

# PowerMTS 251Si GMAW/GTAW/SMAW



**5**  
YEAR WARRANTY

**PULSE MIG AND TIG**

## Not just another multi-welder. It's a statement.

If you are comparing welders and looking for something that will handle about anything you throw at it, the PowerMTS 251Si is the model to have. That's because this welder offers more power and more features than other multi-process welders in its class. And it does so while remaining light and small enough to carry around.

The PowerMTS 251Si features the latest features in MIG, TIG and Stick multi-process inverter design and technology. The unit puts out a whopping 250 amps of MIG and TIG power and does so with a respectable 40% duty cycle. An industry first, MIG and TIG modes also feature a pulse control functions, which offer greater heat and arc control capability. All MIG/TIG and Stick connections are made on the front of the machine, including the standard foot pedal, and the TIG gas connection. TIG Gas connection? Yes, the unit has fully adjustable pre/post flow feature so there's no need to have a gas valve torch. It's exactly what you'd expect out of a high end DC TIG welder. As far as TIG arc starting, select from either lift or HF start, another unique feature. However, that's not all. It would not be complete without a full list of Stick features, which include arc force and hot start controls.

## FEATURES THAT YOU NEED.

### Features that have a purpose

- Dependable digitally controlled IGBT inverter design offers excellent low spatter arc characteristics.
- Euro type connector makes gun attachment quick and easy. Gun is easy to remove for transport and storage.
- Ergonomic 24 Series MIG gun is well matched to the unit.
- Digital control with 9 program memory.
- Heavy duty wire feeder drive system is made of cast aluminum and steel instead of plastic for durability and smooth feeding of wire types.
- Start/End Amps, Up/Down Slope, and Pre/Post Flow features for full 2T/4T TIG operation when needed.
- TIG weld function for all metals except for Aluminum.
- Stick weld function tackles almost any class electrode.

### Features that perform

- Stick Hot Start and Arc force controls for better control.
- MIG Wire speed feed up to 600 inches per minute.
- TIG foot pedal is standard for infinite amp control.
- Burn-back timer reduces need for wire trimming.

- Capable of feeding 12" spools, 8" with optional adapter.
- Pulse MIG (single, voltage type) and TIG pulse extend range and performance with greater heat and arc control.
- Heavy Duty 4 roll gear driven wire feeder mechanism.

### Features that stand out

- Industry leading 40% duty cycle @ 250 amps offers a true, sustainable output at maximum amps for 4 minutes without stopping to cool.
- Spool gun capable for economical feeding of aluminum and stainless steel.
- Welding package includes MIG gun, Stick electrode holder, TIG torch, foot pedal, work clamp and regulator.
- Under the cover access makes polarity change easy.
- Auto sensing, dual voltage 120/240V input makes the unit versatile, allowing true versatility anywhere it goes.
- Over current and Duty cycle protection and diagnostic function safely interrupts welding when an event occurs.
- HF Start for TIG for effortless, touch free arc starts.
- MIG inductance control tailors puddle wet-in and arc feel.

## POWER SPECIFICATIONS AND FEATURES

PROCESSES: GMAW/SMAW (MIG/Stick)  
 INPUT VOLTAGE: 120/240V 1 Phase, 50/60Hz  
 MIG OUTPUT 120V: 30A/15.5V-150A/21.5V  
 MIG OUTPUT 240V: 30A/15.5V-250A/26.5V  
 STICK OUTPUT 120V: 10A/20.4V-120A/24.8V  
 STICK OUTPUT 240V: 10A/20.4V-200A/28V  
 PULSE MIG/TIG Hz: 10-250Hz/5-500Hz

INPUT I1MAX: (120,240V) 32,40A  
 WEIGHT: 35 lbs., unit only  
 MIG DUTY CYCLE 120V: 40% @ 150A  
 MIG DUTY CYCLE 240V: 40% @ 250A  
 STICK DUTY CYCLE 120V: 40% @ 100A  
 STICK DUTY CYCLE 240V: 40% @ 175A  
 WIRE FEED SPEED: Up to 600 IPM

INPUT I1EFF: (120, 240V) 23, 23A  
 INVERTER TYPE: IGBT  
 SPOOL CAPACITY: 12" (8" with adapter)  
 TIG OUTPUT 120V: 10A/10.4V-150A/16V  
 TIG OUTPUT 240V: 10A/10.4V-250A/20V  
 TIG DUTY CYCLE 120V: 40% @ 150A  
 TIG DUTY CYCLE 240V: 40% @ 250A

DIMENSIONS: 26"Lx18"Hx11.25"W  
 OCV: 60V  
 MIG GUN: 24 Series, Euro, 3M  
 PREFLOW/POSTFLOW: 0-10 Seconds  
 SPOT/STITCH TIMER: 0-15 Seconds  
 BURNBACK TIMER: 0-2 Seconds  
 STICK HOT START TIME: 0-2 Seconds



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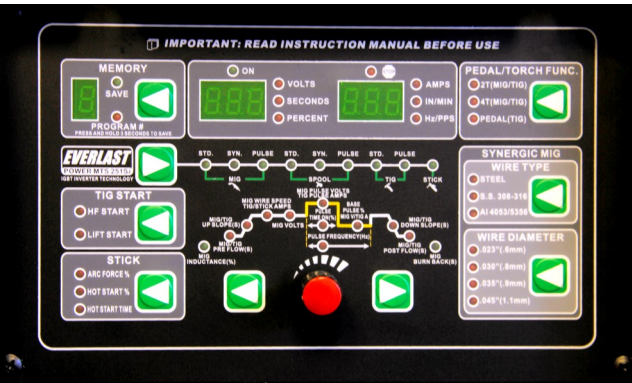
[everlastwelders.com](http://everlastwelders.com)

# PowerMTS 251Si GMAW/GTAW/SMAW



Everlast 24 Series MIG Torch, 3m    Work Clamp Cable Assembly, 3m    Electrode holder and Cable Assembly, 3m    120/240V Adapter    Everlast Argon/Argon-CO2 Regulator    Everlast 26 Series Air-Cooled TIG Torch, 4m

Actual appearance and quantity of accessories may vary.



### Performance and Equipment Specifications:

INPUT VOLTAGE	120/ 240V 50/60 HZ (± 10%)
WIRE SPEED FEED RATE	60-600 INCHES PER MINUTE
DRIVE ROLL SIZE	.035"-.045" (Opt. sizes available)
DRIVE ROLL TYPE	4 ROLL, GEAR DRIVEN
MAX WIRE SPOOL SIZE	8" (UP TO 12 LBS)
BURN BACK TIMER	0-1.5 SECONDS
ARC FORCE CONTROL	0-100% (STICK)
INDUCTANCE	0-100% (MIG)
GUN TYPE AND CABLE	24 SERIES, 3m (10 ft) LONG
PRE/POST FLOW	0-10 SECONDS
STICK HOT START TIME	0-2 SECONDS
STICK HOT START INTENSITY	0-100%
TIG LIFT START	YES
TIG HF START	YES
SYNERGIC FUNCTION	YES, MIG
UPSLOPE/DOWNSLOPE	0-1 S (MIG)/0-10 SECONDS (TIG)
MEMORY	9 PROGRAMS
SPOT/STITCH TIMER	0-15 SECONDS
MIG/TIG PULSE Hz	10-250Hz/.5-250Hz
MIG/TIG PULSE V/A /RANGE	10-100%/3-95%
MIG/TIG PULSE TIME ON	10-90%/5-95%
INPUT	120V/240V

### Safety/ Unit Protection Features:

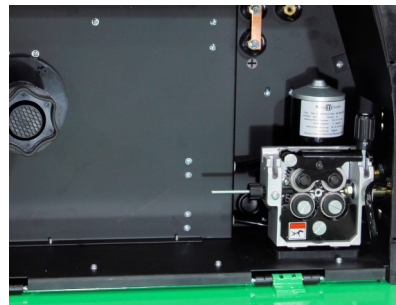
OVER TEMPERATURE WARNING	YES
OVER CURRENT WARNING	YES
SWITCH TYPE	ROCKER
FAN COOLING TYPE	DUAL FAN , CONTINUOUS
SELF DIAGNOSING	YES

All specifications subject to change without notice.



All Everlast Power i-MIG welders are covered by a 5 year parts/labor warranty.

- Polarity change is easily accomplished by swapping the solid copper buss bar position. Compared to other machines, this machines uses copper in places where others would use aluminum or even steel for carrying current. This is noticeable in the smoothness and consistency of the arc.
- A heavy duty wire feed mechanism is also designed for long service life and reliable delivery of wire to the end of the gun. Additional wire roll sizes can be obtained through Everlast.
- Burn back control reduces the need for trimming the wire at every restart by keeping the wire energized briefly after the trigger is let go, allowing the wire to quickly burn back to the desired length. The automatic postflow keeps the wire shielded during this process.
- The Euro quick-connect torch system eliminates the need for tools while coupling and decoupling the torch. The connection is the fastest connection in the industry. The foot pedal, torch switch control connection, gas connection and TIG power connection are mounted directly on the front so there is no need to open or access the main cover while TIG welding.
- Synergic function reduces setup effort. Volts and amps are controlled through single knob simultaneously. Especially helpful while running spool gun.
- High Frequency start for TIG reduces starting effort while increasing weld quality.
- Pulse MIG and Pulse TIG capability offer pedal control over heat than standard MIG and TIG. Full manual setup offers complete control over pulse parameters without complicated menus.



### RECOMMENDED OPTIONS



SKU: EV-FLUXROLL-68-1PC  
Description: Flux Core Drive Roll .6-.8mm (.023-.030")



SKU: Various  
Description: Consult Everlast website



SKU: PC250-M  
Description: Power Cart with full size cylinder capacity



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