

# Unistep 3500XP/4500XP

## **Welding process**

- MIG/MAG short spray manual arc welding
- MIG/MAG short spray synergic arc welding

## **Materials**

- Carbon steels
- Aluminized and galvanized steels
- Stainless steels
- Aluminum and aluminum alloys

## **Applications**






- Light job shop fabrication
- Medium-heavy job shop fabrication
- Heavy job shop fabrication
- Building sites
- Plants machinery construction
- Railway industry
- Machine and apparatus construction
- Automobile industry
- Repair and overhaul
- Workshops

## **Technical features**

- Extremely rugged, reliable and easy-to-use systems
- High power at 100% of duty cycle

- Heavy duty and environmental conditions, high service life
- High temperature, shockproof, abrasion resistant plastic case
- Excellent performances also with long power supply extension cables
- 230V power supply socket for preheater
- Wire feeder unit (2/4 rolls drive)
- Full parameters control panel on wire feeder unit
- Fully Selco designed wire drive unit
- Ø 200/300 mm wire spool compatible
- Full digital and user-friendly control panel
- Welding parameters digital display
- Last job settings auto-storage at switch-off
- Multiple output choke selection
- 2/4 step operating mode
- Perfect arc ignition (soft start - motor slope)
- Burn-back and droplet detachment correction
- Synergic operations from databank (12 pre-set programs)
- Spot welding mode
- Intermittent welding mode
- Euro adaptor - MIG/MAG torch compatible
- Selco WU cooling unit compatible

**Power source**


			<b>P</b>	<b>X%</b>				<b>I<sub>2</sub></b>	<b>U<sub>0</sub></b>	<b>IP</b>	 mm l x w x h	 Kg
	<b>Unistep 3500XP</b>	3x400V	20A	16,6kVA 15,0kW	40°C	35%	350A	3x10	30- 380A	50V	21S	1060x400x780mm
40°C					60%	300A						
40°C					100%	240A						
25°C					40%	350A						
25°C					60%	320A						
25°C					100%	260A						
40°C					35%	350A						
40°C	60%	300A										
40°C	100%	240A										
25°C	40%	350A										
25°C	60%	320A										
25°C	100%	260A										
<b>Unistep 4500XP</b>	3x400V	30A	24,0kVA 22,9kW	40°C	40%	450A	3x10	30- 480A	50V	21S	1060x400x780mm	139,0kg
				40°C	60%	370A						

			40°C	100%	300A							
			25°C	45%	450A							
			25°C	60%	390A							
			25°C	100%	320A							
			<b>P</b>	<b>X%</b>			<b>I<sub>2</sub></b>	<b>U<sub>0</sub></b>	<b>IP</b>	<b>mm</b> l x w x h		
3x230V	50A	24,0kVA 22,9kW	40°C	40%	450A	3x10	30- 480A	50V	21S	1060x400x780mm	139,0kg	
			40°C	60%	370A							
			40°C	100%	300A							
			25°C	45%	450A							
			25°C	60%	390A							
			25°C	100%	320A							

### Wire feeder unit

	<b>P</b>	$\phi$ (rev/min)			$\phi$	$\emptyset$ mm	$\phi$			<b>IP</b>	<b>mm</b> l x w x h	
<b>WF 115XP (Unistep 3500/4500) SL 4R-1T (v.2R)</b>	90W	1,5- 22,0m/min		200/300mm	2 ● 4 ○	1,0/1,2mm ● 0,6-1,6mm ○ A 0,8- 1,6mm ○ Z 1,2-2,4mm ○	● ●			○ 23S	600x220x440mm	17,5kg






● = Included ○ = Optional A = Aluminum Z = Cored

### Cooling units

WU 22			<b>P</b>		<b>IP</b>	<b>mm</b> l x w x h	
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	WU 22	1x230V	1,0kW	4,0l	23S	250x150x700mm	16,0kg
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**Cooling units**

			<b>P</b>		<b>IP</b>	 mm <small>l x w x h</small>	 Kg
WU 22	WU 22	1x230V	1,0kW	4,0l	23S	250x150x700mm	16,0kg