



# XTM 221Di

## 5 in 1 MULTI-PROCESS INVERTER

The XTM 221Di MIG Inverter is ideal for the welding of Steels, Stainless Steels and Aluminium using the MIG, AC TIG, DC TIG and MMA processes, and cutting and gouging using the Plasma process. The machine uses auto polarity switching so there is no need to change the work lead connections on the front of the machine. Instant swapping between the MIG, TIG & PLASMA processes with one touch of the torch trigger makes it well suited to multi process workshops. The multi-language digital user interface rapidly gets you to the correct machine setting with minimal process knowledge, on site or in the workshop.

### KEY FEATURES

- ▶ Large high quality colour screen with multi-language easy to follow digital interface
- ▶ View and adjust machine parameters from the MIG torch handle (*\*OLED torch optional extra*)
- ▶ HF Start TIG
- ▶ Instant swapping between MIG, TIG and Plasma process with one touch of the torch trigger
- ▶ Rapid synergic setup for MIG, TIG, MMA, PLASMA
- ▶ MIG Weld, down to 0.9mm thick material
- ▶ Memory function for all processes to save and recall welding programs
- ▶ Supplied with MMA lead set, input cable and 3 gas hoses
- ▶ Pulse TIG function for superior arc control
- ▶ Dual voltage 110 / 230V
- ▶ Welding Capacity 6mm (230V input)

### TECHNICAL INFORMATION

Parameter	Value		
Machine Style / Type	Portable MIG/TIG/MMA/PLASMA		
Output Current Max (A)	MIG	140 (110V)	200 (230V)
	TIG	140 (110V)	200 (230V)
	MMA	110 (110V)	200 (230V)
	PLASMA	25 (110V)	40 (230V)
Spool Size	300mm (15kg) 200mm (5kg)		
Feed Box	4 Roll		
Wire Size	0.6-1.0mm		
Duty Cycle (MIG)	200A @ 30%		
Input Voltage	110V / 230V (Smart Switching)		
Input Current DC (Eff)	MIG - 19.4A @ 110V / 14.4A @ 230V TIG - 17.7A @ 110V / 12.5A @ 230V MMA - 21.8A @ 110V / 16.2A @ 230V PLASMA - 21.9A @ 110V / 16.0A @ 230V		
Minimum Fuse Rating	32A @ 110V / 16A @ 230V		
KVA	3.7		
Generator Size	7 KVA		
Enclosure Protection	IP23S		
Dimensions (LxWxH mm)	650 x 275 x 495		
Weight (kg)	30		



**TR007**  
Twin Bottle Trolley with Drawer

# XTM 221Di

ACCESSORIES	
Part Number	Description
XTM221DI	Machine with MMA leads and 3 gas hoses
XTM221DI-P1	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button control type, gas regulator
XTM221DI-P2	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button, PRO TIG 4M torch with 3 button control, gas regulator
XTM221DI-P1T	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button, Twin bottle trolley with drawer
XTM221DI-P2T	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button, PRO TIG 4M torch with 3 button control, Twin bottle trolley with drawer and gas regulator.
XTM221DI-P3	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button, PRO TIG 4M torch with 3 button control, PLASMA 60A cutting torch, gas regulator
XTM221DI-P3T	Machine with MMA leads and 3 gas hoses, 3M 250A MIG torch 4 Button, PRO TIG 4M torch with 3 button control, PLASMA 60A cutting torch, Twin bottle trolley with drawer and gas regulator.
TR007	Twin bottle trolley with drawer
XTI902D	Foot control
IV26-12S3BD18	PRO TIG torch with 3 button control 4m
PRO2500-30ER4	PRO MIG torch with 4 button control
PRO2500-30ER4D	PRO MIG torch with OLED display
XTP40-6-CC	PLASMA 60A Cutting torch 6M
<i>Note: Machine supplied with 0.8/1.0 V Roller as standard</i>	

WELDING CAPACITY			
Process	Material	Size	Material Range
MIG	Steel	Wire 0.6/0.8/0.9/1.0	0.6-6.0mm (10mm)*
	Stainless Steel	Wire 0.8/1.0	0.8-9.0mm
	Aluminium	Wire 0.9/1.0	1.0-5.0mm
	Steel Flux core Gas assist	Wire 1.0-1.2	1.0-6.0mm (8mm)*
TIG	Steel (DC)	-	0.8-6.0mm (10mm)*
	Stainless Steel (DC)	-	0.8-6.0mm (12mm)*
	Aluminium (AC)	-	0.6-6.0mm (8mm)*
MMA	E60XX electrode	2.5/3.2/4.0	1.5-7.0mm
	E70XX electrode	2.5/3.2/4.0	1.5-7.0mm
<i>Note:</i>			
1) Recommended material range is 0.6 to 6mm for best performance.			
2) *Absolute maximum for short periods.			
3) Capacity is reduced when operating on 110V input			

DUTY CYCLES				
Process	110V Input		230V Input	
MIG	100A@60%	140A@30%	140A@60%	200A@30%
TIG (AC)	100A@60%	140A@30%	140A@60%	200A@30%
MMA	110A@50%	100A@60%	140A@60%	200A@30%
PLASMA	25A@20%		28A@60%	40A@30%