

# CIGWELD

AN ESAB BRAND

AUTO SET WELDING INVERTER

# Transmig **185** ULTRA

PROFESSIONAL  
SERIES

**AUTO SET**  
TAKE THE GUESSWORK  
OUT OF WELDING -  
YOU SET THE PROCESS,  
THE **ULTRA** DOES  
THE REST!

**ULTRA**



# Our customers spoke – and we listened.

CIGWELD have been listening to market feedback about having versatile welding inverters suitable for Australian welders, making welding easier while increasing productivity.

Professional Fabricators asked for a multi-process portable inverter with VRD and a 3 year warranty that had exceptional arc performance and stability that they can easily manoeuvre around a workshop or job site.

TAFE Teachers asked for an inverter that was easy to setup and could help guide their students to achieve perfect weld results.

The DIY Weekend Warrior wanted a simple to navigate interface, an AUTO Setup option for MIG STICK and TIG, a 10amp plug and Spool Gun compatibility.

So CIGWELD delivered the Transmig 185 ULTRA – successfully combining the needs of both the professional and novice welder, but most importantly, regardless of skill level, simplifying welding.

It really is child's play! Just plug it in - and weld away!



**“ The preset parameters make welding setup easy, but we also loved having the flexibility to adjust them slightly to suit the individual needs of our welders. ”**

Optional SGT250 Spool Gun ideal for your precision aluminium fabrication, repairs and auto/marine work.

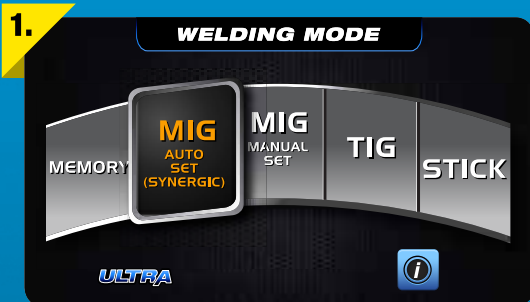


## Auto Set – MIG | TIG | STICK

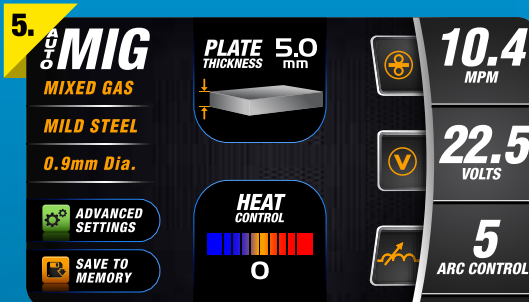
AutoSet takes the guess work out of welding.

Simply select the material type, thickness & consumable diameter and AUTO SET will pre-set the Wirefeed Speed (Amperage) and Voltage (MIG) along a pre-programmed synergic line. Experienced welders can further customise their settings by tweaking speed and heat according to technique and other factors, or for ultimate flexibility just use MANUAL MODE.

With excellent welding performance across a broad range of applications anyone can weld like a Pro! You set the process - MIG, TIG or STICK and the Ultra does the rest!



Choose **MIG AUTO SET (SYNERGIC)**



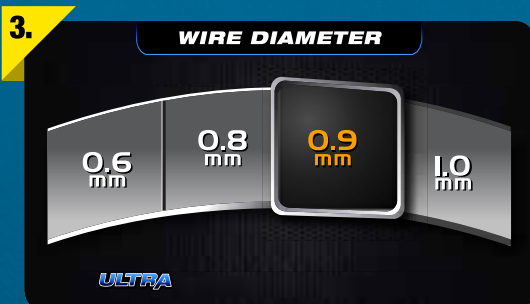
Summary Screen displays your **AUTO SET** parameters



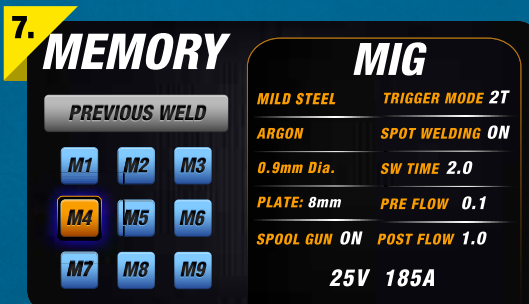
Choose your **MATERIAL** (in this case **MILD STEEL**)



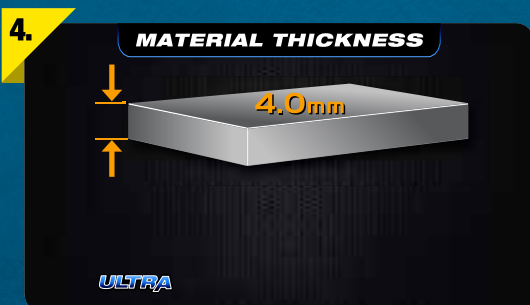
Get Welding!



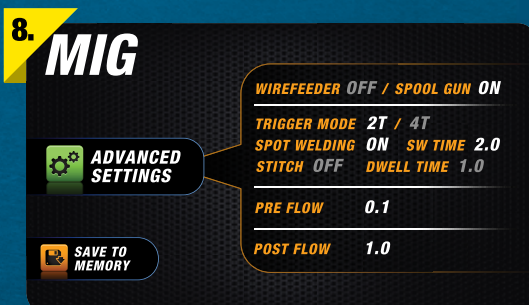
Choose **WIRE DIAMETER**



Memory Screen to save your favourite welds



Choose **MATERIAL THICKNESS**



Advanced Settings for professional welds

**“ We MIG welded with 0.8mm solid wire on 1mm to 12mm plate, and the weld performance was one of the best I have used. I also love the convenience of the 10amp plug ”**

#### **Australian Designed Interface**

A simple user-friendly interface that our Australian team have designed in house to suit the local needs of Australian and New Zealand welders. Synergically programmed for our plate thicknesses, consumables and gas types.



## Features



240V 10A

**PLUG & PLAY** - Suitable for use with any standard 10amp power point! 240 Volt, 50/60Hz, 10 Amp Supply Lead Fitted to Power Source

**3 IN 1**  
MIG STICK TIG

### 3 IN 1 Multi-Process

A true multi-process machine offering outstanding welding results across MIG, Stick and TIG

**AUTO SET**  
MIG STICK TIG

### Auto Set

Auto Set parameters for MIG, STICK and TIG. Determined by material type, thickness & consumable diameter



### MIG (Auto & Manual): 185A @ 20%

0.6mm to 1.0mm: Mild Steel Wires  
0.8mm to 1.2mm: Gasless Wires  
0.8mm to 1.0mm: Stainless Steel Wires  
0.9mm / 1.0mm: Aluminium Wires



### STICK (Auto & Manual): 185A @ 15%

Power Source is suitable for 2.0mm, 2.5mm, 3.2mm and 4.0mm electrode sizes



### TIG (Auto & Manual): 185A @ 20%

This unit features a Lift TIG function that provides smooth starting and running characteristics across a broad range of applications.

**185A**  
DC

### Output Current

Current range for this Power Source is 30 to 185A. Provides DC Output

**A+**

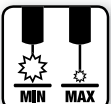
### Advanced Features

Includes 2T/4T, Spot/Stitch Weld, Pre/Post Flow, Hot Start, Anti-stick, Arc Force & Up/Down Slope

**4.3"**

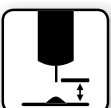
### 4.3" Colour LCD Screen

Allows for full interactive digital control over easy to navigate menus. Great colour / light contrast ideal for indoor and outdoor use.



### Arc Control

Variable inductance for softer arc and less spatter or stronger arc and increased penetration



### Adjustable Burnback Control

Adjusts stick-out and prevents wire from burning back



### Voltage Reduction Device

Standards compliant STICK mode only



### Integrated Wire Feed Unit

Spools up to 5kg or 200mm



### Euro Torch Connection



### Digital MIG Gun

Tweco Fusion DX250 Digital MIG gun allows remote operation of volts and wirefeed speed in the palm of your hand



### SGT250\* Spool Gun Compatible

\*Wirespeed adjustable on the Power Source only (no remote speed control)



### Generator

Recommended generator required: 10kVA at 0.8 Power Factor



### Over Temperature

This protection has been fitted to the Power Source



### Fully compliant to AS 60974.1-2006.

Enclosure rated to IP23S - Suitable for outdoor use



### 3 Year Limited Warranty\*

\*Refer to operating manual for further details



Suitable for Gas and Gasless Wires



### BONUS Heavy Duty Backpack\*

Purpose built heavy duty backpack for convenient transport of accessories

\*Included for a limited time only.

**“ The menu selection was simple to use and the crystal clear screen made everything easy to read. ”**

# Tweco DX250 Digital MIG Gun

To assist with increased productivity, and reduce the time spent walking back and forth to the machine, the 185 Ultra comes standard with the new Tweco Fusion DX250 digital mig gun.

We transformed the popular standard Tweco Fusion 250, with its comfortable ergonomic light weight handle, and added four tactile control buttons for optimal dexterity. The user can now conveniently adjust wirefeed speed and voltage in the palm of their hand.

More experienced welders now have the ability to actually tweak their heat (volts) and wire speed while welding ensuring perfect weld results and no need to stop and start.



**“ Having the digital control from the gun reduced our down time as there is no need to walk back and forth to the machine ”**

## Specifications

### SPECIFICATIONS

Power Source Dimensions	H520mm x W220mm x D420mm
Power Source Weight	17.4kg
Plant (Package) Weight	30kg
Cooling	Fan on Demand
Welder Type	3-in-1 Multi-Process Inverter with AUTOSSET Auto MIG / Manual MIG (Gas & Gasless) Auto TIG / Manual TIG Auto STICK / Manual Stick
Australian Standard	AS60974-1 / IEC60974-1
Number of Phases	Single Phase
Nominal Supply Voltage	240 VAC $\pm$ 15%
Nominal Supply Frequency 50 / 60Hz	50 / 60Hz
Factory Fitted Supply Plug Rating	10 Amps
Effective Input Current (I <sub>1eff</sub> ) [Refer Note 1]	9.5 Amps
Maximum Input Current (I <sub>1max</sub> )	30 Amps
Minimum Single Phase Generator	10 kVA (at 0.8 Power Factor)
Recommendation [Refer Note 3]	8 kW (at 1.0 Power Factor)
Output Terminal Type	Dinse™ Style 50
Protection Class	IP23S
Welding Environment Classification	Suitable for Welding in Category C Environments; Suitable for Indoor and Outdoor Welding
Welding Environment Classification	Suitable for Welding in Category C Environments; Suitable for Indoor and Outdoor Welding
Warranty	3 Years (Refer to operating manual for detail)

### MIG (GMAW / FCAW) WELDING, STICK (MMAW) & TIG (GTAW)

MIG Welding Current Range	30 – 185A
MIG Welding Voltage Range	15.5 – 23.3V DC
MIG Welding Output, 40°C, 10 min	185A @ 20%, 23.3V 116A @ 60%, 19.8V 90A @ 100%, 18.5V
Stick Welding Current Range	10 – 185A
Stick Welding Output, 40°C, 10 min.	185A @ 15%, 27.4V 95A @ 60%, 23.8V 80A @ 100%, 23.2V
Open Circuit Voltage (VRD On)	<26V DC
TIG Welding Current Range	10 – 185A
TIG Welding Output, 40°C, 10 min.	185A @ 20%, 17.4V 116A @ 60%, 14.6V 90A @ 100%, 13.6V

### ORDERING INFORMATION

Transmig 185 Ultra Plant	W1006185
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### OPTIONAL ACCESSORIES

Tweco Professional Fusion DX250 Digital MIG Torch, 3.0 metre EURO	W4018900
Tweco Professional Fusion 250 MIG Torch, 3.0 metre EURO	W4013701
Tweco Professional Fusion 250 MIG Torch, 3.6 metre EURO	OTWF212X3035
Tweco #2, 250A MIG torch, 3.6 metre EURO	OTWX212/3035
Tweco Mig Torch Consumables Organiser	W4012300
Tweco SGT 250 Spool Gun*	W4011250
Feed Roll 0.6/0.8mm V groove (hard)	7977036
Feed Roll 0.9/1.2mm V groove (hard)	7977660
Feed Roll 0.8/0.9mm U groove (soft)	7977731
Feed Roll 1.0/1.2mm U groove (soft)	7977264
Feed Roll 0.8/0.9mm V groove knurled (flux cored)	7977732
Feed Roll 1.2/1.6mm V groove knurled (flux cored)	704277
Shielding Gas Hose Assembly	W7004913
MIG Pliers	WSPLIER
TIG Torch 17V with 4m lead	W4013801
WeldSkill TIG Welding Gloves	646754
WeldSkill Heavy Duty Welding Gloves	646755
Prolite Auto-Darkening Welding Helmet - SPACE	454332
Prolite Auto-Darkening Welding Helmet - CLAW	454333
ProPlus Digital Auto-Darkening Welding Helmet - WEB	454351
ProPlus Digital Auto-Darkening Welding Helmet - PRO RACER	454353
Heavy Duty Backpack	W4018001
Autocraft LW1-6, 0.8mm solid wire 5kg (handispool)	721109
Autocraft LW1-6, 0.9mm solid wire 5kg (handispool)	720161
Shield-Cor 15, 0.8mm flux cored 4.5kg (handispool)	721923
Shield-Cor 15, 0.9mm flux cored 4.5kg (handispool)	721924
Autocraft 316LSi, 0.8mm solid wire 5kg (handispool)	720288
Autocraft 316LSi, 0.9mm solid wire 5kg (handispool)	720283
Autocraft AL5356, 0.9mm 0.5kg (minispool)	721223
Autocraft AL5356, 1.0mm 0.5kg (minispool)	721224
Autocraft AL5356, 1.0mm 2kg (handispool)	723224
Satincraft 13, 2.5mm Electrodes 2.5kg	612182
Satincraft 13, 3.2mm Electrodes 2.5kg	612183
Satincraft 13, 4.0mm Electrodes 5kg	611184

\*Note: When using the Tweco SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.

# CIGWELD

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## AUTO SET WELDING INVERTER

### PLANT CONTENTS

Transmig 185 Ultra Power Source - 17.4kg

Tweco Fusion DX250 MIG Torch, 3m

Comet Professional Argon Regulator/Flowmeter

Feed rolls: 0.8/0.9mm V Groove (fitted)

1.0/1.2mm U Groove; 0.8/0.9mm V Knurled

Contact Tips: 0.8mm (fitted); 0.9mm; 1.0mm

Twistlock Electrode Holder with 4m Lead

Work Clamp with 4m Lead

Shielding Gas Hose Assembly - Quick Connect

Shoulder Strap

Operating Manual



### BONUS

Purpose Built Heavy Duty Backpack\* (W4018001)

Designed to carry all Ultra Accessories.

\*Included for a limited time only.

## WE RECOMMEND GENUINE CIGWELD PRODUCTS



THE BIGGEST RANGE AND THE BEST QUALITY, WITH GUARANTEED PERFORMANCE.



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