



PRODUCT CATALOGUE

POWER SOURCES



2022



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DINSE - WE ARE YOUR STRONG PARTNER FOR THE ENTIRE WELDING PROCESS.

LIVE TO WELD.

For us, this is more than just a „fancy slogan“: our 150 employees have been passionate about welding for more than 60 years.

Would you like to know what DINSE passion looks like? There is, for example, our stockist who personally assembles each wear part for your order.

Or the production worker who manually bends your automatic torch to the desired angle. But also the colleague in the purchasing department who daily searches for the highest quality raw materials for our products and the constructing engineer who puts all his experience into developing new systems.

IN SHORT:
FOR YOUR PERFECT
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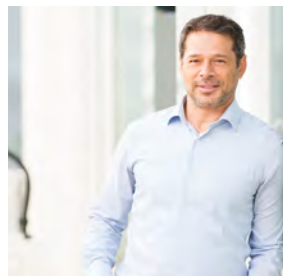


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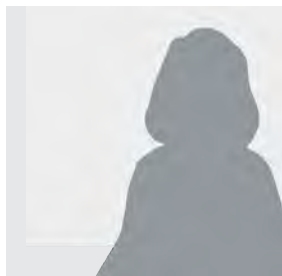
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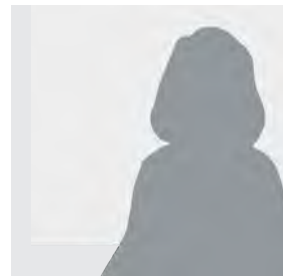
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You can further your knowledge through seminars on various topics based around welding with DINSE.

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Art.-Nr. WF10172

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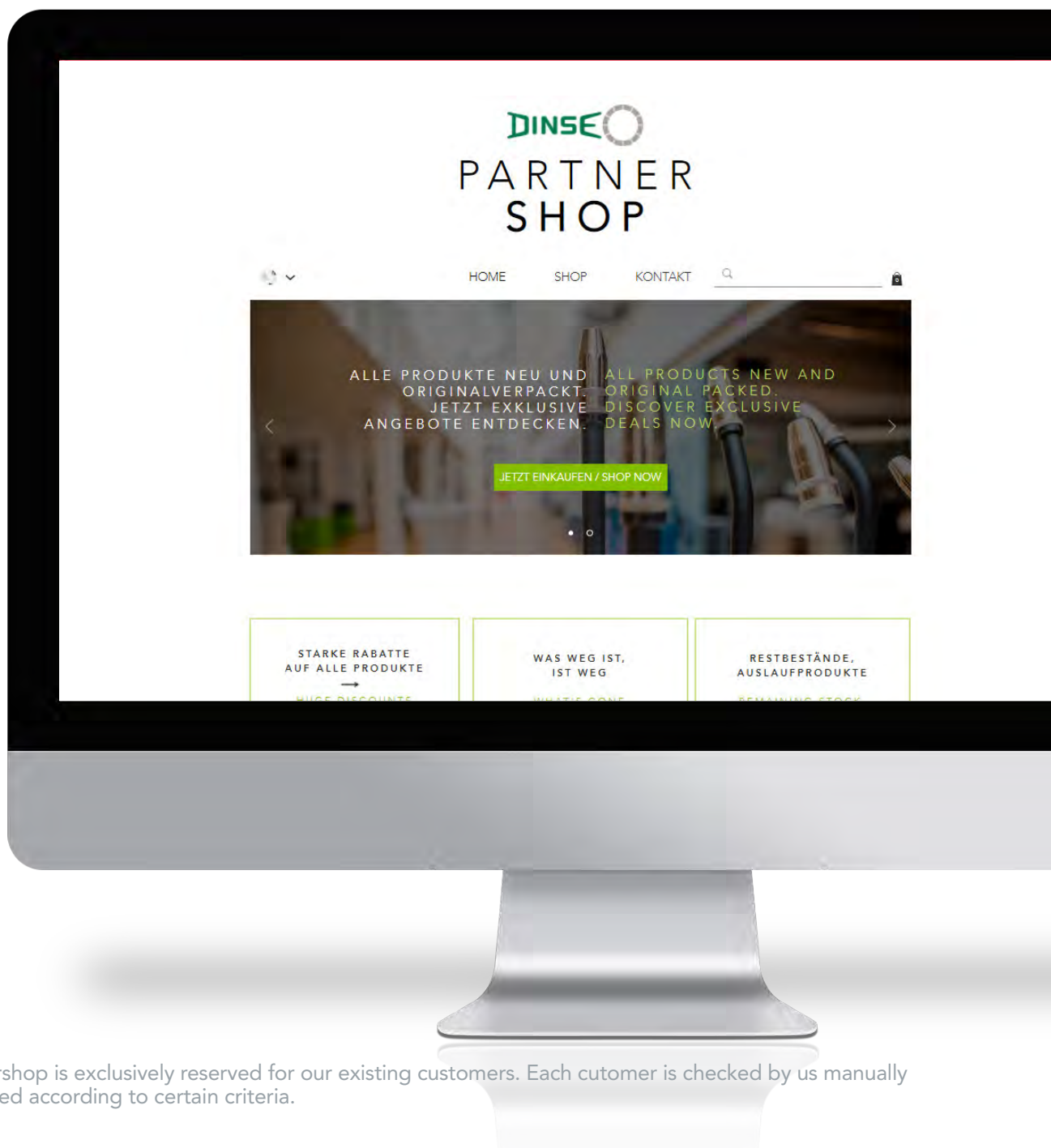
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FLYERS

IN OUR FLYERS YOU CAN FIND ALL DETAILS ABOUT A PRODUCT COMPACTLY SUMMARIZED:



DIX.M
Overview
Art.-Nr.
WF2052



DIX PI GO
1156.M
Art.-Nr.
WF1912



DIX PI GO
1156.M PULS
Art.-Nr.
WF1922



DIX PI GO
2006.M
Art.-Nr.
WF1932



DIX PI GO
2006.M PULS
Art.-Nr.
WF1942



DIX PI
3006.M PULS
4006.M PULS
4606.M PULS
Art.-Nr.
WF1952



DIX PI
3006.M PULS
4006.M PULS
4606.M PULS
BASIC
Art.-Nr.
WF2102



DIX PI
3006.M I
3506.M I
Art.-Nr.
WF1962



DIX PI
3006.M I
3506.M I
BASIC
Art.-Nr.
WF2112



DIX PI
3006.M I PULS
3506.M I PULS
Art.-Nr.
WF1972



DIX PI
3006.M I PULS
3506.M I PULS
BASIC
Art.-Nr.
WF2122



DIX TIG GO
1406.M HF
Art.-Nr.
WF2022



DIX TIG GO
1406.M HF
PRO
Art.-Nr.
WF2032



DIX TIG GO
1806.M AC/DC
Art.-Nr.
WF1982



DIX TIG GO
2506.M AC/DC
Art.-Nr.
WF2002



DIX TIG GO
1906.M HF
Art.-Nr.
WF1992



DIX TIG GO
2506.M HF
Art.-Nr.
WF2012



DIX GO
1206.M
1306.M
1106.M C
1206.M C
Art.-Nr.
WF2042



DINSE

MANUAL TORCH SET SERIES WITH BALL JOINT



MQ(Z).NEO

- ▶ The ball joint and a highly flexible cover hose relieve the welder
- ▶ Separate shield gas hose optimizes gas coverage and prevents gas losses
- ▶ High-quality, compatible wear parts: Work interruption and stock holding reduced to a minimum
- ▶ DINSE quality cooling for long duty cycle and high productivity
- ▶ Ergonomic and robust handle for maximum grip safety

For notes:

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Power sources MIG/MAG, TIG, MMA DIX PI.GO 1156.M and DIX PI.GO 1156.M PULS For manual welding applications



1

Application

- ▶ Power sources with the latest inverter technology
- ▶ Single-phase power source, suitable up to 230V mains voltage
- ▶ Synergetically preset welding characteristics
- ▶ Integrated wire feed
- ▶ MIG/MAG welding, TIG welding with „Lift“ type ignition welding processes
- ▶ Portable compact power source of the PI.GO M series
- ▶ Pulse welding (PULS)
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Special processes with the DIX ARC software for perfect control of the arc
- ▶ Ex works with mounting for 5 kg wire spool
- ▶ 15 kg wire spool (Ø 300mm) can be retrofitted

Options according to range of application



Power source DIX PI.GO 1156.M and DIX PI.GO 1156.M PULS - Application sample

Properties

- ▶ Up to 99 Jobs selectable
- ▶ All parameters for welding procedures, material and function are adjustable
- ▶ Call up and appliance of special welding characteristics via display

Technical data (IEC 60974-1, -5, -10):							
Power sources		DIX PI.GO 1156.M			DIX PI.GO 1156.M PULS		
Welding processes		MIG/MAG	TIG	MMA	MIG/MAG	TIG	MMA
Mains voltage - 1 ph 50/60 Hz		230 V \pm 15%			230 V \pm 15%		
Power input @ I ₂ MAX	kVA	8.1	6.4	7.8	9.7	6.4	7.8
Delayed fuse (I _{eff}) (I _{eff})		16 A			16 A		
Power factor / cosφ		0.63 / 0.99			0.64 / 0.99		
Efficiency degree		0.83	0.8	0.83	0.83	0.8	0.83
Voltage without load		60 V			60 V		
Welding current control range	A	10-175	5-175	10-150	10-200	5-175	10-150
Welding current at 100% duty cycle (40 °C)	A	100	100	90	100	100	90
Welding current at 60% duty cycle (40 °C)	A	115	115	110	115	115	110
Welding current at X% duty cycle (40 °C)	A	175 (20%)	175 (20%)	150 (25%)	200 (15%)	175 (20%)	150 (25%)
Wire diameter		0.6 - 1.2 mm			0.6 - 1.2 mm		
Welding wire spool Diameter / Weight	mm/kg	200 / 5	-	-	200 / 5	-	-
Electrodes - ø	mm	-	1.0-3.2	1.6-3.2	-	1.0-3.2	1.6-3.2
Protection class		IP 23 S			IP 23 S		
Insulation class		H			H		
Safety marking		S - mark			S - mark		
Dimension (L/W/H)		500 / 425 / 220 mm			500 / 425 / 220 mm		
Weight approx.		16 kg			16 kg		

MIG/MAG TIG MMA Manual



Power sources MIG/MAG, TIG, MMA

DIX PI.GO 1156.M and DIX PI.GO 1156.M PULS

For manual welding applications

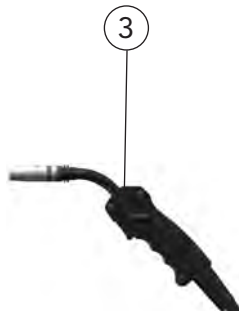
Power sources system components



1

MIG/MAG TIG MMA Manual



Power source DIX PI.GO 1156.M (PULS)
Application sample



Description	Dimension	Part name	Part number
1 Power source		DIX PI.GO 1156.M	7420010010
Power source, not shown		DIX PI.GO 1156.M PULS	7420010011
Accessories			
2 Trolley		DIX T 1	7420050000
3 Torch set for MIG/MAG welding	 3.00 m	DIX MS 230-3 SA	6102123131
Torch set for MIG/MAG welding	 4.00 m	DIX MS 230-4 SA	6102123141
4 Torch set for TIG welding	4.00 m	DIX TM 17V-4	7422000000
Torch set for TIG welding	8.00 m	DIX TM 17V-8	7422000001
5 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
Pressure regulator AR/CO2, not shown	0-30 l/min	DIX DRV-400	7420900007
Pressure regulator, not shown	0-20 l/min	DIX DRV-100	628080100
Ground cable, not shown	4.00 m	DIX GL.M 16-4	7420070000

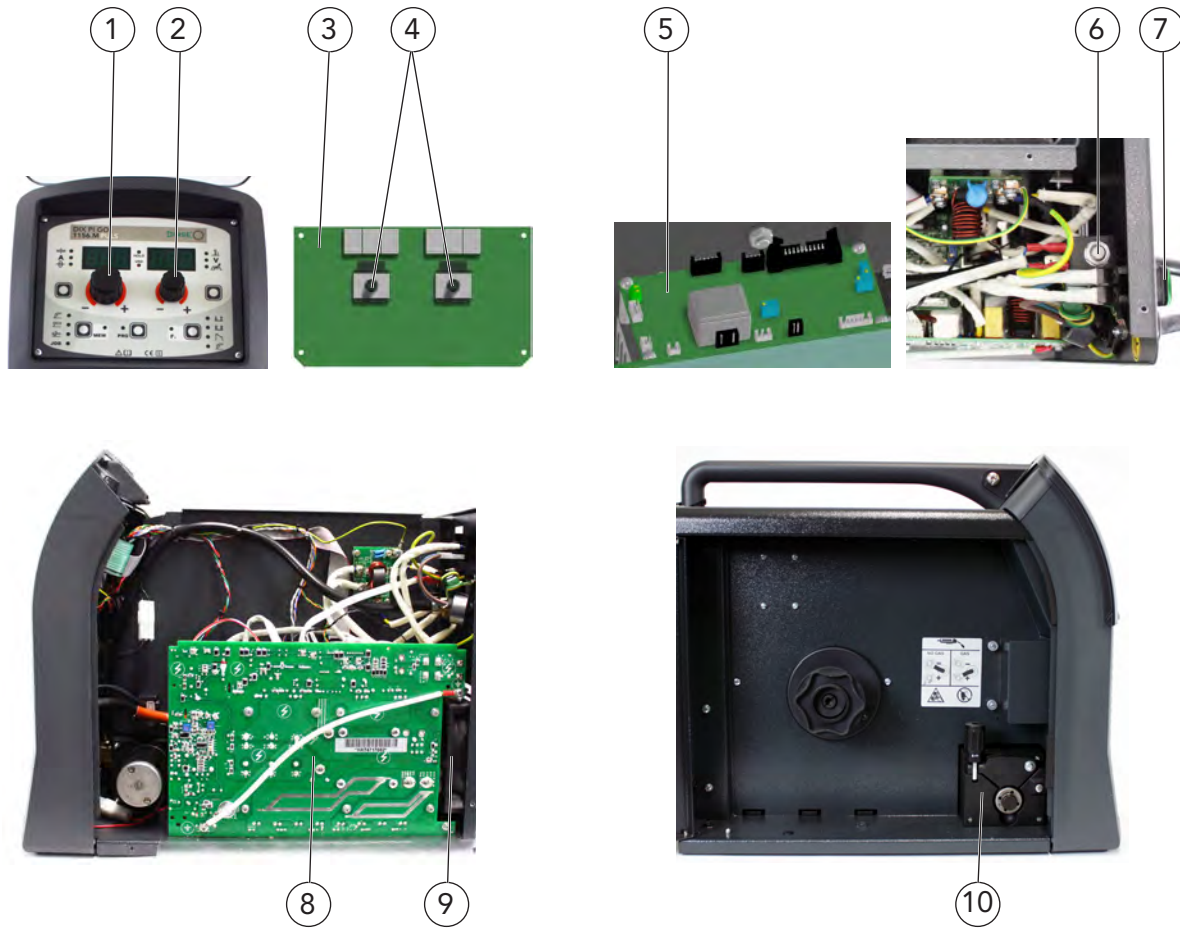


Power sources MIG/MAG, TIG, MMA DIX PI.GO 1156.M and DIX PI.GO 1156.M PULS For manual welding applications



1

Spare parts and wear parts



MIG/MAG TIG MMA Manual

Description	Part number
1 Rotary knob ø 29 mm	7421000081
2 Rotary knob ø 22 mm without index	7421000082
3 Front board For DIX PI.GO 1156.M	7421000050
Front board For DIX PI.GO 1156.M PULS	7421000048
4 Encoder	7421000091
5 Secondary board 1156	7421000039
6 Gas valve	7421000066
7 Main switch	7421000071
8 Power inverter assembly	7421000017
9 Fan	7421000097
10 2 roller drive unit	7421000012
Optional:	
Adapter set, not shown For DIX PI.GO 1156.M PULS	7420060003



Power sources MIG/MAG, TIG, MMA DIX PI.GO 2006.M and DIX PI.GO 2006.M PULS For manual welding applications

Application

- ▶ Power sources with the latest inverter technology
- ▶ Power sources three-phase input, suitable up to 400V mains voltage
- ▶ Synergetically preset welding characteristics
- ▶ Integrated 4 rolls wire feed
- ▶ Tool-free change of the wire feed rolls
- ▶ MIG/MAG welding, TIG welding with „Lift“ type ignition welding processes
- ▶ Portable compact power source of the PI.GO M series
- ▶ Welding using the MIG / MAG pulse proceed and in the MIG / MAG double pulse proceed (PULS) with and without protective gas
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Special processes with the ARC and ARC.COOL software for perfect control of the arc
- ▶ Cooling module optional
- ▶ For 15 kg wire spool (Ø 300mm)

Properties

- ▶ Up to 99 Jobs selectable
- ▶ All parameters for welding procedures, material and function are adjustable



Power sources DIX PI.GO 2006.M (PULS)
Application sample



Options according to range of application

Power sources DIX PI.GO 2006.M PULS, Trolley
DIX T 2 with adapter plate and cooling module
DIX CM 589.M with storage drawer
Application sample

Technical data (IEC 60974-1, -5, -10):

Power sources	DIX PI.GO 2006.M			DIX PI.GO 2006.M PULS			
	MIG/MAG	TIG	MMA	MIG/MAG	TIG	MMA	
Welding processes							
Mains voltage - 3 ph 50/60 Hz	400 V±15%			400 V±15%			
Power input @ I ₂ MAX	kVA	10	8,5	11	10	8,5	11
Delayed fuse (I _{eff}) (I _{eff})		16 A	10 A	16 A	16 A	10 A	16 A
Power factor / cosφ		0.74 / 0.99	0.69 / 0.99	0.77 / 0.99	0.74 / 0.99	0.69 / 0.99	0.77 / 0.99
Efficiency degree		0.89	0.86	0.90	0.89	0.86	0.90
Voltage without load		60 V			60 V		
Welding current control range		10-250 A			10-250 A		
Welding current at 100% duty cycle (40 °C)		180 A			180 A		
Welding current at 60% duty cycle (40 °C)		200 A			200 A		
Welding current at 35% duty cycle (40 °C)		250 A			250 A		
Wire diameter	mm	0.6 - 1.2	-	-	0.6 - 1.2	-	-
Welding wire spool Diameter / Weight	mm/ kg	300 / 15	-	-	300 / 15	-	-
Electrodes - ø	mm	-	1.0 - 3.2	1.6 - 4.0	-	1.0 - 3.2	1.6 - 4.0
Protection class		IP 23 S			IP 23 S		
Insulation class		H			H		
Safety marking		S - mark			S - mark		
Dimension (L/W/H)		650 / 388 / 300 mm			650 / 388 / 300 mm		
Weight approx.		21 kg			21 kg		



Power sources MIG/MAG, TIG, MMA DIX PI.GO 2006.M and DIX PI.GO 2006.M PULS For manual welding applications



1

Power sources system components



Power sources DIX PI.GO 2006.M (PULS)
Application sample

MIG/MAG TIG MMA Manual

Description	Dimension	Part name	Part number
1 Power source		DIX PI.GO 2006.M	7420010012
Power source, not shown		DIX PI.GO 2006.M PULS	7420010013
2 Cooling module		DIX CM 589.M	7420020002
Accessories			
3 Trolley		DIX T 2	7420050001
4 Adapter plate		DIX FW T2_2006.M	7420060001
5 Storage drawer For cooling module DIX CM 589.M			7420060000
6 Torch set for MIG/MAG welding	3.00 m	DIX MS 330-3 SA	6202133131
Torch set for MIG/MAG welding	4.00 m	DIX MS 330-4 SA	6202133141
Torch set for MIG/MAG welding	3.00 m	DIX MSZ 330-3 SAZ	6203133131
Torch set for MIG/MAG welding	4.00 m	DIX MSZ 330-4 SAZ	6203133141
7 Torch set for WIG welding	4.00 m	DIX TM 26V-4	7422000002
Torch set for WIG welding	8.00 m	DIX TM 26V-8	7422000003
8 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
Pressure regulator AR/CO2, not shown	0-30 l/min	DIX DRV-400	7420900007
Pressure regulator, not shown	0-20 l/min	DIX DRV-100	628080100
Spool adapter, not shown		DIX DV-KA	718500100
Ground cable, not shown	5.00 m	DIX GL.M 35-5	7420070002



Power sources MIG/MAG, TIG, MMA DIX PI.GO 2006.M and DIX PI.GO 2006.M PULS For manual welding applications

Spare parts and wear parts

1

MIG/MAG TIG MMA Manual



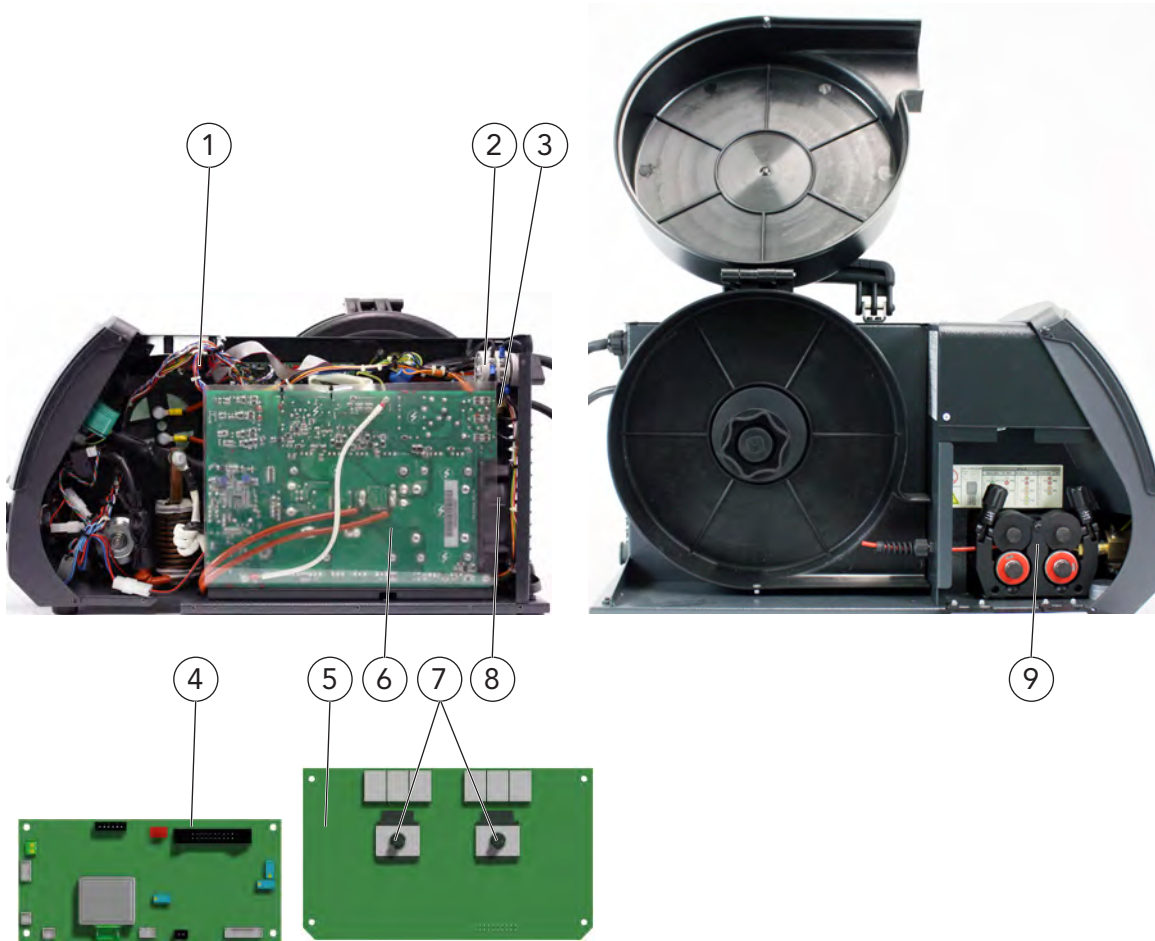
Description	Part number
1 Rotary knob ø 29 mm	742100081
2 Rotary knob ø 22 mm	742100082
3 Switch button	742100078



Power sources MIG/MAG, TIG, MMA DIX PI.GO 2006.M and DIX PI.GO 2006.M PULS For manual welding applications



Spare parts and wear parts



Description	Part number
1 Circuit board	7421000060
2 Main switch 16A	7421000075
3 Gas valve	7421000066
4 Inverter board	7421000059
5 Inverter board For DIX PI.GO 2006.M	7421000052
Inverter board For DIX PI.GO 2006.M PULS	7421000053
6 Power inverter assembly	7421000018
7 Encoder	7421000091
8 Fan	7421000087
9 4 roller drive unit	7421000013

MIG/MAG TIG MMA Manual



Cooling modules for DIX PI.GO Power sources DIX CM 589.M and DIX CM 653.M For manual welding applications

1

Technical data (IEC 60974-2/10):		
Cooling module	DIX CM 589.M	DIX CM 653.M
Cooling type	Air Forced (AF)	
Cooling performance	max.0.95 kW	
Cooling loop pressure	max. 4.3 bar	
Tank volume	approx. 5.0 Liter	
Protection class	IP 23	
Dimensions (L/W/H)	670/235/305 mm	
Weight, approx. (without coolant)	16 kg	
Weight, approx. (with coolant)	21 kg	

Options according to range of application



Cooling module DIX CM 589.M - Application sample

Properties

- ▶ Manual welding applications
- ▶ Control of the cooling module DIX CM 653.M via the welding power source with integrated 4 rolls wire feed
- ▶ Cooling module to be switched on by manual DIX CM 589.M with connection for the cooling water hoses of the torch sets

Application

- ▶ Single-phase electric pump
- ▶ Air Forced (AF) cooling module



Power source with cooling module and trolley Application sample



A



1

Description	Part name	Part number
A Cooling module	DIX CM 589.M	7420020002
Cooling module, not shown	DIX CM 653.M	7420020004
1 Coolant, 10 litres	DIX CM LIQUID 10L	7410082100

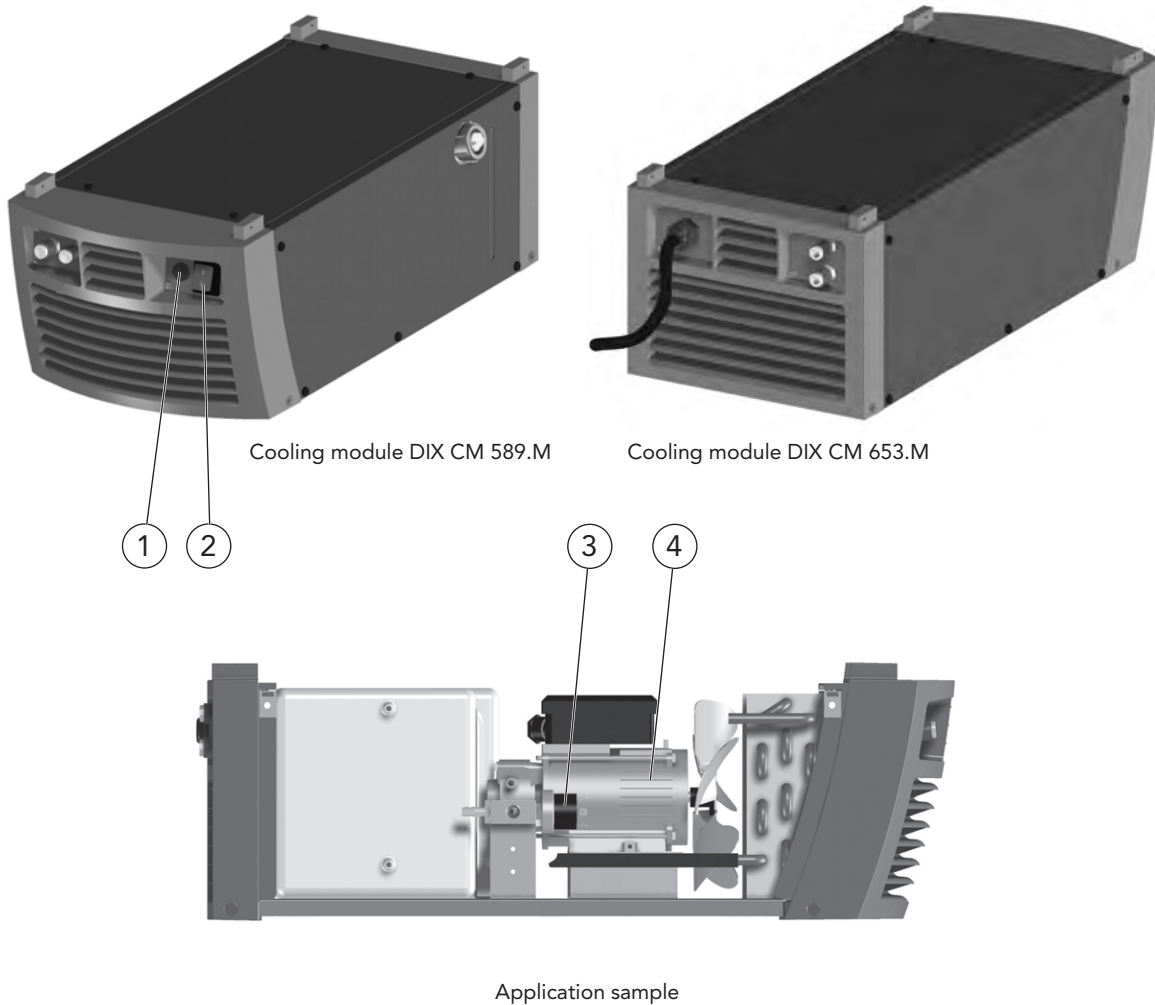
- ▶ Liquid capacity of the cooling modules 5 litres.



Cooling modules for DIX PI.GO Power sources DIX CM 589.M und DIX CM 653.M For manual welding applications



Spare parts and wear parts



Description	Part number
1 Fuse 1,6A	7421000070
2 Main switch	7421000071
3 Pressure switch	7421000090
4 Water pump	7421000021

► Liquid capacity of the cooling modules 5 litres.



Power sources MIG/MAG, TIG, MMA DIX PI 3006.M PULS (BASIC), DIX PI 4006 (4606).M (DF) PULS (BASIC) For manual welding applications

Application

- ▶ Multifunctional power sources with the latest inverter technology
- ▶ 3 phase power source, suitable up to 400V mains voltage
- ▶ Synergetically preset welding characteristics
- ▶ Separate wire feeder or as a double wire feeder variant available
- ▶ Welding using the pulse welding (PULS) and double pulse welding
- ▶ MIG / MAG welding manual / synergetic, TIG welding with „lift“ ignition welding processes (PULS)
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Seven integrated special processes with the DIX ARC 5 software for perfect control of the arc
- ▶ Version power source BASIC with DIX ARC software

Optional:

Cooling module	DIX CM 653.M
Wire feed	DIX WF 793.M
Trolley	DIX T 3
Manual remote control	DIX RC 3

Properties

- ▶ Up to 99 Jobs selectable
- ▶ All parameters for welding procedures, material and function are adjustable
- ▶ Call up and appliance of special welding characteristics via display
- ▶ Ethernet interface for network connection optional

Options according to range of application



Power source DIX PI 4006.M PULS, wire feeder DIX WF 793.M, cooling module DIX CM 653.M and Trolley DIX T 3 - Application sample



Version (DF) with two wire feeds Application sample

Technical data (IEC 60974-1, -10):

Power sources	DIX PI 3006.M PULS	DIX PI 4006.M PULS	DIX PI 4606.M PULS
Welding processes	MIG/MAG*	MIG/MAG*	MIG/MAG*
Mains voltage - 3 ph 50/60 Hz	400 V \pm 20%	400 V \pm 20%	400 V \pm 20%
Power input @ I ₂ MAX	18.8 kVA	25.5 kVA	32.0 kVA
Delayed fuse (I _{eff}) (I ₂ @60%)	25 A	30 A	40 A
Power factor / cosφ	0.64 / 0.99	0.66 / 0.99	0.66 / 0.99
Efficiency degree	0.83	0.86	0.89
Secondary open circuit voltage	63 V	70 V	70 V
Welding current control range	10-330 A	10-400 A	10-500 A
Welding current at 100% duty cycle (40 °C)	280 A	330 A	380 A
Welding current at 60% duty cycle (40 °C)	300 A	370 A	460 A
Welding current at 50% duty cycle (40 °C)	330 A (40% duty cycle)	400 A	500 A
Wire diameter	0.6mm - 1.2 mm	0.6 mm - 1.6 mm	0.6 mm - 1.6 mm
Welding wire spool Diameter / Weight	ø 300 mm / 15 kg	ø 300 mm / 15 kg	ø 300 mm / 15 kg
Protection class	IP 23 S	IP 23 S	IP 23 S
Insulation class	H	H	H
Safety marking	S - mark	S - mark	S - mark
Dimension (L/W/H)	660 / 515 / 290 mm	660 / 515 / 290 mm	660 / 515 / 290 mm
Weight approx.	35 kg	40 kg	44 kg

* The technical data refer to the main welding processes.



Power sources MIG/MAG, TIG, MMA DIX PI 3006.M PULS (BASIC), DIX PI 4006 (4606).M (DF) PULS (BASIC) For manual welding applications



Power sources system components



Power source DIX PI 4006.M PULS
Application sample

Description	Dimension	Part name	Part number
1 Power source		DIX PI 3006.M PULS	7420010019
Power source, not shown		DIX PI 3006.M PULS BASIC	7420010029
Power source, not shown		DIX PI 4006.M PULS	7420010020
Power source, not shown		DIX PI 4006.M PULS BASIC	7420010030
Power source, not shown Version for two wire feeds		DIX PI 4006.M DF PULS	7420010022
Power source, not shown Version for two wire feeds		DIX PI 4006.M DF PULS BASIC	7420010032
Power source, not shown		DIX PI 4606.M PULS	7420010021
Power source, not shown		DIX PI 4606.M PULS BASIC	7420010031
Power source, not shown Version for two wire feeds		DIX PI 4606.M DF PULS	7420010023
Power source, not shown Version for two wire feeds		DIX PI 4606.M DF PULS BASIC	7420010033
2 Wire feeder		DIX WF 793.M	7420030000
3 Cooling module		DIX CM 653.M	7420020004
Accessories			
4 Trolley		DIX T 3	7420050002
5 Torch set for MIG/MAG welding	3.00 m	DIX MSZ 304-3 SAZ	620314331
Torch set for MIG/MAG welding	4.00 m	DIX MSZ 304-4 SAZ	620314341
6 Torch set for TIG welding	4.00 m	DIX TM 26V-4	7422000002
Torch set for TIG welding	8.00 m	DIX TM 26V-8	7422000003
7 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
8 Manual remote controller		DIX RC 3	7420900006
Pressure regulator AR/CO2, not shown		DIX DRV-400	7420900007
Pressure regulator, not shown		DIX DRV-100	628080100
Ground cable, not shown	50 mm ² / 5.00 m	DIX GL.M 50-5	7420070003
Ground cable, not shown	70 mm ² / 5.00 m	DIX GL.M 70-5	7420070004
Spool adapter, not shown		DIX DV-KA	718500100
Intermediate hose package, not shown	1.2 m	DIX WFL-1.2/SW - PI.M	7420040000
Intermediate hose package, not shown	5.0 m	DIX WFL-5.0/SW - PI.M	7420040001
Intermediate hose package, not shown	10.0 m	DIX WFL-10.0/SW - PI.M	7420040002





**Power sources MIG/MAG, TIG, MMA
DIX PI 3006.M PULS (BASIC), DIX PI 4006 (4606).M (DF) PULS (BASIC)
For manual welding applications**

Spare parts and wear parts

2

MIG/MAG MMA TIG Manual



Power source DIX PI 4006.M PULS - Application sample

Description	Part number
1 Rotary knob ø 29 mm	7421000081
2 Rotary knob ø 22 mm, without index	7421000082
3 Switch button	7421000078

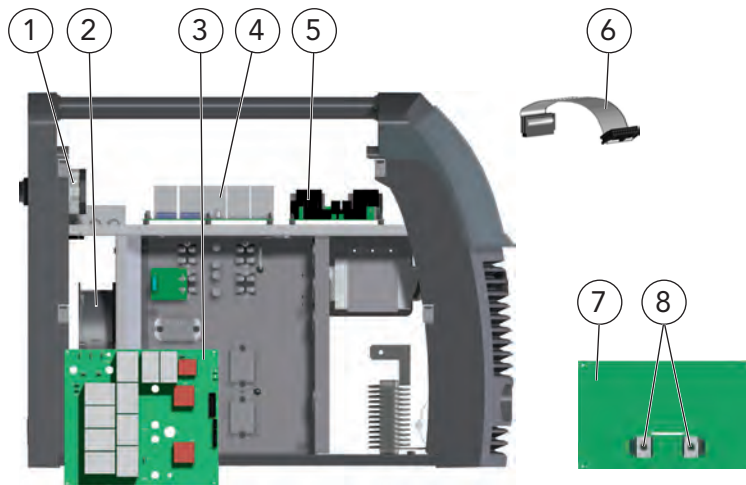


Power sources MIG/MAG, TIG, MMA DIX PI 3006.M PULS (BASIC), DIX PI 4006 (4606).M (DF) PULS (BASIC) For manual welding applications

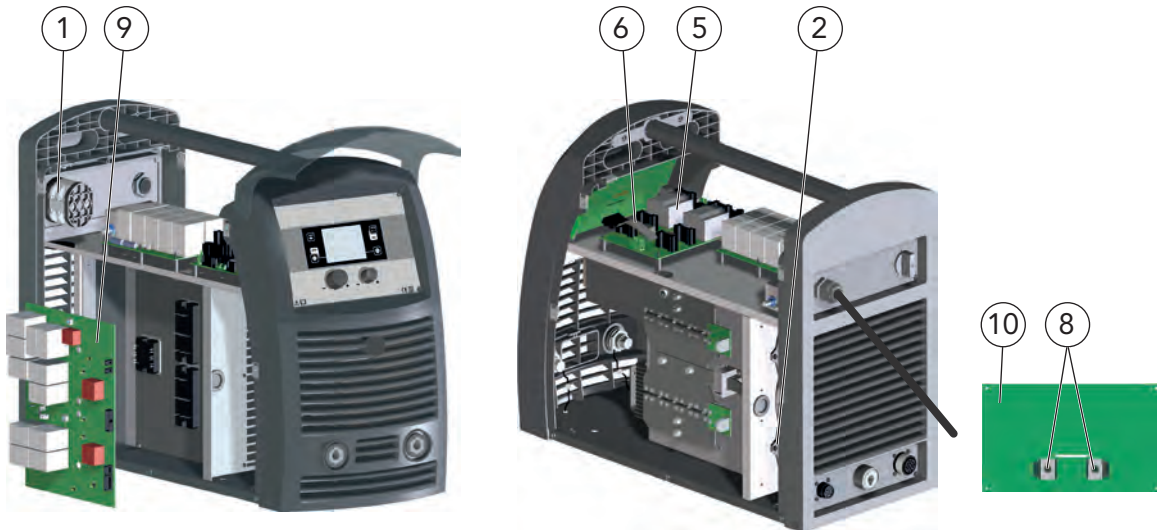


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Spare parts and wear parts



Power source DIX PI 3006.M PULS - Application sample



Power source DIX PI 4006(4606).M PULS - Application sample

Description	Part number
1 Main switch 50A	7421000074
2 Fan	7421000095
3 Power inverter assembly For DIX PI 3006.M PULS	7421000005
4 Capacitor circuit board	7421000036
5 Supply circuit board	7421000035
6 Ribbon cable	7421000064
7 Inverter board For DIX PI 3006.M PULS	7421000061
8 Encoder	7421000091
9 Power inverter assembly For DIX PI 4006.M (DF) PULS	7421000002
Power inverter assembly, not shown For DIX PI 4606.M (DF) PULS	7421000003
10 Inverter board For DIX PI 4006.M (DF) PULS	7421000062
Inverter board, not shown For DIX PI 4606.M (DF) PULS	7421000063

MIG/MAG MMA TIG Manual



Wire feeder for DIX PI Power sources MIG/MAG DIX WF 793.M For manual welding applications

Technical data (IEC 60974-5):

Wire feeder	DIX WF 793.M
Wire feed speed	0,6 - 25 m/min
Welding current, max.	600A/60% duty cycle
Welding current, max.	460A/100% duty cycle
Wire diameter	0.8 - 1.6 mm
Line voltage	24V DC
Protection class	IP 23
Dimension (L/W/H)	635/270/415 mm
Weight	approx. 15 kg

Options according to range of application



Wire feeder DIX WF 793.M - Application sample

Properties

- ▶ Large variety of variants thanks to modular design
- ▶ Separate wire feed or as a double wire feed variant available
- ▶ Powerful 4 rolls drive
- ▶ For wire spools up to ø 300 mm
- ▶ Compact design
- ▶ More ease of use thanks to quick release couplings
- ▶ For all common SAZ fittings connections
- ▶ Supportive PUSH operation for wire feeding over long distances
- ▶ Tool-free exchange of the wire feed rolls



Rear of wire feeder connections for gas line, intermediate hose package, quick connector pulse pol and cooling welding set



4 rolls drive

Application

- ▶ Solid and flux-cored wires
- ▶ Non- and low alloyed steels
- ▶ High alloyed steels
- ▶ Aluminum-, magnesium-, copper-and nickel alloys
- ▶ Small to large material thicknesses



Double wire feed variant - Application sample



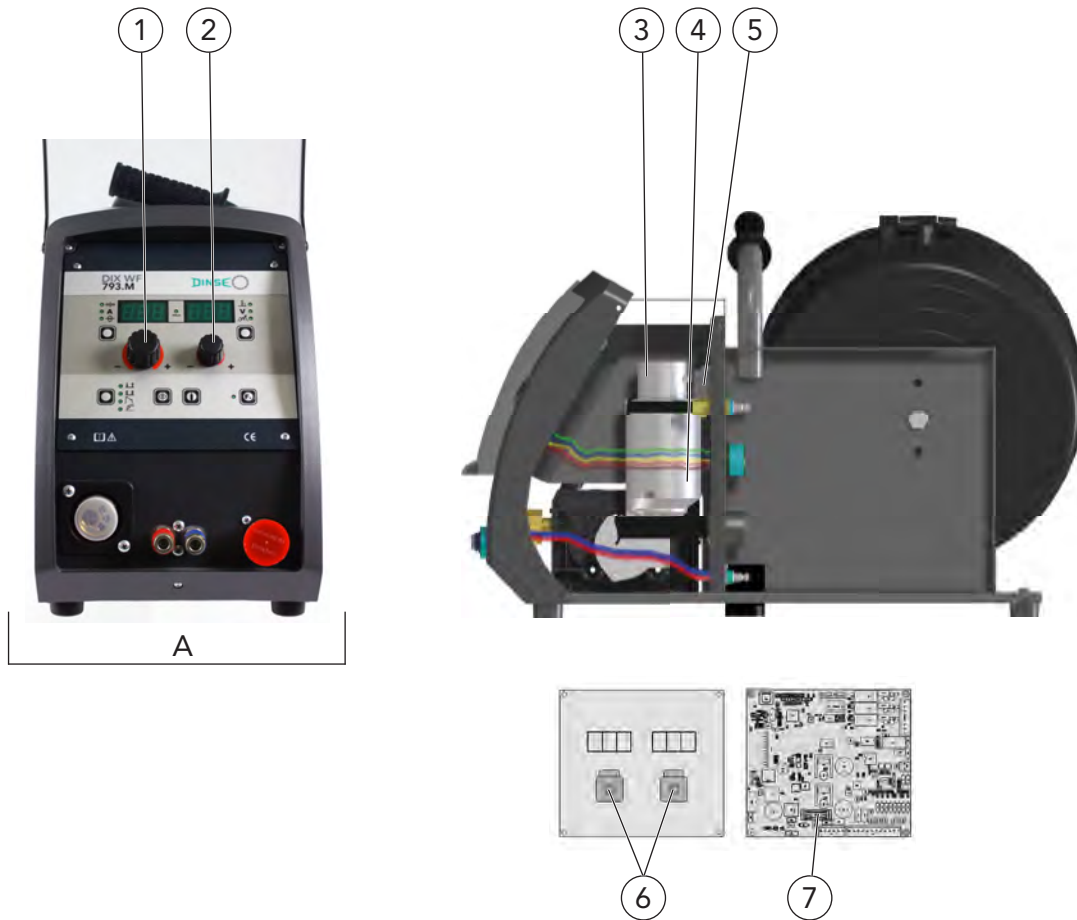
Wire feeder for DIX PI Power sources MIG/MAG

DIX WF 793.M

For manual welding applications



Spare parts and wear parts



2

Description	Part name	Part number
A Wire feeder	DIX WF 793.M	7420030000
1 Rotary knob ø 29 mm		7421000081
2 Rotary knob ø 22 mm, without index		7421000082
3 Encoder		7421000092
4 Motor with encoder		7421000083
5 Gas valve		7421000067
6 Encoder		7421000091
7 Fuse 10A		7421000069
Panel WF, not shown		7421000088
Front circuit board, not shown		7421000034



Wire feeder for DIX PI Power sources MIG/MAG

Drive rolls WFR-xxx S(A)(C)

For manual welding applications

Spare parts and wear parts

2



Description	Dimension	Part name	Part number
Type of application for steel wire electrodes:			
1 Drive roll	Wire ø 0,6 + 0,8 mm	DIX WFR-0608 S	7410084108
Drive roll	Wire ø 0,9 + 1,0 mm	DIX WFR-0910 S	7410084110
Drive roll	Wire ø 1,0 + 1,2 mm	DIX WFR-1012 S	7410084112
Drive roll	Wire ø 1,2 + 1,4 mm	DIX WFR-1214 S	7410084114
Drive roll	Wire ø 1,4 + 1,6 mm	DIX WFR-1416 S	7410084116
Type of application for aluminum and copper alloy wire electrodes:			
Drive roll	Wire ø 0,8 + 1,0 mm	DIX WFR-0810 A	7410084210
Drive roll	Wire ø 1,0 + 1,2 mm	DIX WFR-1012 A	7410084212
Drive roll	Wire ø 1,6 + 2,4 mm	DIX WFR-1624 A	7410084224
Type of application for cored wires:			
Drive roll	Wire ø 0,8 + 0,9 mm	DIX WFR-0809 C	7410084309
Drive roll	Wire ø 1,0 + 1,2 mm	DIX WFR-1012 C	7410084312
Drive roll	Wire ø 1,2 + 1,4 mm	DIX WFR-1214 C	7410084314
Drive roll	Wire ø 1,6 + 2,0 mm	DIX WFR-1620 C	7410084320
Drive roll	Wire ø 1,6 + 2,4 mm	DIX WFR-1624 C	7410084324

► Each wire diameter requires his own drive roll. Other diameters on request.



Power sources MIG/MAG, TIG, MMA DIX PI 3006(3506).M I (BASIC), DIX PI 3006(3506).M I PULS (BASIC) For manual welding applications



2

MIG/MAG MMA TIG Manual



Application

- ▶ Multifunctional power sources with the latest inverter technology
- ▶ 3 phase power source, suitable for 400V mains voltage
- ▶ Synergetically preset welding characteristics
- ▶ Intuitive program selection
- ▶ With security protection VRD (Voltage reduction device)
- ▶ Integrated 4 roll wire feeder
- ▶ Welding using the pulse welding (PULS) and double pulse welding
- ▶ MIG / MAG welding manual / synergetic, TIG welding with „lift“ ignition welding processes (PULS)
- ▶ Manual Metal ARC-Verfahren (MMA) mit Stabelektroden zum Schweißen von Cellulose-Elektroden geeignet
- ▶ Two integrated special processes with the DIX ARC.COOL and DIX ARC.MEGA FAST software for perfect control of the arc
- ▶ Version power source BASIC with DIX ARC software
- ▶ For 15 kg wire spool (Ø 300mm)

Optional:

Cooling module DIX CM 589.M
Trolley DIX T 3

Options according to range of application



Power source DIX PI 3006.M I PULS, integrated wire feeder, cooling module DIX CM 589.M and trolley DIX T 3
Application sample

Properties

- ▶ Up to 99 Jobs selectable
- ▶ All parameters for welding procedures, material and function are adjustable
- ▶ Call up and appliance of special welding characteristics via display
- ▶ Ethernet interface for network connection optional

Technical data (IEC 60974-1, -10):				
Power sources	DIX PI 3006.M I	DIX PI 3506.M I	DIX PI 3006.M I PULS	DIX PI 3506.M I PULS
Welding processes	MIG/MAG*	MIG/MAG*	MIG/MAG*	MIG/MAG*
Mains voltage - 3 ph 50/60 Hz	400 V±20%	400 V±20%	400 V±20%	400 V±20%
Power input @ I ₂ MAX	13 kVA	17,8 kVA	17 kVA	23,7 kVA
Delayed fuse (I _{eff}) (I ₂ @60%)	20A	20A	25A	25A
Power factor / cosφ	0.87 / 0.99	0.92 / 0.99	0.66 / 0.99	0.70 / 0.99
Efficiency degree	0.86	0.85	0.86	0.85
Secondary open circuit voltage	63V	63V	63V	63V
Welding current control range	10-320A	10-400A	10-320A	10-400A
Welding current at 100% duty cycle (40 °C)	280A	300A	280A	300A
Welding current at 60% duty cycle (40 °C)	300A	350A	300A	350A
Welding current at 40% duty cycle (40 °C)	320A	400A	320A	400A
Wire diameter	0.6mm - 1.2 mm	0.6mm - 1.2 mm	0.6mm - 1.2 mm	0.6mm - 1.2 mm
Welding wire spool Diameter / Weight	ø 300 mm / 15 kg	ø 300 mm / 15 kg	ø 300 mm / 15 kg	ø 300 mm / 15 kg
Protection class	IP 23 S		IP 23 S	IP 23 S
Insulation class	H		H	H
Safety marking	S - mark		S - mark	S - mark
Dimension (L/W/H) mm	660 / 515 / 290	660 / 515 / 290	660 / 515 / 290	660 / 515 / 290
Weight approx.	41 kg	42 kg	42 kg	43 kg

* The technical data refer to the main welding processes.

Power sources MIG/MAG, TIG, MMA DIX PI 3006(3506).M I (BASIC), DIX PI 3006(3506).M I PULS (BASIC) For manual welding applications

Power sources system components



Power source DIX PI 3006.M I PULS
Application sample

Description	Dimension	Part name	Part number
1 Power source		DIX PI 3006.M I	7420010014
Power source, not shown		DIX PI 3506.M I	7420010017
Power source, not shown		DIX PI 3006.M I BASIC	7420010025
Power source, not shown		DIX PI 3506.M I BASIC	7420010027
Power source, not shown		DIX PI 3006.M I PULS	7420010015
Power source, not shown		DIX PI 3506.M I PULS	7420010016
Power source, not shown		DIX PI 3006.M I PULS BASIC	7420010026
Power source, not shown		DIX PI 3506.M I PULS BASIC	7420010028
2 Cooling module		DIX CM 589.M	7420020002
Accessories			
3 Trolley		DIX T 3	7420050002
4 Torch set for MIG/MAG welding	3.00 m	DIX MSZ 304-3 SAZ	620314331
Torch set for MIG/MAG welding	4.00 m	DIX MSZ 304-4 SAZ	620314341
5 Torch set for MIG/MAG welding	3.00 m	DIX MSZ 330-3 SAZ	6203133131
Torch set for MIG/MAG welding	4,00 m	DIX MSZ 330-4 SAZ	6203133141
6 Torch set for TIG welding	4.00 m	DIX TM 26V-4	7422000002
Torch set for TIG welding	8.00 m	DIX TM 26V-8	7422000003
7 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
Pressure regulator AR/CO2, not shown	0-30 l/min	DIX DRV-400	7420900007
Pressure regulator, not shown		DIX DRV-100	628080100
Ground cable, not shown	50 mm ² / 5.00 m	DIX GL.M 50-5	7420070003
Spool adapter, not shown		DIX DV-KA	718500100



Power sources MIG/MAG, TIG, MMA
 DIX PI 3006(3506).M I (BASIC), DIX PI 3006(3506).M I PULS (BASIC)
 For manual welding applications



Spare parts and wear parts



Power source DIX PI 3006.M I PULS - Application sample

Description	Part name	Part number
1 Rotary knob ø 29 mm		7421000081
2 Rotary knob ø 22 mm, without index		7421000082
3 Switch button		7421000078

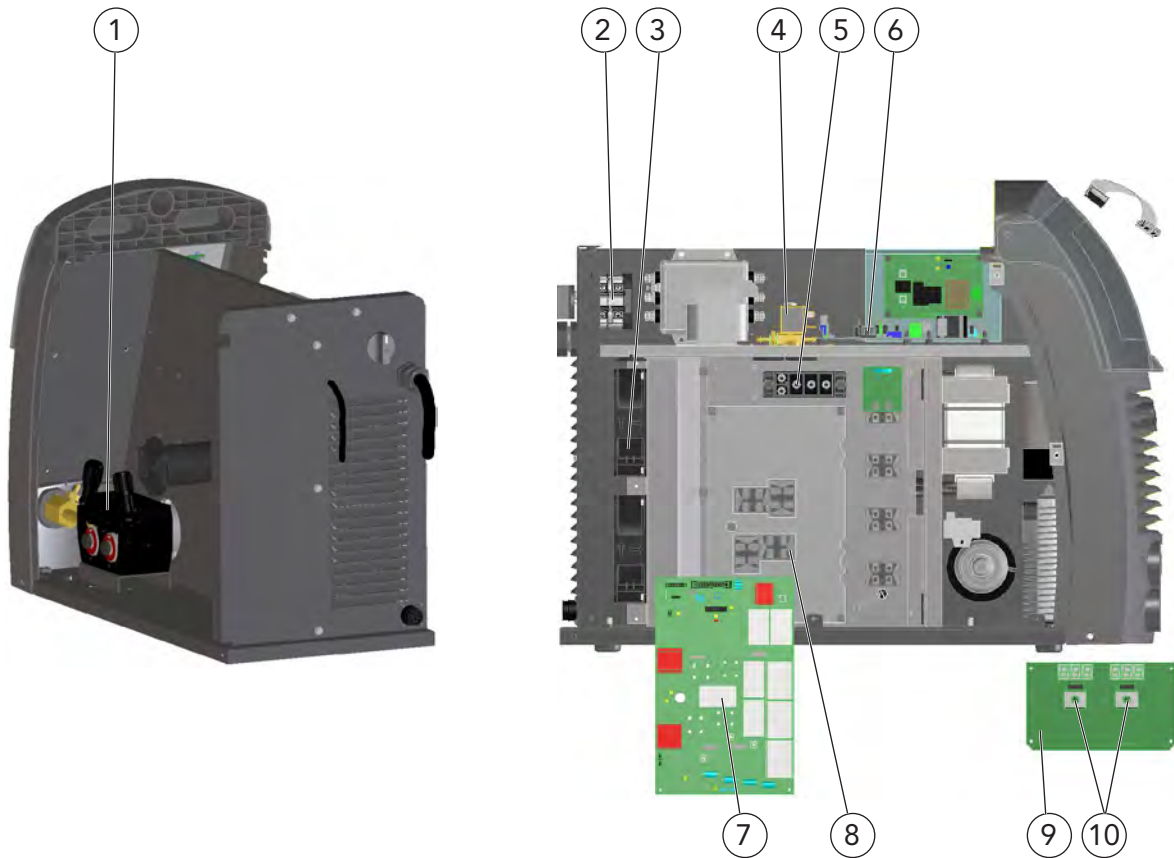


Power sources MIG/MAG, TIG, MMA DIX PI 3006(3506).M I (BASIC), DIX PI 3006(3506).M I PULS (BASIC) For manual welding applications

Spare parts and wear parts

2

MIG/MAG MMA TIG Manual



Power source DIX PI 3006.M I PULS - Application sample

Description	Part number
1 4 rolls drive unit	7421000013
2 Main switch 32A	7421000076
3 Fan	7421000094
4 Gas valve	7421000066
5 Rectifier	7421000093
6 Supply and motor board	7421000056
7 Inverter board For DIX PI 3006.M I (PULS)	7421000057
Inverter board, not shown For DIX PI 3506.M I (PULS)	7421000058
8 Primary IGBT	7421000019
9 Interface board (digital) For DIX PI 3006.M I	7421000049
Interface board, not shown For DIX PI 3006.M I PULS	7421000051
Interface board, not shown For DIX PI 3506.M I	7421000054
Interface board, not shown For DIX PI 3506.M I PULS	7421000055
10 Encoder	7421000091



Power sources TIG, MMA

DIX TIG.GO 1406.M HF und DIX TIG.GO 1406.M HF PRO

For manual welding applications



2

Application

- ▶ Multifunctional power sources with the latest inverter technology
- ▶ 1 phase power source
- ▶ Suitable for 230V mains voltage
- ▶ Operating mode 2 stroke, 4 stroke and Spot welding
- ▶ Synergetically preset welding characteristics
- ▶ With security protection VRD (Voltage reduction device)
- ▶ The PRO version with PULSE function up to 500 Hz
- ▶ TIG welding with „lift“ ignition (PULS)
- ▶ High-frequency arc start or via Lift-ARC
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Digital display
- ▶ Low weight of approx. 7.5 kg
- ▶ **Optional:**
 - Handheld remote control DIX RC 2
 - Remote foot control DIX RC 1

Properties

- ▶ Up to 99 Jobs selectable (only for DIX TIG.GO 1406.M HF PRO)
- ▶ All parameters for welding procedures, material and function are adjustable

Options according to range of application



Power source DIX TIG.GO 1406.M HF
Application sample

Options according to range of application



Power source DIX TIG.GO 1406.M HF PRO
Application sample

TIG MMA Manual

Technical data (IEC 60974-1, -10):				
Power sources	DIX TIG.GO 1406.M HF		DIX TIG.GO 1406.M HF PRO	
Welding processes	WIG DC	MMA	WIG DC	MMA
Mains voltage - 1 ph 50/60 Hz	230 V \pm 20%		230 V \pm 20%	
Power input @ I ₂ MAX	8.5 kVA	9.0 kVA	8.5 kVA	9.0 kVA
Delayed fuse (I ₂ @ 100%)	20 A		20 A	
Power factor / cosφ	0.67 / 0.99		0.67 / 0.99	
Efficiency degree MAX	0.82	0.84	0.82	0.84
Secondary open circuit voltage	88 V		88 V	
Welding current control range	5-200 A	5-160 A	5-200 A	5-160 A
Welding current at 100% duty cycle (40°C)	120 A	110 A	120 A	110 A
Welding current at 60% duty cycle (40°C)	140 A	130 A	140 A	130 A
Welding current I ₂ @ X% duty cycle (40°C)	200 A (25%)	160 A (30%)	200 A (25%)	160 A (30%)
Mains cable length (m) / cross-section (mm ²)	2.5 / 2.5		2.5 / 2.5	
Ground cable cross-section (mm ²)	25		25	
Protection class	IP 23 S		IP 23 S	
Insulation class	F		F	
Dimension (L/W/H)	390 / 300 / 135		390 / 300 / 135	
Weight approx.	7.5 kg		7.5 kg	



Power sources TIG, MMA DIX TIG.GO 1406.M HF and DIX TIG.GO 1406.M HF PRO For manual welding applications

Power sources system components

2

TIG MMA Manual



Power source DIX TIG GO 1406.M HF
Application sample



Description	Dimension	Part name		Part number
1 Power source		DIX	TIG.GO 1406.M HF	7420010004
Power source, not shown		DIX	TIG.GO 1406.M HF PRO	7420010005
Accessories				
2 Torch set for TIG welding	4.00 m	DIX	TM 17-4	7422000004
Torch set for TIG welding	8.00 m	DIX	TM 17-8	7422000005
Torch set for TIG welding	4.00 m	DIX	TM 26-4	7422000006
Torch set for TIG welding	8.00 m	DIX	TM 26-8	7422000007
3 Remote foot controller		DIX	RC 1	7420900003
4 Handheld remote control		DIX	RC 2	7420900004
Ground cable, not shown	25 mm ² / 4.00 m	DIX	GL.M 25-4	7420070001
Ground cable, not shown	35 mm ² / 5.00 m	DIX	GL.M 35-5	7420070002
Adapter cable, not shown For connection at handheld remote control and TIG torch set				7420900005
Shoulder belt, not shown		DIX	PI GO	7420900002
Pressure regulator AR/CO ₂ , not shown	0-30 l/min	DIX	DRV-400	7420900007
Pressure regulator, not shown	0-20 l/min	DIX	DRV-100	628080100



Power sources TIG, MMA DIX TIG.GO 1406.M HF and DIX TIG.GO 1406.M HF PRO For manual welding applications



Spare parts and wear parts



Power source DIX TIG GO 1406.M HF - Application sample

Description	Part number
1 Rotary knob ø 29 mm	7421000081
2 Switch button	7421000077

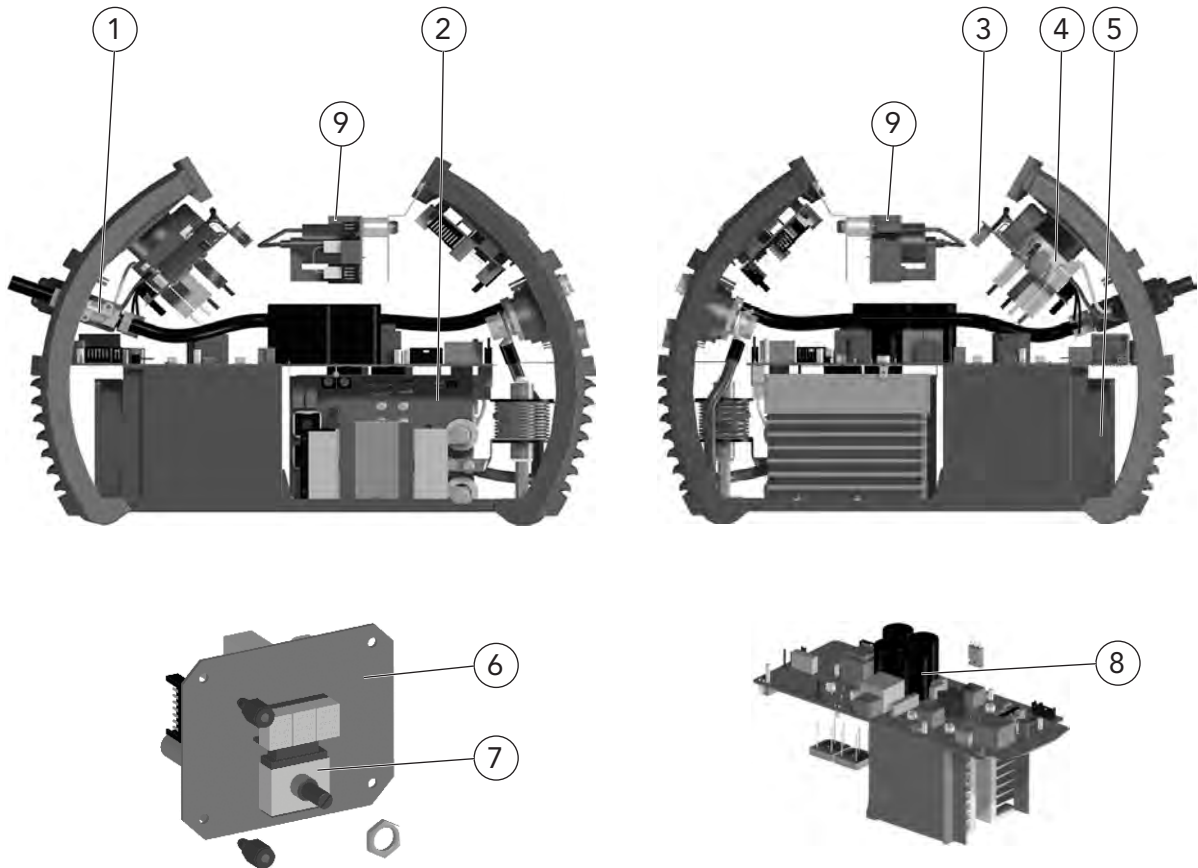


Power sources TIG, MMA DIX TIG.GO 1406.M HF and DIX TIG.GO 1406.M HF PRO For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Power source DIX TIG GO 1406.M HF - Application sample

Description	Part number
1 Gas valve	7421000065
2 Secondary board 1406 MFH	7421000047
3 Board 1406 MHF	7421000046
4 Main switch	7421000072
5 Fan motor	7421000086
6 Front board For DIX TIG.GO 1406.M HF	7421000044
Front board A For DIX TIG.GO 1406.M HF PRO	7421000045
7 Encoder	7421000091
8 Power inverter module	7421000010
9 HF board	7421000043



Power sources TIG, MMA

DIX TIG.GO 1806.M AC/DC and DIX TIG.GO 2506.M AC/DC

For manual welding applications



Application

- ▶ Multifunctional power sources with the latest inverter technology
- ▶ 1 or 3 phase power source
- ▶ Suitable for 230V / 400V mains voltage
- ▶ Synergetic selection of PULS parameters
- ▶ With security protection VRD (Voltage reduction device)
- ▶ TIG welding with „lift“ ignition (PULS)
- ▶ High frequency arc start
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Digital display
- ▶ Low weight of approx. 15.5 / 19 kg
- ▶ **Optional:**
 - Remote foot control DIX RC 1
 - Handheld remote control DIX RC 2

Properties

- ▶ Up to 99 Jobs selectable
- ▶ Setting of all parameters for waveform and functions

Options according to range of application



Power source DIX TIG.GO 2506.M AC/DC
Application sample

Options according to range of application



Power source DIX TIG.GO 1806.M AC/DC with cooling module DIX CM 141.M -
Application sample

TIG MMA Manual

Technical data (IEC 60974-1, -10):				
Power sources	DIX TIG.GO 1806.M AC/DC		DIX TIG.GO 2506.M AC/DC	
Welding processes	TIG	MMA	TIG	MMA
Mains voltage 50/60 Hz	1~230 V±20%		3~400 V±20%	
Power input @ I ₂ MAX	6.5 kVA	7.0 kVA	9.6 kVA	
Delayed fuse (I ₂ @ 100%)	16 A		10 A	
Power factor / cosφ	0.99 / 0.99		0.95 / 0.99	
Efficiency degree MAX	0.77		0.76	0.81
Secondary open circuit voltage	100 V		100 V	
Welding current control range	5-220 A	10-180 A	5-300 A	10-250 A
Welding current at 100% duty cycle (40°C)	140 A	120 A	210 A	190 A
Welding current at 60% duty cycle (40°C)	180 A	150 A	250 A	220 A
Welding current I ₂ @ X% duty cycle (40°C)	220 A (30%)	180 A (30%)	300 A (35%)	250 A (40%)
Mains cable length (m) / cross-section (mm ²)	3.5 / 2.5		4.0 / 2.5	
Ground cable cross-section (mm ²)	25		35	
Electrodes to be used (mm)	1.2 - 2.4	1.6 - 4.0	1.2 - 4.0	1.6 - 5.0
Protection class	IP 23 S		IP 23 S	
Insulation class	F		F	
Dimension (L/W/H)	465 / 390 / 185		495 / 390 / 185	
Weight approx.	15.5 kg		19 kg	

2



Power sources TIG, MMA

DIX TIG.GO 1806.M AC/DC and DIX TIG.GO 2506.M AC/DC For manual welding applications

Power sources system components

2

TIG MMA Manual



Power source DIX TIG.GO 1806.M AC/DC with cooling module DIX CM 141.M and Trolley DIX T1
Application sample

Description	Dimension	Part name	Part number
1 Power source		DIX TIG.GO 1906.M AC/DC	7420010006
Power source, not shown		DIX TIG.GO 2506.M AC/DC	7420010007
2 Cooling module		DIX CM 141.M	7420020000
Cooling module, not shown		DIX CM 592.M	7420020001
3 Trolley		DIX T 1	7420050000
Accessories			
4 Torch set for TIG welding	4.00 m	DIX TM 26-4	7422000006
Torch set for TIG welding, not shown	8.00 m	DIX TM 26-8	7422000007
Torch set for TIG welding, not shown	4.00 m	DIX TMZ 18-4	7422000008
Torch set for TIG welding, not shown	8.00 m	DIX TMZ 18-8	7422000009
Torch set for TIG welding, not shown	4.00 m	DIX TMZ 20-4	7422000010
Torch set for TIG welding, not shown	8.00 m	DIX TMZ 20-8	7422000011
5 Remote foot control		DIX RC 1	7420900003
6 Handheld remote control		DIX RC 2	7420900004
7 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
Ground cable, not shown	35 mm ² / 5.00 m	DIX GL.M 35-5	7420070002
Adapter cable, not shown For connection at handheld remote control and TIG torch set			7420900005
Shoulder belt, not shown		DIX PI GO	7420900002
Pressure regulator AR/CO ₂ , not shown	0-30 l/min	DIX DRV-400	7420900007
Pressure regulator, not shown	0-20 l/min	DIX DRV-100	628080100



Power sources TIG, MMA DIX TIG.GO 1806.M AC/DC and DIX TIG.GO 2506.M AC/DC For manual welding applications



Spare parts and wear parts



Application sample



Rear view power source DIX TIG.GO 1806.M AC/DC



Application sample



Rear view power source DIX TIG.GO 2506.M AC/DC

2

TIG MMA Manual

Description	Part number
1 Rotary knob \varnothing 29 mm without index	7421000082
2 Switch button	7421000077
3 Main switch For DIX TIG.GO 1806.M AC/DC	7421000072
4 Main switch 16A For DIX TIG.GO 2506.M AC/DC	7421000075

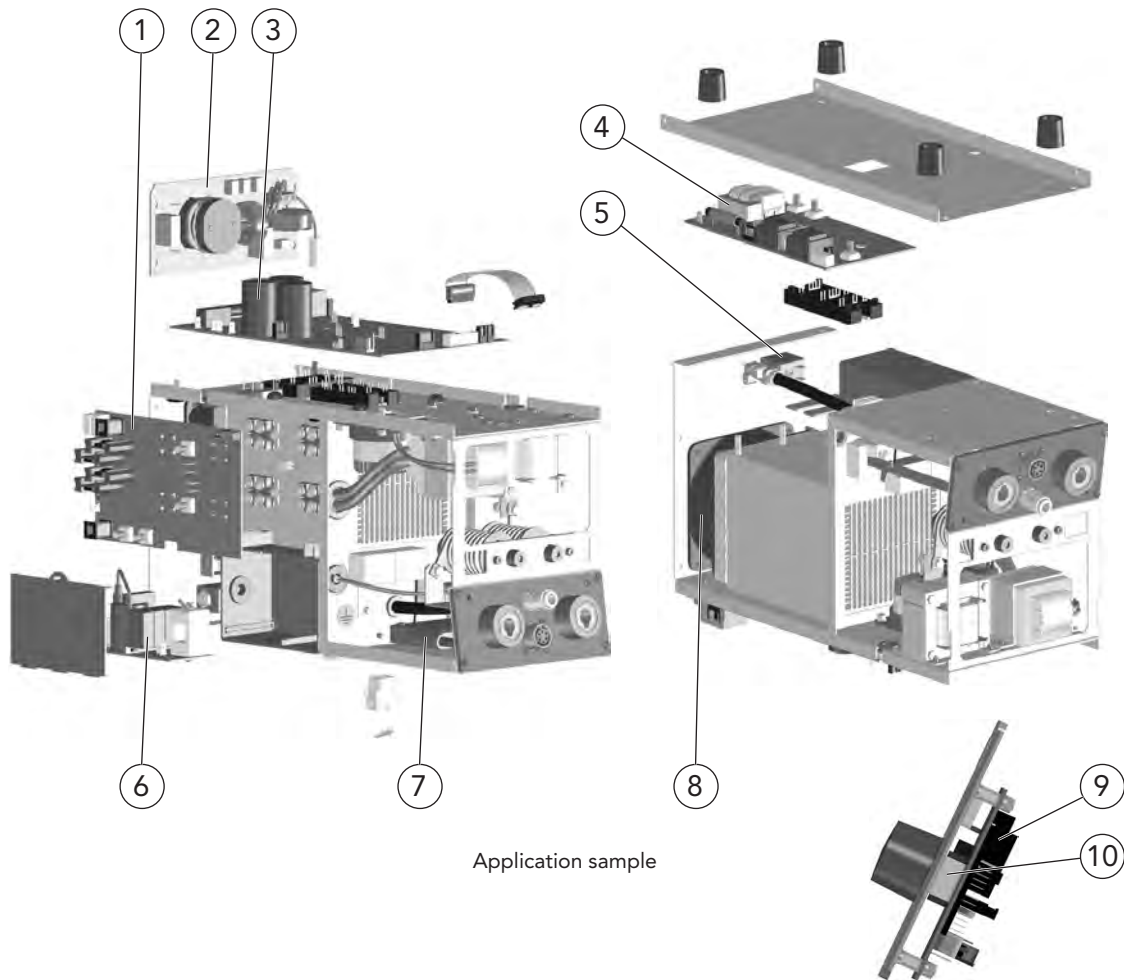


Power sources TIG, MMA DIX TIG.GO 1806.M AC/DC For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Application sample

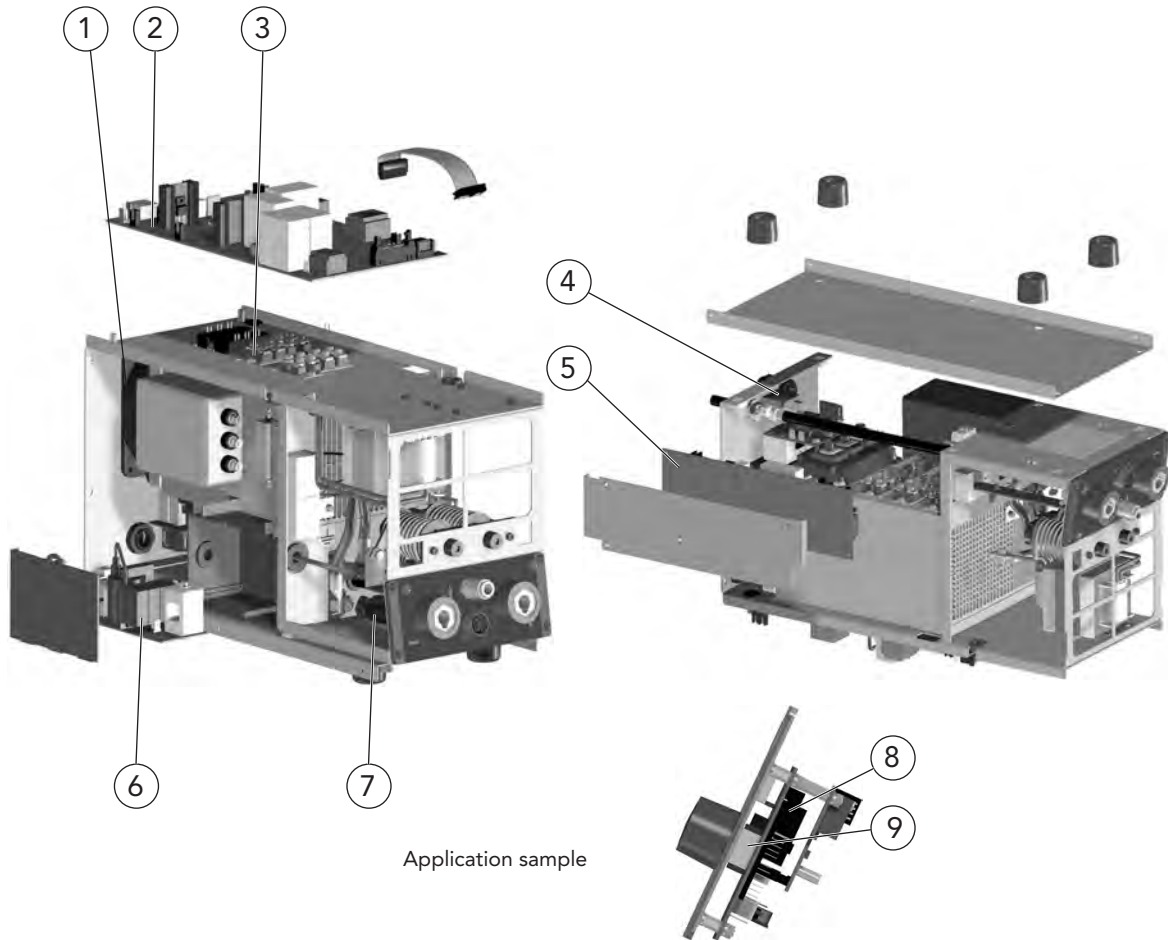
Description	Part number
1 Secondary board 1806 AC/DC	742100032
2 EMC board	742100029
3 Power inverter module	742100004
4 Secondary IGBT	742100011
5 Gas valve	742100065
6 HF board	742100028
7 Filter plate	742100022
8 Fan	742100096
9 Interface board	742100030
10 Encoder	742100091



Power sources TIG, MMA DIX DIX TIG.GO 2506.M AC/DC For manual welding applications



Spare parts and wear parts



TIG MMA Manual

Description	Part number
1 Fan	7421000096
2 Power inverter module	7421000001
3 Primary IGBT	7421000019
4 Gas valve	7421000066
5 Secondary board 2506 AC/DC	7421000038
6 HF board	7421000028
7 Filter plate	7421000022
8 Interface board	7421000040
9 Encoder	7421000091



Power sources TIG, MMA

DIX TIG.GO 1906.M HF and DIX TIG.GO 2506.M HF

For manual welding applications

Application

- ▶ Multifunctional power sources with the latest inverter technology
- ▶ 1 or 3 phase power source
- ▶ Suitable for 230V / 400V mains voltage
- ▶ Synergetic selection of PULS parameters
- ▶ With security protection VRD (Voltage reduction device)
- ▶ TIG welding with „lift“ ignition (PULS)
- ▶ High frequency arc start
- ▶ Manual metal ARC process (MMA) with electrodes suitable for welding cellulose electrodes
- ▶ Digital display
- ▶ Low weight of approx. 14 / 17.5 kg
- ▶ **Optional:**
 - Remote foot control DIX RC 1
 - Handheld remote control DIX RC 2

Properties

- ▶ Up to 99 Jobs selectable
- ▶ Setting of all parameters for procedures and functions

Options according to range of application



Power source DIX TIG.GO 2506.M HF
Application sample

Options according to range of application



Power source DIX TIG.GO 1906.M HF with cooling module DIX CM 141.M
Application sample

Technical data (IEC 60974-1, -10):				
Power sources	DIX TIG.GO 1906.M HF		DIX TIG.GO 2506.M HF	
	TIG	MMA	TIG	MMA
Welding processes				
Mains voltage 50/60 Hz	1~230 V±20%		3~400 V±20%	
Power input @ I ₂ MAX	6.0 kVA	6.6 kVA	9.1 kVA	9.8 kVA
Delayed fuse (I ₂ @ 100%)	16 A		10 A	
Power factor / cosφ	0.99 / 0.99		0.96 / 0.99	0.95 / 0.99
Efficiency degree MAX	0.77	0.80	0.78	0.83
Secondary open circuit voltage	100 V		100 V	
Welding current control range	5-220 A	10-180 A	5-300 A	10-270 A
Welding current at 100% duty cycle (40°C)	160 A	120 A	210 A	200 A
Welding current at 60% duty cycle (40°C)	190 A	150 A	250 A	230 A
Welding current @ *30%/**35% duty cycle (40°C)	220 A*	180 A*	300 A**	270 A**
Mains cable length (m) / cross-section (mm ²)	3.5 / 2.5		4.0 / 2.5	
Ground cable cross-section (mm ²)	25		35	
Electrodes to be used (mm)	1.2 - 2.4	1.6 - 4.0	1.2 - 4.0	1.6 - 5.0
Protection class	IP 23 S		IP 23 S	
Insulation class	F		F	
Dimension (L/W/H)	465 / 390 / 185		495 / 390 / 185	
Weight approx.	14 kg		17.5 kg	



Power sources TIG, MMA

DIX TIG.GO 1906.M HF and DIX TIG.GO 2506.M HF

For manual welding applications



Power sources system components



Power source DIX TIG.GO 1906.M AC/DC with cooling module DIX CM 141.M and Trolley DIX T1 Application sample

Description	Dimension	Part name	Part number
1 Power source		DIX TIG.GO 1906.M HF	7420010006
Power source, not shown		DIX TIG.GO 2506.M HF	7420010007
2 Cooling module		DIX CM 141.M	7420020000
Cooling module, not shown		DIX CM 592.M	7420020001
3 Trolley		DIX T 1	7420050000
Accessories			
4 Torch set for TIG welding	4.00 m	DIX TM 26-4	7422000006
Torch set for TIG welding, not shown	8.00 m	DIX TM 26-8	7422000007
Torch set for TIG welding, not shown	4.00 m	DIX TMZ 18-4	7422000008
Torch set for TIG welding, not shown	8.00 m	DIX TMZ 18-8	7422000009
Torch set for TIG welding, not shown	4.00 m	DIX TMZ 20-4	7422000010
Torch set for TIG welding, not shown	8.00 m	DIX TMZ 20-8	7422000011
5 Remote foot control		DIX RC 1	7420900003
6 Handheld remote control		DIX RC 2	7420900004
7 Coolant	10 Liter	DIX CM LIQUID 10L	7410082100
Ground cable, not shown	35 mm ² / 5.00 m	DIX GL.M 35-5	7420070002
Adapter cable, not shown For connection at handheld remote control and TIG torch set			7420900005
Shoulder belt, not shown		DIX PI GO	7420900002
Pressure regulator AR/CO ₂ , not shown	0-30 l/min	DIX DRV-400	7420900007
Pressure regulator, not shown	0-20 l/min	DIX DRV-100	628080100



Power sources TIG, MMA DIX TIG.GO 1906.M HF and DIX TIG.GO 2506.M HF For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Application sample



Rear view power source DIX TIG.GO 1906.M HF



Application sample



Rear view power source DIX TIG.GO 2506.M HF

Description	Part number
1 Rotary knob \varnothing 29 mm without index	742100082
2 Switch button	742100077
3 Main switch Für DIX TIG.GO 1906.M HF	742100072
4 Main switch 16A Für DIX TIG.GO 2506.M HF	742100075

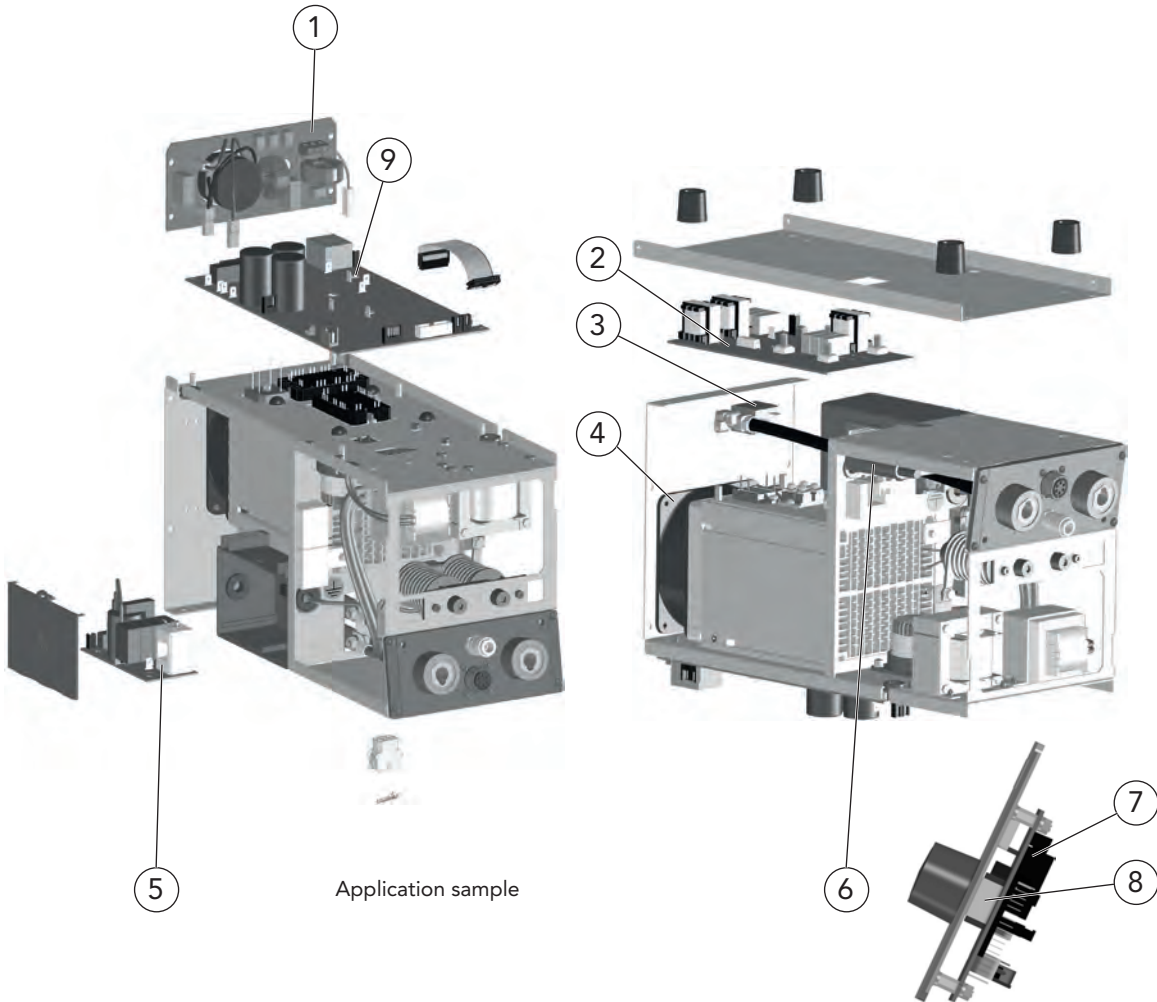


Power sources TIG, MMA DIX TIG.GO 1906.M HF For manual welding applications



Spare parts and wear parts

2



TIG MMA Manual

Description	Part number
1 EMC board	7421000029
2 Secondary board 1906 HF	7421000033
3 Gas valve	7421000065
4 Fan	7421000096
5 HF board	7421000028
6 Filter plate	7421000022
7 Interface board	7421000031
8 Encoder	7421000091
9 Power inverter module	7421000004

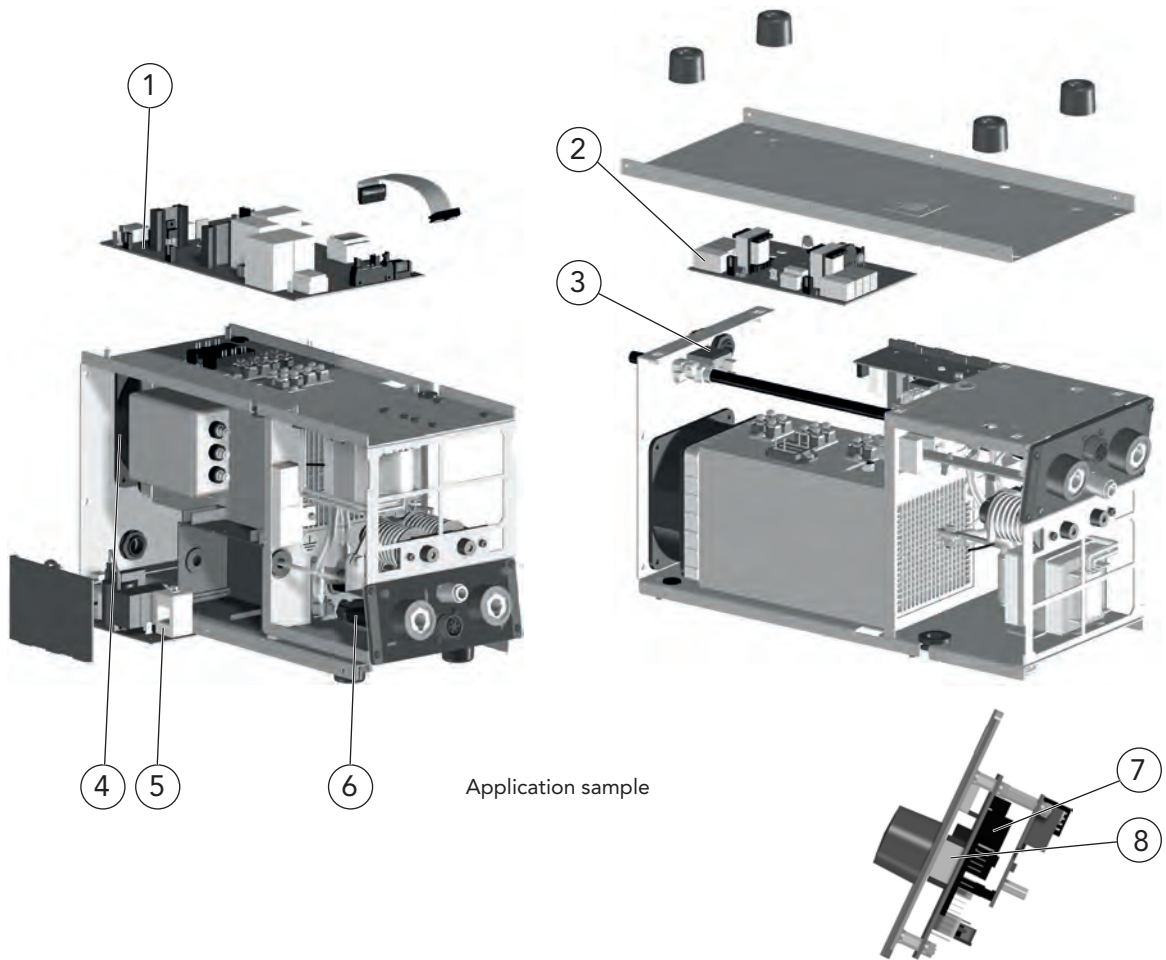


Power sources TIG, MMA DIX TIG.GO 2506.M HF For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Application sample

Description	Part number
1 Power inverter module	7421000001
2 Secondary board 2506 HF	7421000042
3 Gas valve	7421000066
4 Fan	7421000096
5 HF board	7421000028
6 Filter plate	7421000022
7 Interface board	7421000041
8 Encoder	7421000091



Cooling modules for DIX TIG.GO Power sources DIX CM 141.M and DIX CM 592.M For manual welding applications



Technical data (IEC 60974-2/10):		
Cooling module	DIX CM 141.M	DIX CM 592.M
Connection tension	230V	400V
Cooling type	circulating air	circulating air
Cooling performance	max.0.3 kW	max.0.3 kW
Cooling loop pressure	max. 4.3 bar	max. 4.3 bar
Tank volume approx.	2.5 Liter	2.5 Liter
Protection class	IP 23	IP 23
Dimensions (L/W/H)	515/225/185	545/225/185
Weight, approx. (without coolant)	ca. 9.5 kg	ca. 10 kg
Weight, approx. (with coolant)	12 kg	12.5 kg

Options according to range of application



Cooling module DIX CM 141.M Application sample

Properties

- ▶ Standard control by the power source
- ▶ Single-phase electric pump

Application

- ▶ Manual welding applications
- ▶ Cooling module for compact power sources



Power sources with cooling module and trolley
Application sample



	Description	Part name	Part number
A	Cooling module, standard control	DIX CM 141.M	7420020000
	Cooling module, standard control, not shown	DIX CM 592.M	7420020001
1	Coolant, 10 litres	DIX CM LIQUID 10L	7410082100

- ▶ Liquid capacity of the cooling modules 5 litres.

TIG MMA Manual

2



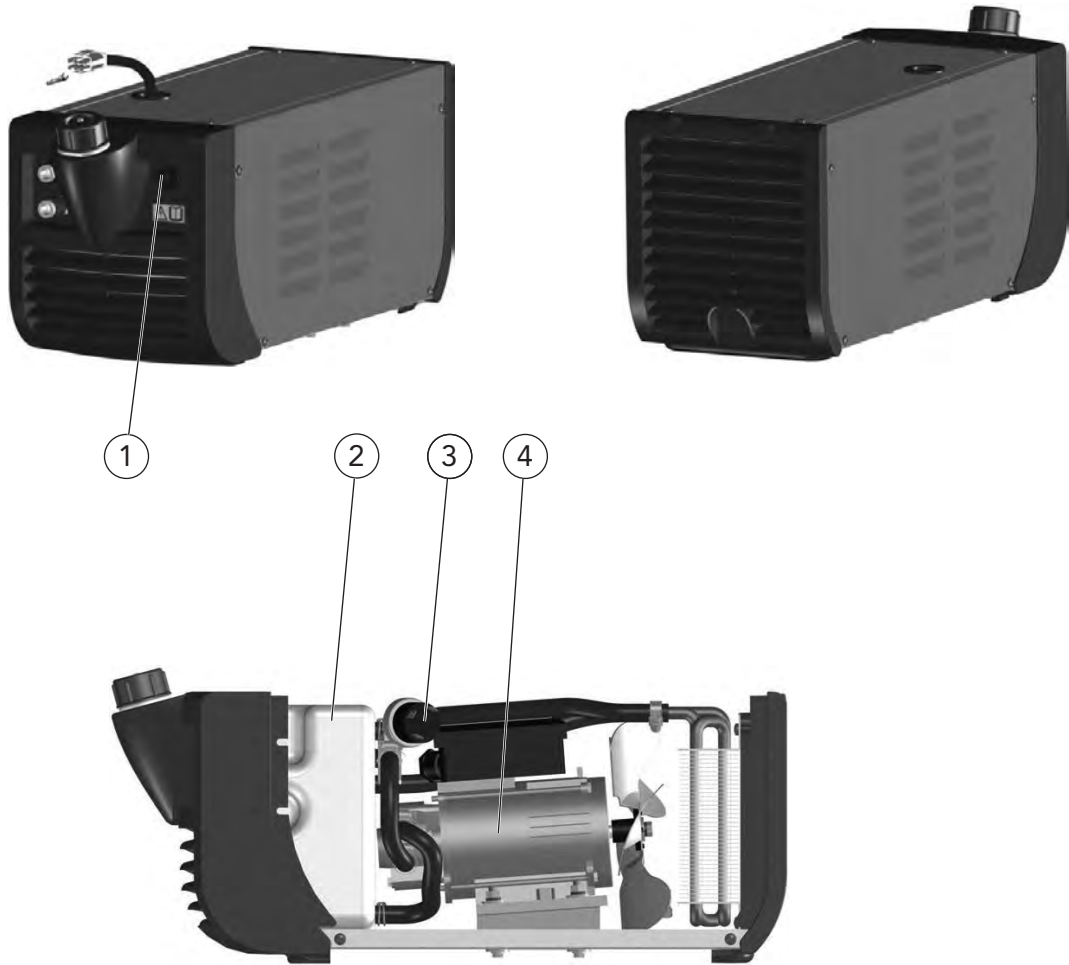


Cooling modules for DIX TIG.GO Power sources DIX CM 141.M and DIX CM 592.M For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Description	Artikelnummer
1 Fuse 1.6A	7421000070
2 Cooling water tank	7421000122
3 Push switch	7421000089
4 Water pump For DIX CM 141.M	7421000021
Water pump For DIX CM 592.M	7421000020



► Liquid capacity of the cooling modules 5 litres.

Power sources TIG, MMA

DIX GO 1206(1306).M and DIX GO 1106(1206).M C

For manual welding applications



2

Application

- Manual power sources with the latest inverter technology
- 1 phase power source
- MMA welding the easy way
- HF power inverter with IGBT of the latest generation
- With security protection (Voltage reduction device) Only DIX GO 1206.M C
- With an anti-stick function, it prevents the stick electrode from sticking and burning out
- Automatic starting aid
- Small, light weight of approx. 4.2 - 6.5 kg

Properties

- Selection of three welding processes
- TIG welding with „Lift“ ARC ignition and thermal control (TCS)
- Manual Metal ARC-prozess (MMA) with stick electrodes suitable for welding cellulose electrodes
- Including program for chrome-nickel electrodes

Options according to range of application



Power source DIX GO 1206.M
Application sample

Options according to range of application



Power source DIX GO 1206.M C
Application sample

TIG MMA Manual

Technical data (IEC 60974-1, -10):				
Power sources	DIX GO 1106.M C	DIX GO 1206.M	DIX GO 1206.M C	DIX GO 1306.M
Mains voltage - 1 ph 50/60 Hz	220 - 240V	220 - 240V	220 - 240V	220 - 240V
Power input @ I ₂ MAX	7.9 kVA	7.6 kVA	11.3 kVA	11.3 kVA
Mains fuse (delay I ₂ @ 100%)	16	16	20	20
Power connection cable Length / cross-section	3 m / 2.5 mm ²	2.2 m / 2.5 mm ²	2.5 m / 2.5 mm ²	2.5 m / 2.5 mm ²
Power factor / cosφ	0.66 / 0.99	0.66 / 0.99	0.55 / 0.99	0.59 / 0.99
Efficiency degree	0.86	0.85	0.86	0.85
Secondary no-load voltage	103	88	105	88
Secondary no-load voltage with VRD (not function)	-	-	≤ 12	-
VRD - Engagement time at the end of welding	-	-	≤ 0.3	-
Welding current control range	5-150A	5-150A	5-180A	5-180A
Welding current @100% duty cycle (40 °C)	90A	100A	100A	110A
Welding current @ 60% duty cycle (40 °C)	110A	120A	120A	130A
Welding current I ₂ @ 20% duty cycle (40 °C)	150A	150A	180A	180A
Electrodes - ø	1.6mm - 4.0 mm	1.6mm - 4.0 mm	1.6mm - 4.0 mm	1.6mm - 4.0 mm
Protection class	IP 23 S	IP 23 S	IP 23 S	IP 23 S
Insulation class	F	F	F	F
Dimension (L/W/H) mm	340 / 260 / 115	340 / 260 / 115	390 / 300 / 135	390 / 300 / 135
Weight approx.	4.2 kg	4.2 kg	6.5 kg	6.5 kg



Power sources TIG, MMA DIX GO 1206(1306).M and DIX GO 1106(1206).M C For manual welding applications

Power sources system components

2

TIG MMA Manual



Application sample

Description	Dimension	Part name	Part number
1 Power source		DIX GO 1206.M	7420010000
2 Power source Version „C“ for welding cellulose electrodes		DIX GO 1106.M C	7420010002
3 Power source		DIX GO 1306.M	7420010001
4 Power source Version „C“ for welding cellulose electrodes		DIX GO 1206.M C	7420010003
Accessories			
5 Torch set for TIG welding	4.00 m	DIX TM 9V-4	7422000014
Torch set for TIG welding, not shown	8.00 m	DIX TM 9V-8	7422000015
Torch set for TIG welding, not shown	4.00 m	DIX TM 17V-4	7422000000
Torch set for TIG welding, not shown	8.00 m	DIX TM 17V-8	7422000001
6 Electrode cable For manual power sources: DIX GO 1206.M / 1106.M C	16 mm ² / 4.00 m	DIX EL.M 16-4	7420080000
Electrode cable For manual power sources: DIX GO 1306.M / 1206.M C	25 mm ² / 4.00 m	DIX EL.M 25-4	7420080001
7 Ground cable, not shown	16 mm ² / 4.00 m	DIX GL.M 16-4	7420070000
Ground cable, not shown	25 mm ² / 4.00 m	DIX GL.M 25-4	7420070001
8 Shoulder belt, not shown		DIX PI GO	7420900002



Power sources TIG, MMA DIX GO 1206.M and DIX GO 1106.M C For manual welding applications



Spare parts and wear parts



Application sample

Description	Part number
1 Rotary knob	7421000079
2 Main switch	7421000071

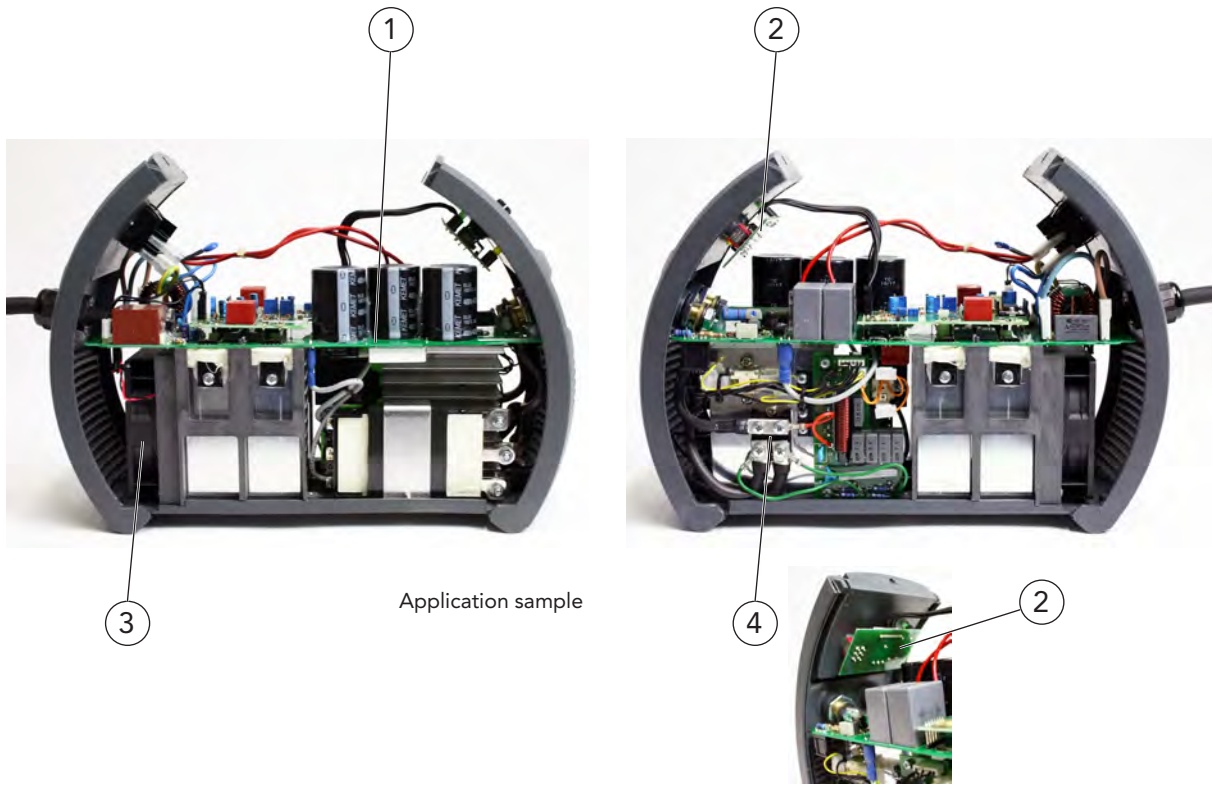


Power sources TIG, MMA DIX GO 1206.M and DIX GO 1106.M C For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Application sample

Description	Part number
1 Power inverter module for DIX GO 1206.M	7421000006
Power inverter module for DIX GO 1106.M C	7421000007
2 Front board for DIX GO 1206.M	7421000024
Front board for DIX GO 1106.M C	7421000023
3 Fan	7421000084
4 Secondary rectifier module	7421000014



Power sources TIG, MMA DIX GO 1306.M and DIX GO 1206.M C For manual welding applications



Spare parts and wear parts



Application sample

2

TIG MMA Manual

Description	Part number
Rotary knob \varnothing 22 mm	7421000080
Switch knob	7421000077

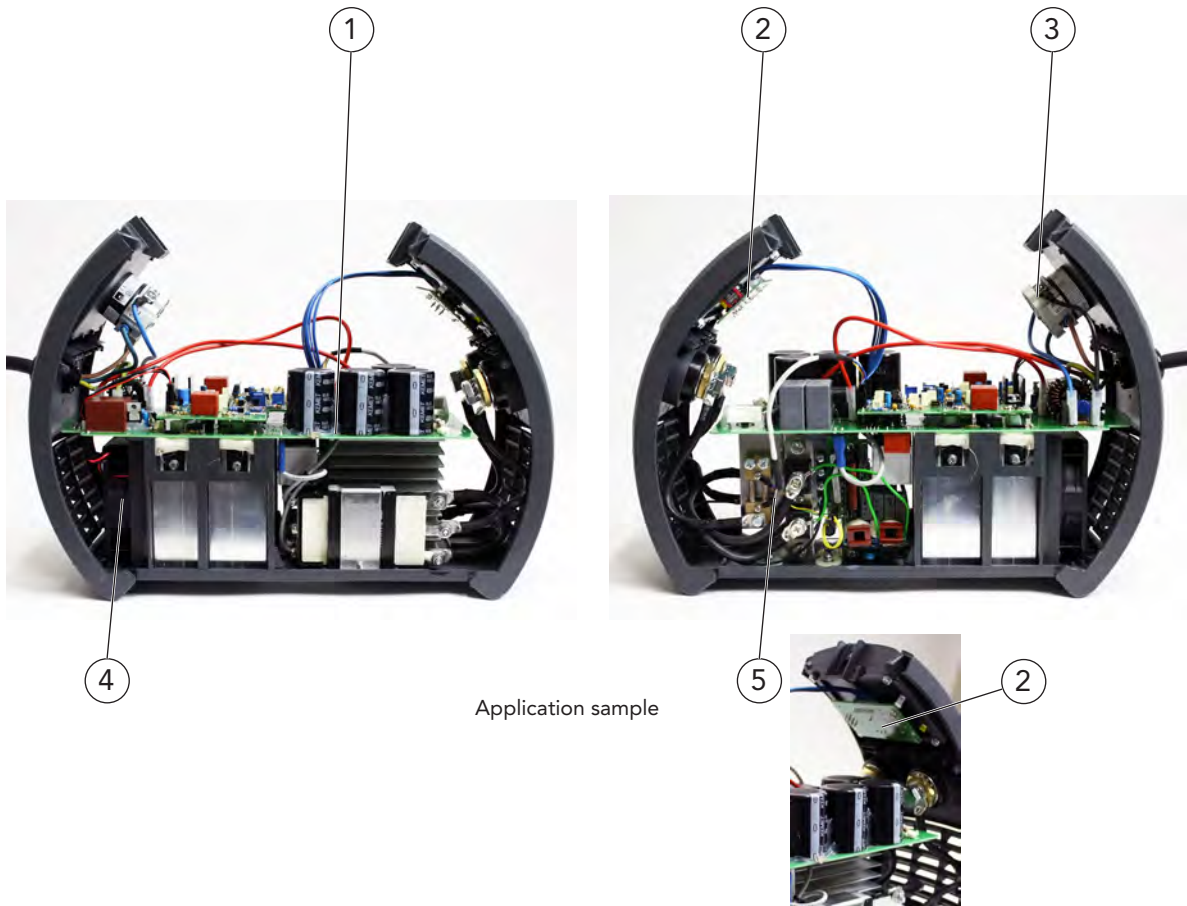


Power sources TIG, MMA DIX GO 1306.M and DIX GO 1206.M C For manual welding applications

Spare parts and wear parts

2

TIG MMA Manual



Application sample

Description	Part number
1 Power inverter module for DIX GO 1306.M	7421000008
Power inverter module for DIX GO 1206.M C	7421000009
2 Front board for DIX GO 1306.M	7421000025
Front board for DIX GO 1206.M C	7421000026
3 Main switch	7421000072
4 Fan	7421000085
5 Secondary rectifier module for DIX GO 1306.M	7421000015
Secondary rectifier module for DIX GO 1206.M C	7421000016
6 Inverter board, not shown For DIX GO 1306.M	7421000027



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