

# Standard model KR II series

Thyristor controlled CO<sub>2</sub>/MAG Welding Machines

Popular model with outstanding performance and wide application!

CO<sub>2</sub>/  
MAG

The most best selling model



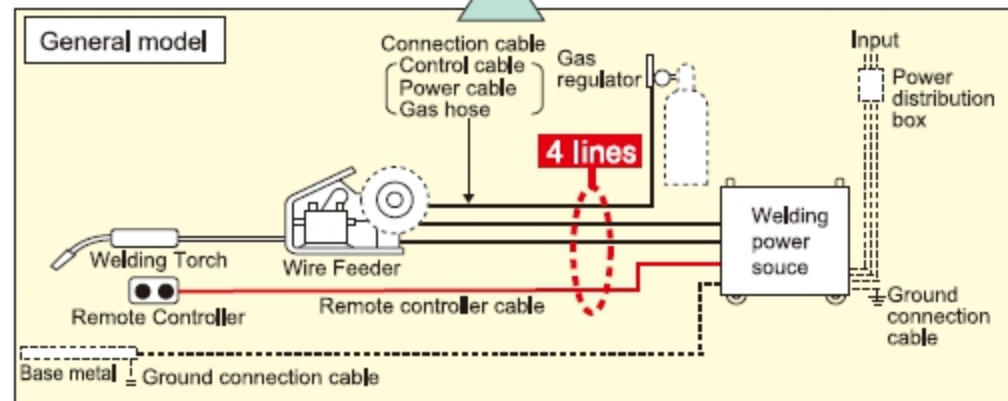
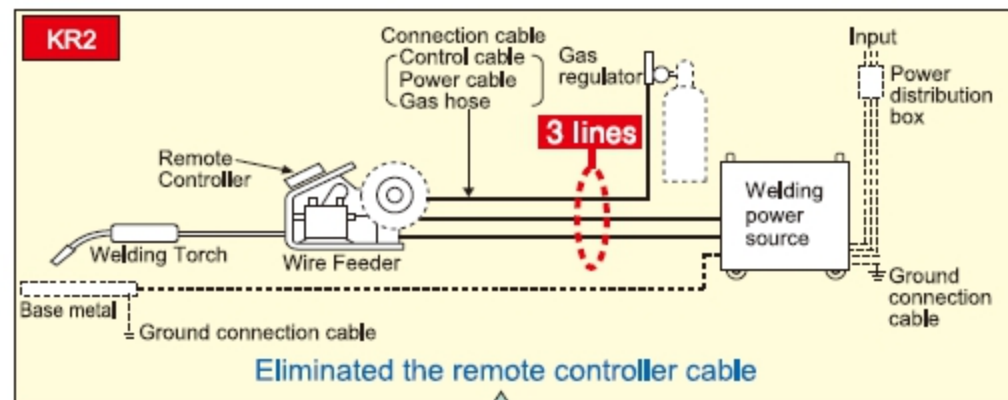
## Good welding performance

- The KR2 adopts the special control circuit which realize low spatter welding in short circuit transfer and spray transfer of CO<sub>2</sub>/MAG welding.
- The arc starting circuit ensured high rate of success of arc start, which reaches to almost 100% under any operating mode within the technical specifications. It is also possible to be equipped with various automatic welding systems.
- When Simple Unitary mode is selected and welding current is set by the current adjust knob on the remote controller, almost corresponding welding voltage is automatically set. Fine-tuning of voltage is also possible.

## Simple structure

### Non-remote control cable design

- By carrying the remote controller on the wire feeder and improvement of control circuit, the original two pieces of cable was integrated to one pieces. This realized light weight, improved mobility and decreased wire breaking trouble.



Thyristor Controlled CO<sub>2</sub>/MAG/GMAW Welding System

# Pana AUTO KR Series

## Semi-Automatic Welding System with Cableless Remote Controller



*Active System equipped with full mobility*

Arc sensitivity is selectable by changing the tap of a reactor

Three kinds of applicable wire diameters are available

Secondary short circuit protection is the standard function

Crater voltage and crater current control are possible

Fresh Tip Treatment, and Burn back time control are realized

CERTIFICATE No. 007130



ISO 14001

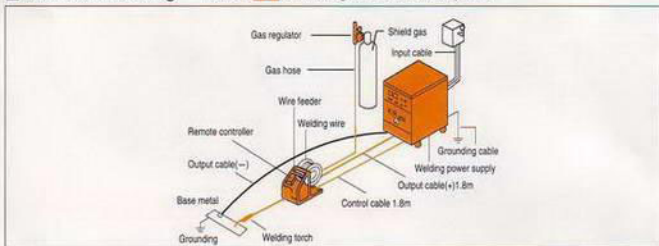
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## ■ KR Series Rated Specifications

	YM-200KR2	YM-250KR2	YM-350KR2	YM-400KR2	YM-500KR2
DC power source for CO <sub>2</sub> welding	YD-200KR2	YD-250KR2	YD-350KR2	YD-400KR2	YD-500KR2
Control Method	Thyristor	Thyristor	Thyristor	Thyristor	Thyristor
Phase	3	3	3	3	3
Rated Input	kVA 7.6(6.5KW)	9.5(7.9KW)	18.1(16.2KW)	21(19KW)	31.9(28.1KW)
Frequency	Hz 50 or 60	50 or 60	50 or 60	50 or 60	50 or 60
Output Current	A 50-200	50-250	60-350	60-400	60-500
Crater Current	A 50-200	50-250	60-350	60-400	60-500
Output Voltage	V 15-25	15-27	16-36	16-39	16-45
Crater Voltage	V 15-25	15-27	16-36	16-39	16-45
Rated Duty Cycle	% 60	60	60	60	60
Applicable Wire Material	Solid/FCW	Solid/FCW	Solid/FCW	Solid/FCW	Solid/FCW
Wire Feeder	YW-35KB1	YW-25KB1	YW-35KB1	YW-50KB1HAR	YW-50KB1
Applicable Wire Diameter	mm (0.8)/0.9/(1.0)/1.2	0.8/(1.0)/1.2	(0.8)/0.9/(1.0)/1.2	(0.8)/(1.0)/1.2/(1.6)	1.2/(1.4)/1.6
Cable Length	m 1.8	1.8	1.8	1.8	1.8
Welding Torch	YT-20CS3	YT-25CS3	YT-35CS3	YT-40CS3	YT-50CS3
Rated Duty Cycle	% CO <sub>2</sub> 50%, MAG 25%	CO <sub>2</sub> 70%, MAG 35%	CO <sub>2</sub> 70%, MAG 35%	CO <sub>2</sub> 60%, MAG 30%	CO <sub>2</sub> 70%, MAG 35%
Rated Current	A 200	250	350	400	500
Wire Diameter	mm (0.8)/0.9/(1.0)/1.2	0.8/(1.0)/1.2	(0.8)/0.9/(1.0)/1.2	(0.8)/(1.0)/1.2/(1.6)	1.2/(1.4)/1.6
Cable Length	m 3	3	3	3	3
Gas Regulator	YX-257CA	YX-257CA	YX-257CA	YX-257CA	YX-257CA

## ■ Connection Drawing

Those in      color in diagram are standard components



## ■ Welding Torch (Optional)

	Par. No. (Duty Cycle)	Remarks
YM-200KR2	YT-20CS3 (CO <sub>2</sub> : 50%, MAG: 25%)	200A torch
YM-250KR2	YT-25CS3 (CO <sub>2</sub> : 70%, MAG: 35%)	250A torch
YM-350KR2	YT-35CS3 (CO <sub>2</sub> : 70%, MAG: 35%)	350A torch
YM-400KR2	YT-40CS3 (CO <sub>2</sub> : 60%, MAG: 30%)	400A torch
YM-500KR2	YT-50CS3 (CO <sub>2</sub> : 70%, MAG: 35%)	500A torch

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Welding Machine

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