

NEW PRODUCT RANGE



Kronos series

KRONOS

dual-pulse

The new generation

YOUR BRAND. YOUR WELDING

Kronos series



KRONOS 500

KRONOS 400

KRONOS 320

KRONOS 300 (compact version)

FIMER
YOUR BRAND, YOUR WELDING



MIG-MAG
INVERTER



TIG
INVERTER



MMA
INVERTER

Kronos series

...MORE THAN WELDING

KRONOS ISN'T ONLY A WELDING GENERATOR BUT A POWERFUL TOOL AT YOUR SERVICE ... ALWAYS



SPECIALIZED WELDERS

Syn, Special programs, Display, HSF, DSF



MANAGEMENT CONTROL

IWS – IWT - IWE

WPS, WDR, WCR, Locking



SERVICE / MAINTENANCE

Kronos series

Multiprocess Synergic Inverter Welding generator

- ***Processes***

MIG/MAG
MIG/MAG Pulse
MIG/MAG Brazing
TIG LIFT DC
MMA
FLUXE CORED
GOUGING

- ***Special processes***

HSF - DSF

- ***Materials***

Non-alloy steel
Low alloy steels
Alloy steels
Stainless steel
Galvanized steel
Aluminum and its alloys
Copper and its alloys
Inconel (Optional)
Stellite (Optional)
Duplex (Optional)

Kronos series

Applications

- ***Medium-heavy Carpentry***
- ***Maintenance***
- ***Repair***
- ***Industrial automation***
- ***Plant construction***
- ***Machinery construction***
- ***Boiler***
- ***Oil and Gas***
- ***Automotive***



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Reliability and best performance



- ***SD CARD data entry has been improved. Thanks to the improved speed on digital communication now 500 Kbps CAN BUS the machine is ready to weld after few seconds***
- ***99 programs can be saved***
- ***Welding Arch's high dynamism thanks to the 40 KHz new inverter's performance***
- ***Polarity changeover***
- ***Improved length for extension lead cables now up to 30 mt length and 12 mt elevation***
- ***Under/over voltage protection +/- 20%***
- ***More constant and controlled arch***
- ***More powerful with improved duty cycle***

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USER FRIENDLY



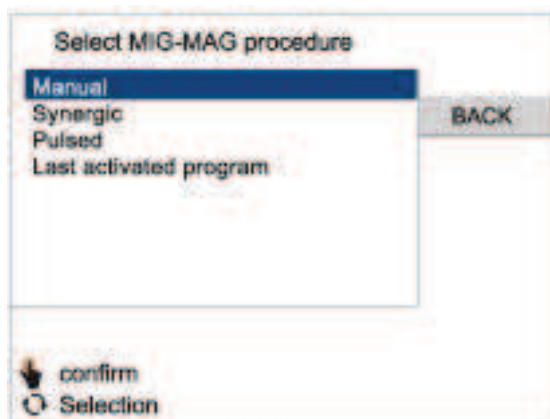
- **KRONOS** user interface is really intuitive, also the less experienced welder can select and set easily and fast welding parameters in order to achieve an optimal result.
- The **TFT display 5,7"** offers a clear visualization allowing the immediate identification of each welding parameter and each function.
- The **ONE WAY** navigation system is revolutionary; it drastically reduces setting errors and it guides the welder during machine's setting up to the final step to get the machine ready to weld.



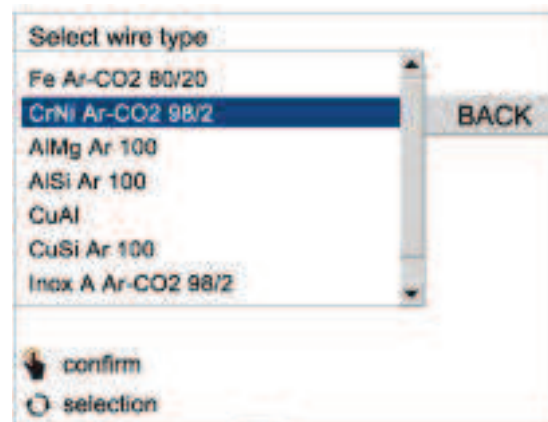
Kronos series



1

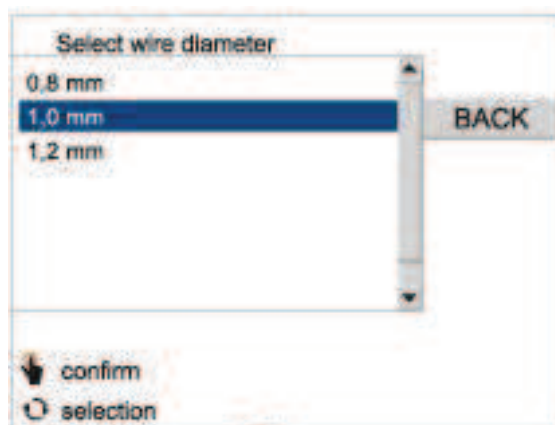


2



ONLY 4 STEPS to ROCK'N ROLL !!!

3



4



Kronos series

USER FRIENDLY

High visibility

- Clear visualization of welding parameters *and functions*
- *Great visualization even through the welding mask*
- Glare-free surface

Everything at a glance

- *Real time values and temporary visualization of average parameters (flashing)*
- *Working mode*
- *Signals*

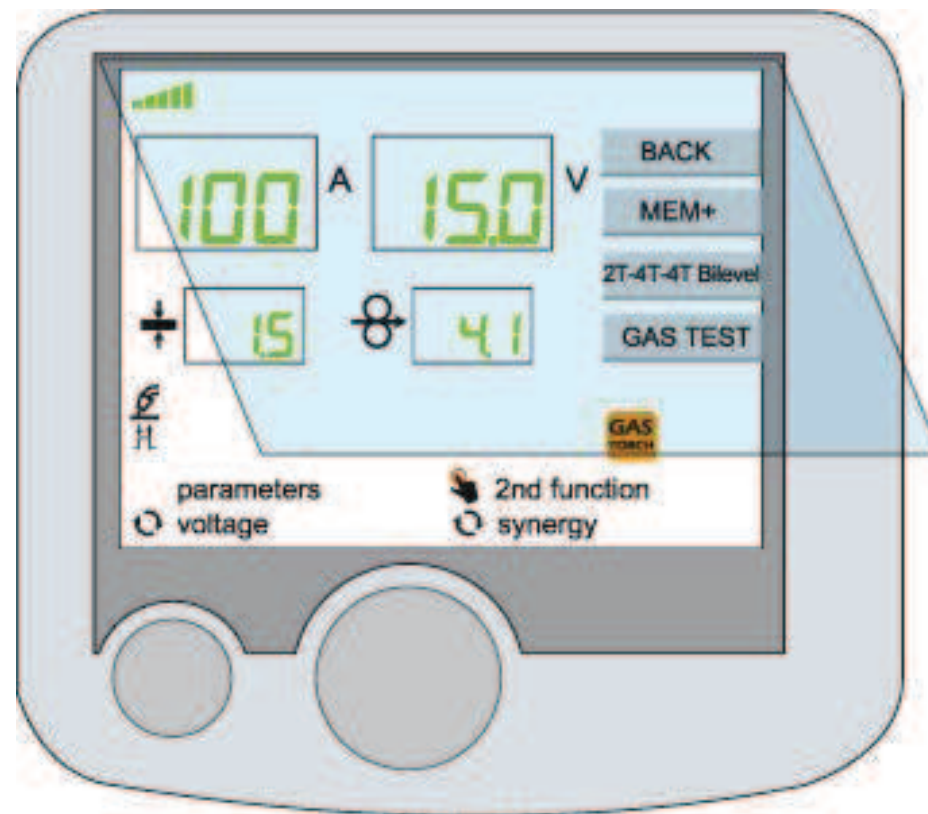


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USER FRIENDLY

LCD Display

- Thanks to the special protection LCD display is preserved over time
- LCD display is always readable over the time because there is no direct touch as in touchscreen



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USER FRIENDLY



Keep you updated

Easy data exchange through the SD CARD

Simplified setting

- *Easy and intuitive use
browse, select and change with
only two knobs*



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New colors LCD 5.7"

● Ready to weld		
44A 14,4v > 2,9m/' 0,4mm		START BACK MEM+ PURGE
voltage deposit inductance DSF L1 span	0,0V 0,0m/' 0 OFF 0,3s	MIG-MAG S.A.S. Fe 80/20 0,8 mm

➡ **OLD**

WDR-00.1

100 A 15.0 V

15 4.1

parameters voltage 2nd function synergy

BACK MEM+ 2T-4T-4T Bilevel GAS TEST

GAS TORCH

➡ **NEW**

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Create your project and start welding

*Kronos will take care of
everything*



WDR



WCR (Statistics)



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Fimer provides to the customer with a system designed to control the following parameters:

- ☐ *Project name*
- ☐ *Program*
- ☐ *Current*
- ☐ *Arc voltage*
- ☐ *Wire speed*
- ☐ *Arc «on» time*
- ☐ *Wire deposit/consumption*
- ☐ *Gas consumption*



This allows to create a documentation in compliance with WPS and to be always up-to-date about each welding process and therefore about job's detailed costs.

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● WDR 00.1



WDR-00 - Microsoft Excel

record	project	program	current (A)	voltage (V)	wire speed (m/min)	arc on (s)	wire (m)	gas (l)						
1	"PROJECT"	"MIG-MAG\S.A.S.\CrNi 98/2\1,6mm"	298	23,4	6,7	4,3	0,474	1,1						
2	"PROJECT"	"MIG-MAG\S.A.S.\CrNi 98/2\1,6mm"	303	23,5	6,8	7,9	0,879	2						
3	"PROJECT"	"MIG-MAG\S.A.S.\CrNi 98/2\1,6mm"	315	25,1	7,5	8,5	1,041	2,1						
4	"PROJECT"	"MIG-MAG\S.A.S.\CrNi 98/2\1,6mm"	327	25,6	8	8,1	1,065	2,1						

Welding data recorded on the SD CARD are clearly displayed as EXCEL format and can be easily recognized by different filter and research options. It is also possible to join the data recorded on the SD CARD to the welder and to the used welding power source.

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WPS



EN 1090 is a European regulation governing the manufacture of steel and aluminum products for the construction of civil engineering works.

For all products of Execution Class 1 and 2 EXC1 and EXC2 FIMER will offer a package of standard WPS according to EN/ISO 15612 which will help companies to improve their CE certification for welded products simplifying the procedure.

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FUNCTIONS

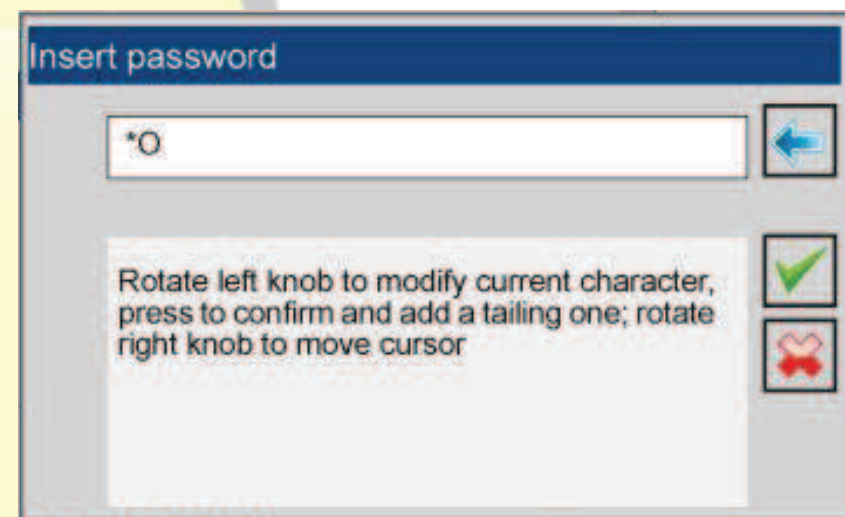


Blocking welding parameters

It's possible to customize each machine. Each welder will work with specific parameters related to the current applications. It means that the program with its main and secondary parameters could never be changed by the welder. Only the person who knows the password could correct the job and corresponding welding parameters.

Has the welder to comply with set WPS parameters?

It will be enough to set the welding parameters and to block them entering an easy Password.



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FUNCTIONS



Check list of digital and analog signals

Is there something wrong with the machine? We check immediately

This application allows to check on real time machine's analog/digital input status. Therefore machine's working conditions can be checked and it can also be possible to take prompt reaction in case of malfunctions.

I/O Signal		
d-IN 1	d-IN 2	d-IN 3 a-IN
☐ UV	☐ OV	☐ OV-AC
☐ Vaux+	☐ Vaux-	☐ I1cc
☐ I2cc	☐ ATMprt	☐ ABIL
☐ I1bit	☐ I2bit	☐ ATMbit
☐ HF	☐ EvTig	☐ EvMig
☐ Fan-AC	☐ Fan-I	☐ CUTt
☐ POL	☐ ARC	☐ ATM0

Stato I/O		
d-IN 1	d-IN 2	d-IN 3 a-IN
440A	12.9V	1.0m/min
296mV	646mV	1.7V
26C I1	26C R1	27C MD
26C I2	26C R2	26C AC/PL
27C amb	0.0V ATM-I	0.0V ATM-V
546Vbus	3.1V	3.1V
0A arco	0A tf	1811mV rem

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Features

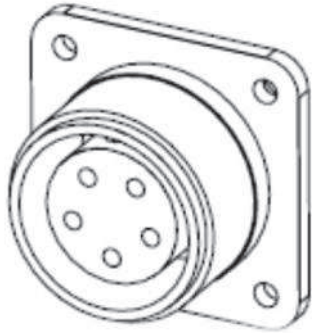


New system for extension lead cables fastening

- *Cables and pipes connections are totally safe inside the wire feeder*
- *It preserves cables and pipes integrity even if pulled from trolley or wire feeder*

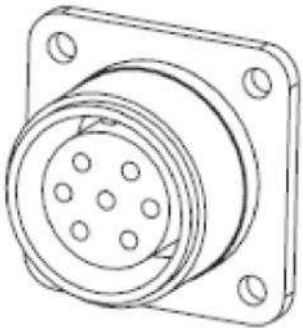
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Wirefeeder



5 PIN Connector:

- **MIG/MAG UP-DOWN Torch**
- **TIG UP-DOWN Torch**
- **BILEVEL Function**



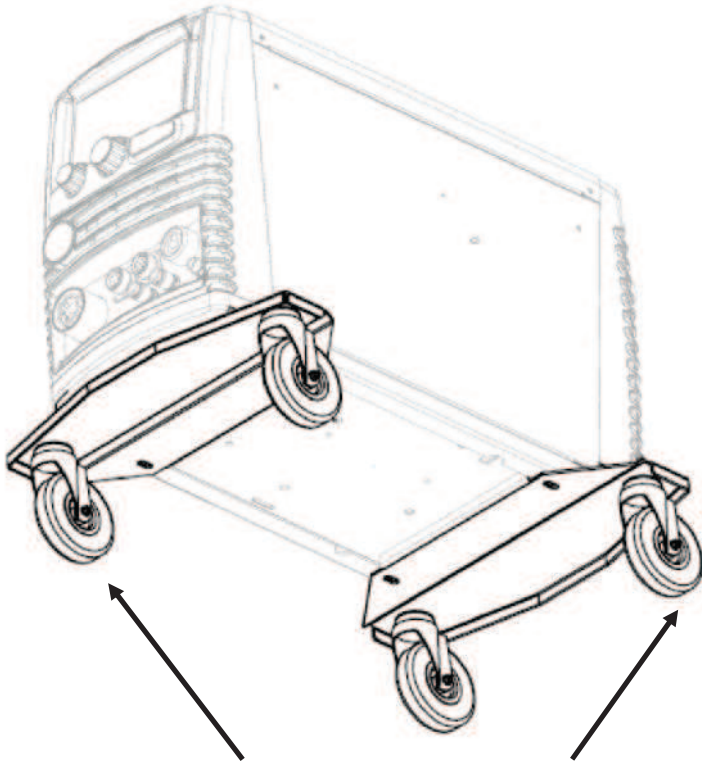
7 PIN Connector:

- **PUSH PULL Torch**
- **Remote control for welding current**
- **Foot control for TIG Welding**



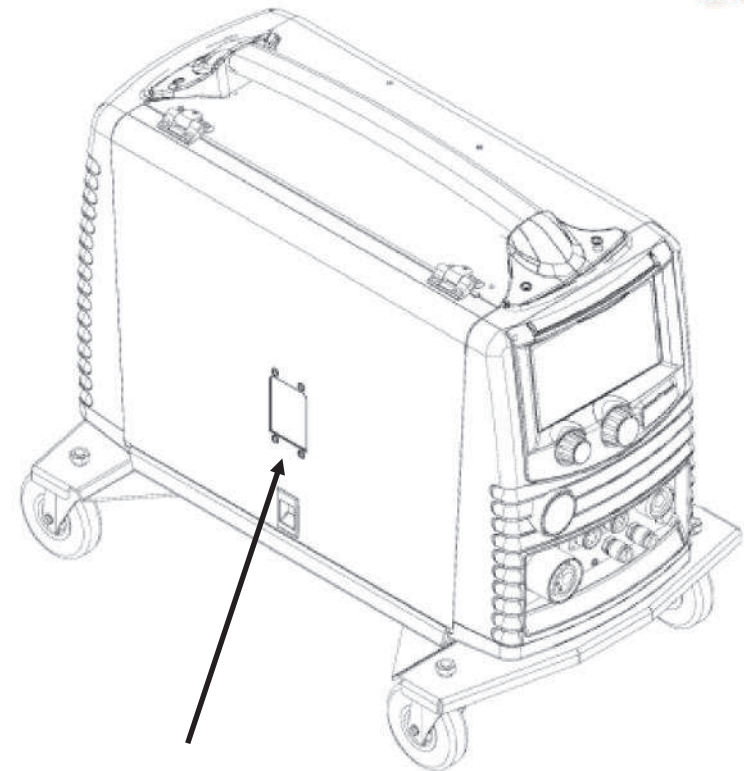
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Wirefeeder



Wheels kit diam. 100 mm for heavy duty environment

- *More stability*
- *More manoeuvrability*



Wire consumption is always under control

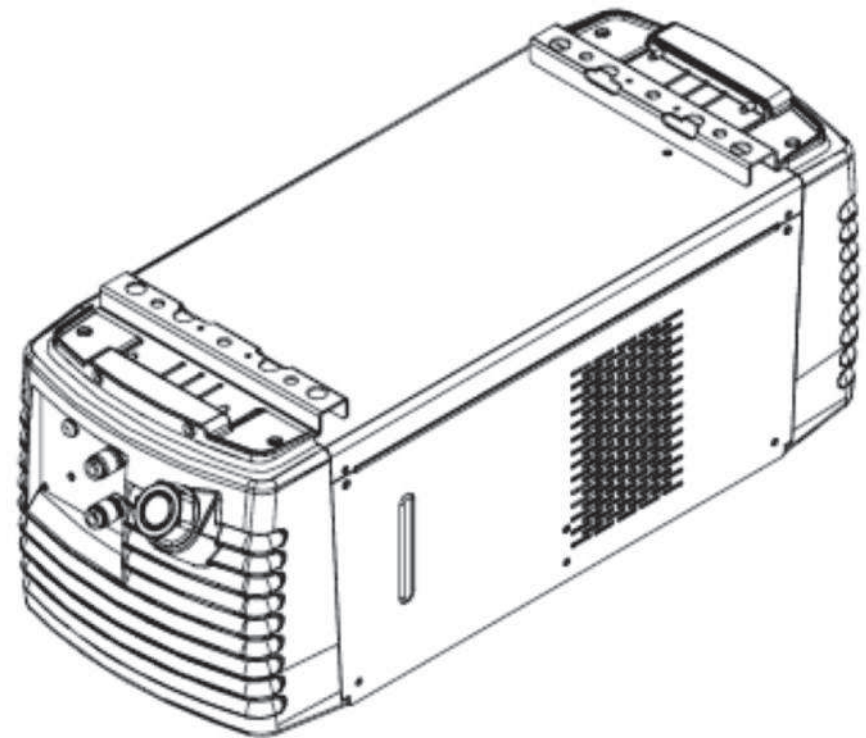
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New Cooling Unit

WCS 5



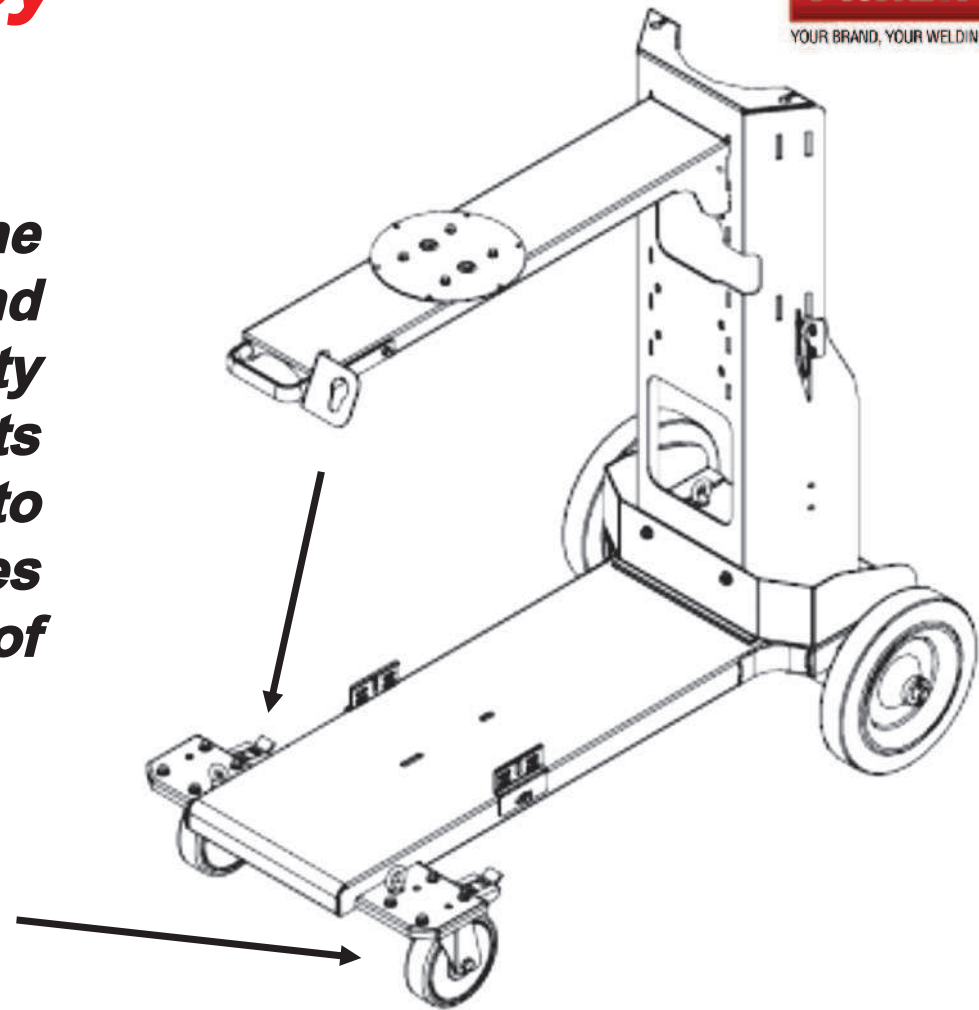
- ***Automatic detection*** machine detects automatically the connection to the water cooling unit and organizes cleverly its operation.
- ***Automatic test*** before working operations
- ***Safety is ensured thanks to the flowmeter***
- ***More cooling power : 1,2 kW***



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New Trolley C7K

Braking wheels, diam. 140 mm, give to the new trolley more manoeuvrability and stability in particular in heavy duty environments, where machine's movements would be difficult. It's possible not only to stop the machine but this trolley guarantees also higher safety to the welder in case of slight slope or heavy environment.



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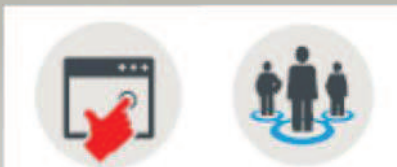


AVAILABLE SYNERGIC, STANDARD AND PULSED PROGRAMS

	Fe		CrNi	CrNiMo	AlMg
	(Ar-CO ₂ 82-18%)	(CO ₂ 100%)	(Ar-CO ₂ 98-2%)	(Ar-CO ₂ 98-2%)	(Ar 100%)
SYNERGIC PROGRAMS Wire / Filo	0.8 - 1.6	0.8 - 1.2	0.8 - 1.6	1.0 - 1.2	1.0 - 1.6
PULSED PROGRAMS Wire / Filo	0.8 - 1.2	-	0.8 - 1.2	1.0 - 1.2	1.0 - 1.2

	AlSi	CuSi	CuAl	Flux/Metal Cored Fe/CrNi
	(Ar 100%)	(Ar 100%)	(Ar 100%)	(Ar-CO ₂ - CO ₂)
SYNERGIC PROGRAMS Wire / Filo	1.0 - 1.6	0.8 - 1.0	1.0 - 1.2	1.0 - 1.2
PULSED PROGRAMS Wire / Filo	1.0 - 1.2	0.8 - 1.0	-	-

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SPECIAL PROGRAMS



Welding programs dedicated to special filler materials provide the ability to enter into sectors where experience and know-how are required. Thanks to the continuous development of generators' construction technology and special programs, FIMER can provide programs dedicated to highly specialized sectors which require the welding of compound alloys such as: INCONEL, DUPLEX, STELLITE...

To satisfy a more and more demanding and advanced market we have developed welding programs for special alloys which were implemented and developed in our laboratories and tested in the field. We're always able to research and develop the best solution for the customer.

**Chemical Industry
Petrochemical industry
Oil & gas industry**

Stellite Ø 1.6	Duplex Ø 1.2	Inconel Ø 1.2
(Ar 100%)	(Ar-CO ₂ 98-2%)	(Ar-CO ₂ 98-2%)



Kronos series



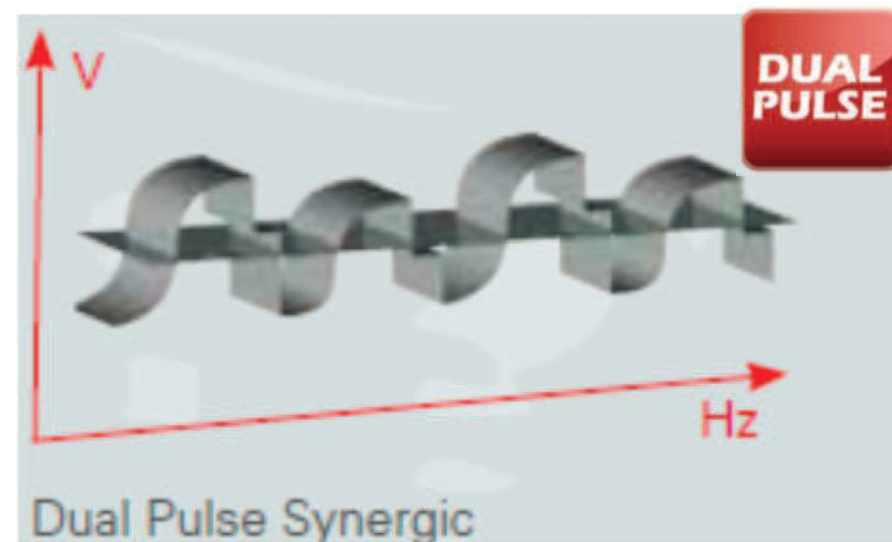
Dual Pulse



Transfer with double pulse is aimed to decrease the thermal input to the workpiece ensuring all advantages of pulsed arc, in particularly with light alloys and thin metal sheet, improving final aesthetics results as the seam looks like a TIG welding.

BENEFITS

- *Weaving is not necessary*
- *Complete control over the welding bath*
- *Reduced and controlled thermal input*
- *Welding of thin thickness keeping an excellent control of the arc and high precision*
- *Aesthetic results similar to TIG process*



Kronos series



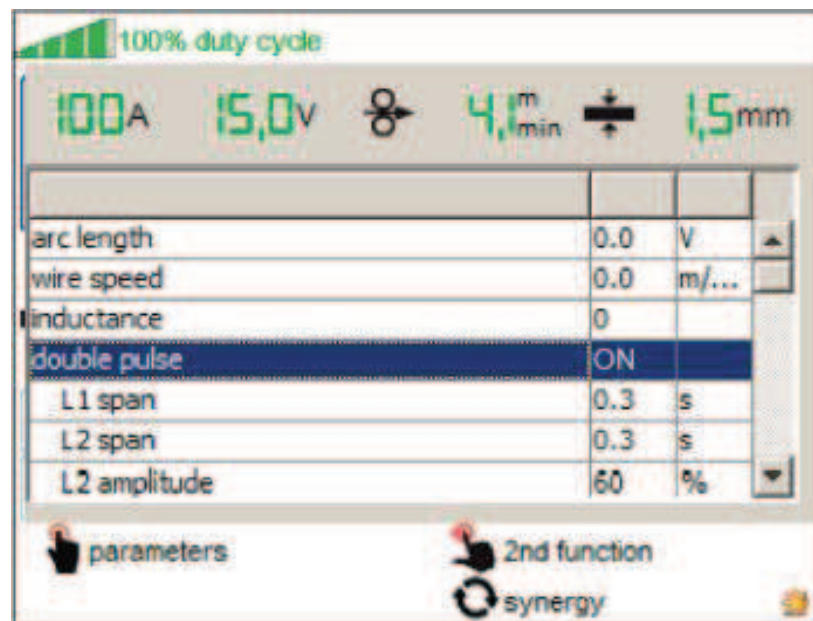
Dual Pulse has never been so fast!!!



Thanks to the optimization of welding programs and synergic curves it's now possible to reduce peak current times and base L1 / L2 up to 0,1 sec. keeping a stable and really controlled welding arc.

It's possible to get more precise works and optimal aesthetic results with thin metal sheets.

0,2 sec
EARLIER



0,1 sec
NOW

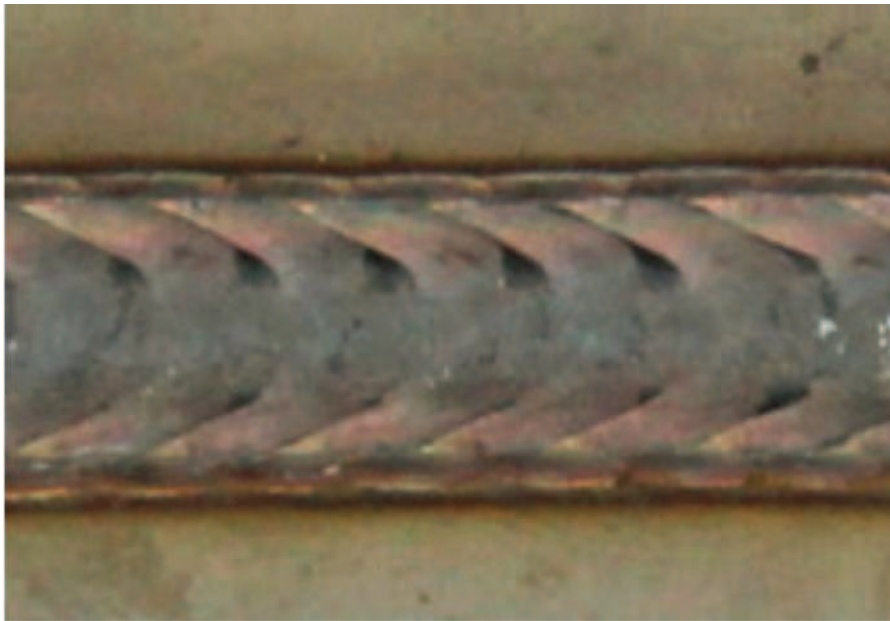
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Dual Pulse



CrNi 308 LSi



L1 0,3 sec
L2 0,3 sec

CrNi 308 LSi



L1 0,1 sec
L2 0,1 sec

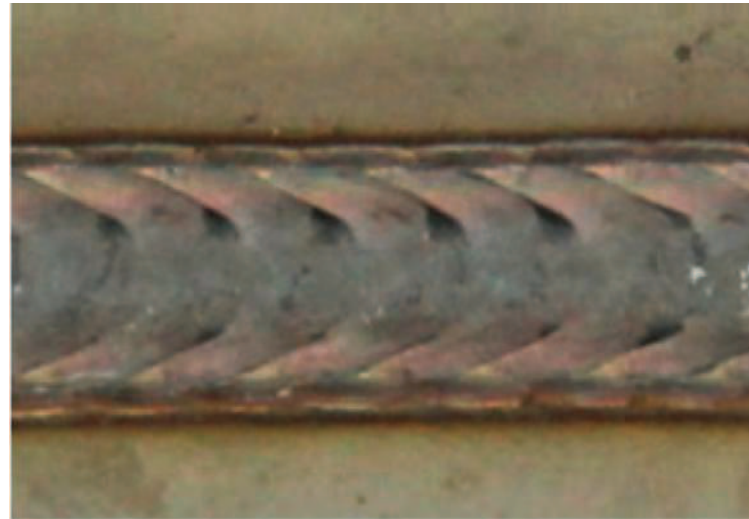
Kronos series



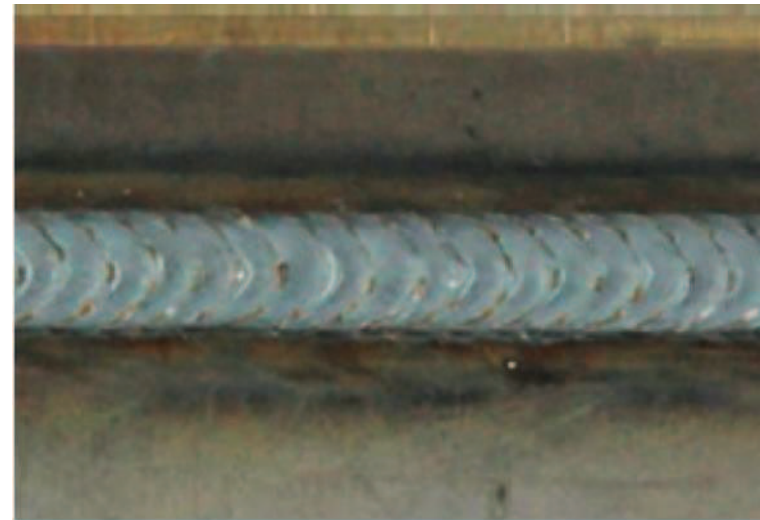
Stainless steel



AlMg 1.2



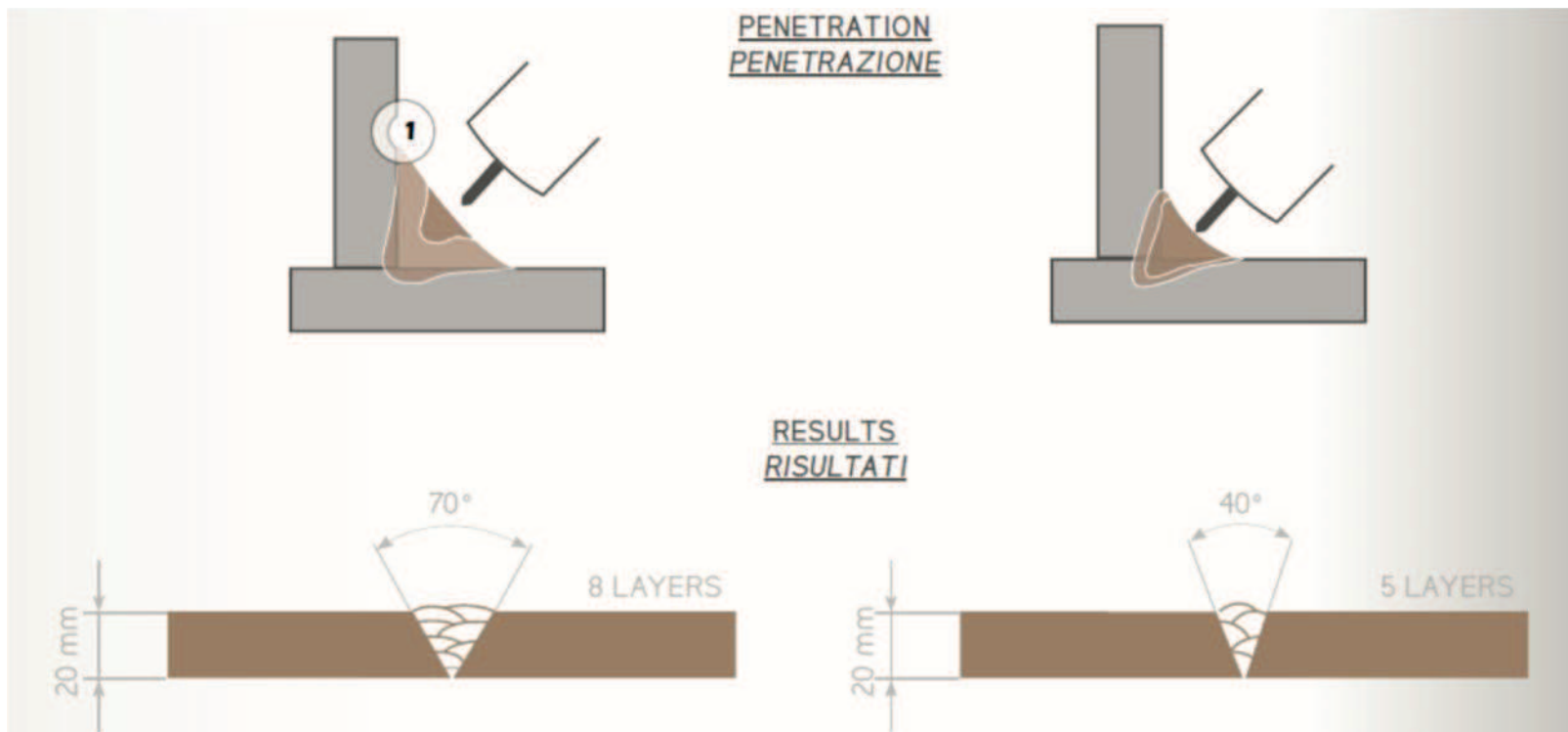
Fe



Kronos series



**I
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D**



MIG MAG SPRAY ARC STANDARD

1. *Complex groove preparation*
2. *Wide V-groove angle (70°)*
3. *High consumption of filler material and gas*

MIG MAG HSF FIMER

1. *V groove reduction*
2. *Reduction of layers numbers*
3. *Reduction of filler material and gas*
4. *Less groove's time preparation*

Kronos series



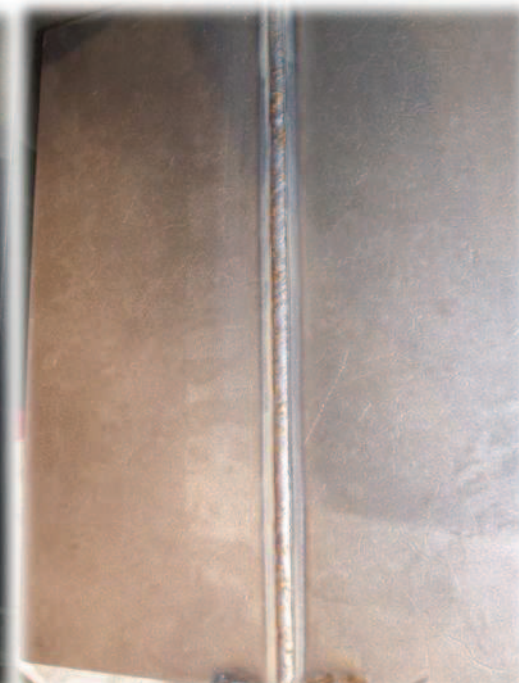
DSF
DUAL
SHORT
FIMER

**I
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DUAL SHORT FIMER PROCESS



FIMER
YOUR BRAND, YOUR WELDING



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AUTOMATION

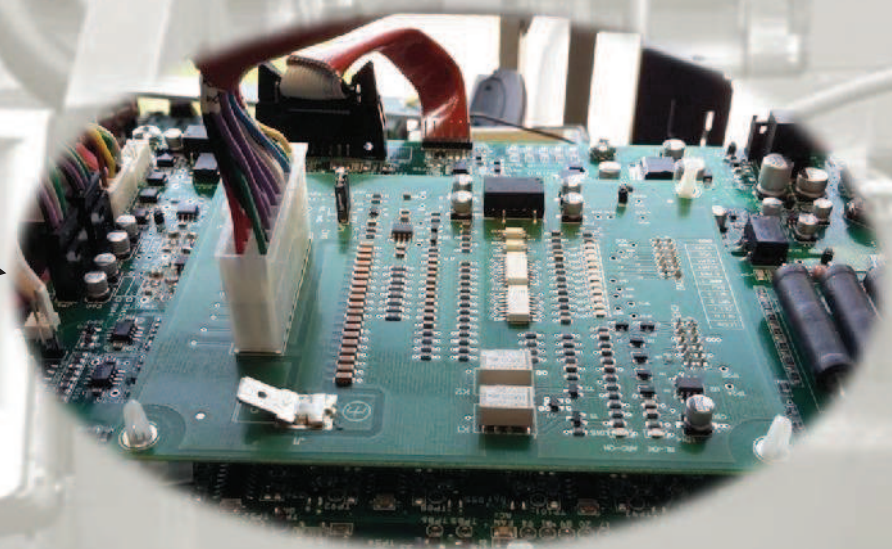


Analog/digital automation PCB is installed directly inside the power source on demand.

Quality and productivity have now become two requirements characteristic of a reality that involves a 360 degree view of many sectors. The compliance with such needs is inevitable by providing machines able to communicate with the world of automation. FIMER has created what is necessary to control and manage analog/digital signals and then to connect the welding generator to an automated robotic and/or mechanized system.

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AUTOMATION



Kronos series

		Kronos 500	Kronos 400	Kronos 320	Kronos 300
Supply voltage		3X400 V			
Output range		15A/14,75V a 500A/39V	15A/14,75V a 400A	15A/14,75V a 320	15A/14,75V a 300
Duty Cycle 40°C	40%	500A	400	320	300
	60%	440 A	360	300	260
	100%	410 A	340	260	240
Open circuit voltage		91 V		88 V	
Mains frequency		50-60 HZ			
Max. connected power		19,6 kVA	13,7 kVA	9,1 kVA	8,3 kVA
Recommended generator rating		31 kVA	21,6 kVA	14,4 kVA	13,1 kVA
Mains fuses (delayed action)		32 A	25 A	16 A	16 A
Protection classification		IP 21 S			
Insulation class		H			
Weight		82 Kg	82 Kg	75 Kg	29,5 Kg
Dimensions		580x1100x1510	580x1100x1510	580x1100x1510	270x720x630
wire	Ø mm	0,8 – 1,6	0,8 – 1,6	0,8 – 1,2	0,8 – 1,2

Kronos series

OPTIONAL ACCESSORIES

	Code		Descrizione	Description
	049.602.002		Cavo con morsetto di massa a vite 70 mm ² - dinse 70 mm ² - 4 m	Ground clamp with screw-fastening 70 mm ² - dinse 70 mm ² - 4 m
	049.602.001	○	Cavo con morsetto di massa a vite 95 mm ² - dinse 70/95 mm ² - 4 m	Ground clamp with screw-fastening 95 mm ² - dinse 70/95 mm ² - 4 m
	580.000.402	○	Riduttore a 2 manometri + riduzione CO ₂ /Argon	Reducer two gauges + reduction CO ₂ /Argon
	421.300.007	●	Kit staffe ruote Ø 100mm per wire feeder	Kit brackets wheel Ø 100mm for wire feeder
	580.690.008	●	Nuovo carrello C7s	Trolley new C7S
	421.100.005		Comando a distanza manuale - L= 5 m - connettore 7 pin	Manual remote control - L= 5 m - 7 pin connector
	421.101.003		Comando a distanza pedale - 5 m - Connettore 7 pin	Foot remote control - 5 m - 7 pin connector
	580.900.500	●	SD card serie LCD per MIG/TIG	SD card LCD serie for MIG/TIG
	580.900.550.xxxxx		Libreria WPS	WPS library
	580.690.100		Toolsbox	Toolsbox

Kronos series

AIR KIT

	Code		Descrizione	Description
	043.600.143	○	Torcia F36 - 4 m - 320A@60%	Torch F36 - 4 m - 320A@60%
	423.991.041		Fascio cavi 2,5 m D.70 mm ² - pressacavo - Aria	Extension lead cable 2,5 m D.70 mm ² - with cable gland - Air
	423.991.042		Fascio cavi 5,0 m D.70 mm ² - pressacavo - Aria	Extension lead cable 5,0 m D.70 mm ² - with cable gland - Air
	423.991.043		Fascio cavi 10 m D.70 mm ² - pressacavo - Aria	Extension lead cable 10 m D.70 mm ² - with cable gland - Air
	423.991.044		Fascio cavi 15 m D.70 mm ² - pressacavo - Aria	Extension lead cable 15 m D.70 mm ² - with cable gland - Air
	423.991.045		Fascio cavi 20 m D.70 mm ² - pressacavo - Aria	Extension lead cable 20 m D.70 mm ² - with cable gland - Air
	423.991.047		Fascio cavi 30 m D.70 mm ² - pressacavo - Aria	Extension lead cable 30 m D.70 mm ² - with cable gland - Air
	423.991.051	○	Fascio cavi 2,5 m D.95 mm ² - pressacavo - Aria	Extension lead cable 2,5 m D.95 mm ² - with cable gland - Air
	423.991.052		Fascio cavi 5,0 m D.95 mm ² - pressacavo - Aria	Extension lead cable 5,0 m D.95 mm ² - with cable gland - Air
	423.991.053		Fascio cavi 10 m D.95 mm ² - pressacavo - Aria	Extension lead cable 10 m D.95 mm ² - with cable gland - Air
	423.991.054		Fascio cavi 15 m D.95 mm ² - pressacavo - Aria	Extension lead cable 15 m D.95 mm ² - with cable gland - Air
	423.991.055		Fascio cavi 20 m D.95 mm ² - pressacavo - Aria	Extension lead cable 20 m D.95 mm ² - with cable gland - Air
	423.991.057		Fascio cavi 30 m D.95 mm ² - pressacavo - Aria	Extension lead cable 30 m D.95 mm ² - with cable gland - Air

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KIT H₂O

	Code		Descrizione	Description
	580.520.153	○	Centralina di raffreddamento	Water cooling unit
	043.600.144		Torcia F51 H ₂ O - 3 m - 430A@100%	Torch F51 H ₂ O - 3 m - 430A@100%
	043.600.145	○	Torcia F51 H ₂ O - 4 m - 430A@100%	Torch F51 H ₂ O - 4 m - 430A@100%
	043.600.156		Torcia Push-Pull per alluminio - Acqua - 8m - 350A@100%	Push-Pull torch for aluminium - Water - 8m - 350A@100%
	043.600.159		Torcia Up/Down - Water - 4m	Up/Down torch - H ₂ O - 4m
	423.991.141		Fascio cavi 2,5 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 2,5 m D.70 mm ² - with cable gland - H ₂ O
	423.991.142		Fascio cavi 5,0 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 5,0 m D.70 mm ² - with cable gland - H ₂ O
	423.991.143		Fascio cavi 10 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 10 m D.70 mm ² - with cable gland - H ₂ O
	423.991.144		Fascio cavi 15 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 15 m D.70 mm ² - with cable gland - H ₂ O
	423.991.145		Fascio cavi 20 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 20 m D.70 mm ² - with cable gland - H ₂ O
	423.991.147		Fascio cavi 30 m D.70 mm ² - pressacavo - H ₂ O	Extension lead cable 30 m D.70 mm ² - with cable gland - H ₂ O
	423.991.151	○	Fascio cavi 2,5 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 2,5 m D.95 mm ² - with cable gland - H ₂ O
	423.991.152		Fascio cavi 5,0 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 5,0 m D.95 mm ² - with cable gland - H ₂ O
	423.991.153		Fascio cavi 10 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 10 m D.95 mm ² - with cable gland - H ₂ O
	423.991.154		Fascio cavi 15 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 15 m D.95 mm ² - with cable gland - H ₂ O
	423.991.155		Fascio cavi 20 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 20 m D.95 mm ² - with cable gland - H ₂ O
	423.991.157		Fascio cavi 30 m D.95 mm ² - pressacavo - H ₂ O	Extension lead cable 30 m D.95 mm ² - with cable gland - H ₂ O

Kronos series

TIG – MMA – MIG/MAG ACCESSORIES

	Code		Descrizione	Description
	043.600.236		Torcia TT 26 - 4 m - dinse 50 mm ² - connettore 7 pin - 200A@60%dc - 150A@60%dc	Torch TT 26 - 4 m - dinse 50 mm ² - 7 pin connector - 200A@60%dc - 150A@60%dc
	043.600.239		Torcia TT 26 - 8 m - dinse 50 mm ² - connettore 7 pin - 200A@60%dc - 150A@60%dc	Torch TT 26 - 8 m - dinse 50 mm ² - 7 pin connector - 200A@60%dc - 150A@60%dc
ACCESSORI MMA - MMA ACCESSORIES				
	Code		Descrizione	Description
	489.603.423		Kit cavi completo 500A - 4 mt	Cables set complete 500 A - 4 mt
RULLINI - ROLLS				
	Code		Descrizione	Description
	422.510.002	●	Rullino 0,8-1,0 D.37 - V cava (acciaio, acciaio inossidabile)	Roll 0,8-1,0 D.37 - V groove (steel, stainless steel)
	422.510.003	●	Rullino 1,0-1,2 D.37 - V cava (acciaio, acciaio inossidabile)	Roll 1,0-1,2 D.37 - V groove (steel, stainless steel)
	422.510.004		Rullino 1,2-1,6 D.37 - V cava (acciaio, acciaio inossidabile)	Roll 1,2-1,6 D.37 - V groove (steel, stainless steel)
	422.510.051		Rullino 0,8-1,0 D.37 - U cava (alluminio)	Roll 0,8-1,0 D.37 - U groove (aluminium)
	422.510.052		Rullino 1,0-1,2 D.37 - U cava (alluminio)	Roll 1,0-1,2 D.37 - U groove (aluminium)
	422.510.053		Rullino 1,2-1,6 D.37 - U cava (alluminio)	Roll 1,2-1,6 D.37 - U groove (aluminium)
	422.510.101		Rullino 1,2-1,6 D.37 - Cava zigrinata (filo animato)	Roll 1,2-1,6 D.37 - knurled groove (flux cored)
	422.510.102		Rullino 2,4-2,8 D.37 - Cava zigrinata (filo animato)	Roll 2,4-2,8 D.37 - knurled groove (flux cored)
	422.510.103		Rullino 1,0-1,2 D.37 - Cava zigrinata (filo animato)	Roll 1,0-1,2 D.37 - knurled groove (flux cored)

Kronos series