MICROPLASMA WELDING

Precision DC plasma and TIG welding for fine seams, thin material and mechanised production.



Choose Your Setup

Application	Range or option	Page
Compare output and duty cycle	25-2, 55-2 and 105-2	02
Choose gas control and interfaces	Standard, PG and PG RC	03
Specify a complete welding package	Torches, cooling and options	04

Choose By Continuous Output

All three models start at 0.3 A in plasma mode. Compare the continuous current rating and choose the gas metering and controls your application requires.

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POWER SOURCES

Three Output Ratings

All three models support DC plasma and TIG, with pulse control and an adjustable plasma pilot arc.



Mobile package with external cooler



Specification	25-2	55-2	105-2
Plasma current	0.3–20 A	0.3–50 A	0.3–100 A
TIG current	2–20 A	2–50 A	2–100 A
Plasma at 100% (40 °C)	20 A	50 A	70 A
Plasma at 60% (40 °C)	—	—	100 A
TIG at 100% (40 °C)	20 A	50 A	100 A
Plasma / TIG fuse	10 / 10 A	16 / 10 A	20 / 16 A
Plasma max. connected load	1.5 kVA	3.1 kVA	5.8 kVA
Typical selection	Fine seams at low current	Thin sheet and longer runs	Higher-output plasma work

Common to standard and PG units: 1 × 230 V, 50/60 Hz, IP23, 2–6 A pilot arc, 625 × 377 × 531mm. External torch cooling required. Check the site supply against the selected process and model.

EWM Microplasma operating instructions

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MACHINE ORDERING

Standard, PG & PG RC

Choose the metering range and control interface before specifying the torch, cooling unit and gas supply.

Model	Standard gas	Precision gas · PG	Automation · PG RC
25-2	090-007030-00502	090-007036-00502	090-007033-00502
55-2	090-007031-00502	090-007037-00502	090-007034-00502
105-2	090-007032-00502	090-007038-00502	090-007035-00502

Standard Gas Metering

For manual and fixture-based welding where the standard flow adjustment suits the job.

Plasma gas 0.1–0.9 L/min

Shielding gas 1.0–17 L/min

EWM standard and PG machine range

PG Precision Gas Metering

Fine metering for work where stable gas delivery at low current is important.

Plasma gas 0.1–1.1 L/min

Shielding gas 3.5–20 L/min

Metering tolerance ±2% of full scale as specified by EWM.

PG RC Automation

For mechanised and automated cells. Confirm the external interface, machine torch and cooling circuit with the integrator.

PG RC operating instructions

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SYSTEM OPTIONS

Build The Welding Package

Match the torch to the current range and select cooling for the duty cycle and installation.



PHW 20 water-cooled torch



Cool 55 MPW55



Trolly 55-6

Item	EWM order code	Application
PHW 20 · 3 m, 5-pole	394-003872-00000	Water-cooled hand torch for 25-2 / 25-2 PG
PHW 100 · 3 m, 5-pole	394-003843-00000	Water-cooled hand torch for 55-2 / 105-2 and PG equivalents
PHW 20 electrode setting gauge	394-001119-00000	Sets electrode position for the matching torch
Cool 55 MPW55	090-008868-00502	Current cooler listed in EWM's manual configurations
Cool 50 MPW50	090-008818-00502	Modular cooler referenced in EWM literature. Confirm supply.
Trolly 55-6	090-008826-00000	Transport cart for machine, cooler and two cylinders
RK 1 recooling unit	094-002283-00000	Separate cooling option. Confirm duty and installation.
RINT X12 Standard	090-008291-00000	External interface option for PG RC automation

For a quote, confirm torch, nozzle bore, electrode, cooler, coolant, gas hoses and regulators. EWM lists 19-pole remote options including RT1 and RTF1. Confirm process and control compatibility when ordering.

EWM plasma range EWM automation catalogue

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