMig M, FastMigX)<br>A7500001 (A7 MIG Welder) |
|--------------|---|

## ACCESSORIES

### MMT MN 32C

|              |         |
|--------------|---------|
| Product code | 6250405 |
|--------------|---------|

### MT51MWC

|              |                                    |
|--------------|------------------------------------|
| Product code | 4,5 m - 6255162<br>6,0 m - 6255163 |
|--------------|------------------------------------|



## FastCool 10

|                             |                         |
|-----------------------------|-------------------------|
| Product code                | 6068100                 |
| Cooling liquid              | 20% – 40 % etanol/water |
| Operating voltage           | 400V -15%...+20%        |
| Connection capacity         | 250 W (100 %)           |
| Start pressure, max         | 0.4 MPa                 |
| Operating temperature range | -20 ... +40 °C          |
| Degree of protection        | IP23S                   |
| Tank volume                 | ca. 3 l                 |
| External dimensions         | 570 x 230 x 280 mm      |
| EMC class                   | A                       |
| Cooling power               | 1 kW                    |
| Storage temperature range   | -40 ... +60 °C          |
| Weight                      | 11 kg                   |

## Rail 2500

|              |         |
|--------------|---------|
| Product code | 6190710 |
|--------------|---------|

## A5 MIG Rail quick extension bracket

|              |         |
|--------------|---------|
| Product code | 6190702 |
|--------------|---------|

## A5 MIG Rail magnet attachment 8 PCS

|              |         |
|--------------|---------|
| Product code | 6190703 |
|--------------|---------|

## FastMig MS 300 control panel

|              |         |
|--------------|---------|
| Product code | 6136400 |
|--------------|---------|

## A5 weaving tilt bracket

|              |         |
|--------------|---------|
| Product code | 6190708 |
|--------------|---------|

## A5 weaving turn bracket

|              |         |
|--------------|---------|
| Product code | 6190709 |
|--------------|---------|

## A5 torch floating head

|              |         |
|--------------|---------|
| Product code | 6190711 |
|--------------|---------|

## A5 carriage carrying and storage box

|                           |                    |
|---------------------------|--------------------|
| Product code              | 6190717            |
| External dimensions LxWxH | 555 x 285 x 300 mm |



### A5 Rail vacuum attachment 4 PCS

|              |   |
|--------------|---|
| Product code | 6190719 - Standard (-40 - 110°C)<br>6190704 - Hi temp (-70 - 200°C) |
|--------------|---|

### A5 MIG carriage transformer

|              |         |
|--------------|---------|
| Product code | 6190714 |
|--------------|---------|

### A5 MIG carriage control cable

|              |         |
|--------------|---------|
| Product code | 6190716 |
|--------------|---------|

### A5 Stiffener bar for flex rail

|              |         |
|--------------|---------|
| Product code | 6190741 |
|--------------|---------|

[WWW.KEMPPI.COM](http://WWW.KEMPPI.COM)

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**Kemppi** is the pioneering company within the welding industry. It is our role to develop solutions that make you win business. Headquartered in Lahti, Finland, Kemppi employs over 800 welding experts in 17 countries and has a revenue of more than 150 MEUR. Our offering includes welding solutions - intelligent equipment, welding management software and expert services - for both demanding industrial applications and ready-to-weld needs. Local expertise is available via our global partner network covering over 60 countries.

