

# ECO DESIGN INFORMATION

## TECHNICAL DATA

A	
B	
P/N:	C S/N: D

- A** Manufacturer name and address
- B** Product name
- C** Product part number
- D** Serial number:
  - X Production plant
  - YY Year of production
  - xxxxxx Progressive number specific for each machine

## EFFICIENCY AND CONSUMPTION

The equipment has been designed in order to comply with the Directive 2009/125/EC and the Regulation 2019/1784/EU.

Efficiency and idle power consumption:

<b>PART NUMBER</b>	99400054
<b>PRODUCT NAME</b>	MONOMIG 186
<b>EFFICIENCY WHEN MAX POWER CONSUMPTION</b>	56,31%
<b>IDLE POWER CONSUMPTION</b>	27W
<b>EQUIVALENT MODEL</b>	No equivalent model

The value of efficiency and consumption in idle state have been measured by method and conditions defined in the product standard EN 60974-1:20XX.

## TYPICAL GAS USAGE FOR MIG/MAG EQUIPMENT

Material type	Wire Diameter mm	DC electrode positive Current (A)	DC electrode positive Voltage (V)	Wire Feeding [m/min]	Shielding Gas	Gas flow [l/min]
Carbon, low alloy steel	0,8 ÷ 1,2	40 ÷ 280	15 ÷ 30	1,0 ÷ 25	Argon 80% CO <sub>2</sub> 20%	10 ÷ 18
Aluminium	0,8 ÷ 1,6	15 ÷ 300	14 ÷ 29	2,0 ÷ 25	Argon	14 ÷ 22
Stainless steel	0,8 ÷ 1,2	30 ÷ 260	15 ÷ 28	1,8 ÷ 12	Argon 98% CO <sub>2</sub> 2%	8 ÷ 16
Copper alloy (Bronze)	0,8 ÷ 1,2	40 ÷ 250	14 ÷ 30	2,5 ÷ 11	Argon	12 ÷ 16

## TIG PROCESS

In TIG welding process, gas usage depends on cross-sectional area of the nozzle. For commonly used torches:

Helium = 14-24 l/min

Argon = 7-16 l/min

**Notice:** Excessive flow rates causes turbulence in the gas stream which may aspirate atmospheric contamination into the welding pool.

**Notice:** A cross wind or draft moving can disrupt the shielding gas coverage, in the interest of saving of protective gas use screen to block air flow.

## END OF LIFE



At end of life of product, it has to be disposal for recycling in accordance with Directive 2012/19/EU (WEEE).