

PowerMTS 221STi



Multi-Process MIG/AC-DC TIG/Stick Series



One welder to out-weld them all.

- ▶ Get a smarter way to weld with MIG, AC-DC TIG and Stick.
- ▶ Take almost any job you want because you can.
- ▶ Weld it where you find it with 120V/240V input.
- ▶ Turn it out fast with 35% Duty Cycle @ max setting.
- ▶ Save space. Make room for more tools.
- ▶ Lower your overhead and increase your bank account.



If you can't choose then don't.

You don't have to pick one over the other any longer.

If you are up against the wall in deciding on the best welder for your business operation, or you need more than one welder and can't really fit all of them in your budget, you can stop worrying. Everlast has you covered with the first compact, true all-in-one welder. The PowerMTS 221STi is feature packed and includes Synergic MIG, AC-DC Pulse TIG and advanced Stick welding functions. In fact, there's pretty much no limitation as to what this unit will weld. Your biggest limitation when considering this welder for your purchase is the thickness of the metal you want to weld. If it's bigger than what the PowerMTS 221STi can handle, then we have you covered there as well, with the larger PowerMTS 252STi. You may be wondering if you have to give up performance or reliability to gain an all-in-one welder. No, you don't. Not with us. The Everlast product line of MTS (MIG, TIG, Stick) welders goes back to 2009, with the introduction of first compact DC only MTS welder line to hit the U.S. market. Since that time we've refined the technology and welder design. In fact there are many more "firsts", too numerous to list, that Everlast is proud to have pioneered and proven in this type of welder. But this simply isn't about our "firsts." It is really about giving you the ability to weld what you want, where you want, when you want, in a reliable, all-in-one package. Chrome-Moly or 6061 Aluminum, it doesn't matter. You have the power and capability to weld it.

Get more out of a new design.

It's simply amazing all the pro-level features we've been able to design into this unit. The compact PowerMTS 221STi is well equipped with features such as Synergic MIG and Synergic Spool Gun capability. The unit can be used in the standard, non-synergic MIG mode as well if needed, and even can weld flux-core when equipped with optional Flux-core drive rolls. It can hold either a 4" (1 to 2 lb) or an 8" (10-12 lb) spool of wire. In TIG mode the PowerMTS 221STi has no equal. In TIG mode it features *both* AC and DC output. It even pulses in both AC and DC. For welding Aluminum, you also have a full compliment of AC welding controls, such as AC frequency, AC balance control, and even 2 wave form control settings to improve puddle control. You even have the ability to control the amps with a foot pedal or to control amps with the remote switch and weld sequencer. The fully featured sequencer cuts no corners in what it allows you to adjust and control. It allows you to program exact parameters you want, from MIG wire run in speed to TIG crater fill capability. In Stick mode, you have the ability to weld with almost any welding rod out there, including a special setting for E6010. Don't worry, it will weld with all the other rods as well, such as E7018, or E7024. Arc force and Hot start controls add an additional layer of professional level control over stick arc performance. Even with all the Pro oriented features, whether you are a Professional or a home hobbyist, the PowerMTS 221STi puts you in full control of what you want to do.

Specifications

Process: MIG, AC-DC Pulse TIG, Stick	MIG Duty Cycle @ Max: 60%@120V, 30%@240V	TIG Duty Cycle @ Max Output: 60%@120V, 35%@240V	Stick Duty Cycle @ Max Output: 60%@120V, 60%@240V
I/IMAX(Inrush): 120V, 33.2A / 240V, 33.6A	I/IEFF(Rated Running): 120V, 26A/ 240V, 23A	Wire Speed 120V/240V: 60-400/600 IPM	Wire Spool Diameter: 4" (1-2lbs.) and 8" (10-12lbs.)
Wire Diameter: .023-.030"(.035-.045"Opt.)	Recommended Stick Electrode Diameter: 1/16" - 1/8"	TIG Torch Type: Air cooled 26 Series, 12.5 ft	MIG Torch Type: 15 Series w/ Euro Quick Connect, 10 ft.
MIG Amp Output 120V/240V: 30-125/200A, 15.5V-20.3/26V	TIG Output 120V/240V: DC 10-125/200A, 10.4-15/18V; AC 20-125/200A, 10.8-15/18V	TIG AC Wave Forms: Adv. Square, Triangular	Stick Output Range 120V/240V: 10-100/160A, 20.4-24V/26.4V
OCV : 74V (with VRD <24V)	Stick VRD Voltage: <24	TIG Pulse Amps: 3-95% of Peak	TIG AC Frequency/ AC Balance: 20-200Hz/ 30-70 % of EP
TIG Pulse Frequency: .5-150Hz	TIG Pulse Time On: 5-95%	Weight: 66 lbs.	Memory: Save up to 9 programs
Water Ingress Protection: IP21S	Cooling: 4 Full Time Fan		Dimensions: 19Hx11Wx26L

Everlast Power Equipment

380 Swift Ave. Unit 12
South San Francisco, CA 94080

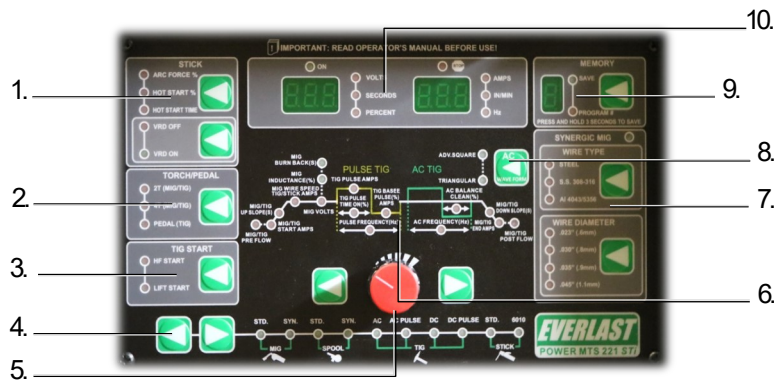
1-877-755-9353

www.everlastwelders.com

All specifications, accessories and options are subject to change without notice.

ORDER PUBLICATION: 30911-ETL OCT '18

Panel Configuration and Details



1. Stick Controls. Pro features for stick welding include Hot Start Time, Hot Start Intensity, Arc Force Control and VRD (for safety).
2. Remote 2T/4T function for MIG and TIG. Foot Pedal mode is for TIG. Choose how the unit operates with the remote or torch switch. 2T/4T (MIG and TIG), Pedal (TIG), Pedal 2T (TIG) or Pedal 4T (TIG). Pedal 2T and 4T allow the unit to be used with a torch mounted Ampctrl with a separate torch switch. The Pedal mode allows the TIG mode to be used with a foot pedal or a torch mounted ampctrl with an switch incorporated into the ampctrl.
3. TIG Start Type. Selects between Lift Start and HF Start.
4. Chooses welding mode. Select from Standard MIG, Synergic MIG, Standard Spool Gun, Synergic Spool Gun, AC TIG, AC Pulse TIG, DC TIG, DC Pulse TIG, Standard Stick and E 6010 Stick (Cellulose type).
5. Highlight parameter to be adjusted with green arrow buttons and adjust value of that parameter with the control knob.
6. Sequencer selects and controls the functions of the weld cycle and welding related features.
7. Synergic MIG Input Parameters. Select Wire diameter and Metal type to control both amps and volts synergically.
8. TIG AC Wave Form Control. Offers a choice of wave forms to improve weld and bead characteristics while welding aluminum.
9. Memory. Save up to 9 different favorite or commonly used programs. Press and hold to save.
10. Volt and Amp display with LEDs indicate function value and which value is being adjusted.

Adjustable Parameters:

1. Pre-Flow, Post Flow. Controls shielding gas flow before and after the weld. (0-10 Seconds)
2. Start Amps, End Amps. Controls Starting Amps and Ending amps of weld for TIG. For MIG, this feature controls wire feed starting speed for smoother starts and crater fill speed. (Min to Max Setting of Process)
3. Up-Slope, Down-slope. With TIG, slope is controlled with the torch switch. Down-slope allows the arc to taper and provides time for the crater to fill as before the arc terminates. (0-10 Seconds) With MG, this controls the initial run-in of wire speed after arc starts. (0-1 Seconds)
4. Amps. Amps are set for TIG and Stick. Represents Base Amps in Pulse TIG mode and welding amps in standard TIG mode. Represents wire feed rate in Inches per Minute in standard MIG mode. In synergic MIG mode, this indicates actual Amps since wire diameter and type are known. DC TIG: 10-200A; AC TIG 20-200A MIG: 30-200 A; Stick: 10-200A
5. MIG Volts. Controls MIG voltage only. Voltage is automatically controlled in TIG and Stick due to the CC process.
6. MIG Inductance adjusts the crispness of the arc. (0-100%)
7. MIG Burn Back. Controls melt back of wire at arc termination. Improves restarts and prevent wire waste. (0-2 Seconds)
8. TIG Pulse Amps. Adjusts the Amps in the Peak stage of the Pulse to control melting/penetrating stage of the arc. (5-200A)
9. TIG Pulse Time On. Controls the balance of time between Peak and Base stages of the Pulse during one pulse cycle to adjust cooling/melting time during one Pulse cycle. (5-95%)
10. TIG Pulse Frequency. Controls number of pulses per second to constrict arc cone and control directability and heat input. Also used to improve appear-

Standard Equipment and Options



Standard Kit:

- 9 ft. Cable with 250 A Stick Electrode Holder
- 9 ft. Cable with 200 A Work Clamp
- 240V to 120V Pigtail Adapter
- Argon Flow Meter (Floating Ball Type)
- NOVA Long Life (2 Million Cycle) Foot Pedal
- 15 Series MIG gun 10 ft. (3M)
- 26 Series TIG torch 12.5 ft. with starter kit



Customer Favorite Options:

- NOVA 17 Rota-Flex Torch, with 12.5 ft. Ultraflex cables #RF-17-125-35QD
- NOVA 20 Rota-Flex Torch, with 25 ft. Ultraflex cables #RF-20-250-35QD
- Everlast 17/26/18 Stubby Gas Lens Kit #E-WP17-26-18-SKT
- Everlast Pyrex Gas Lens Kit # EV-920-332-128-PXGL (20 Series)
- Everlast WC 300 Water Cooler #PCW-300-240
- Everlast SM200N Spool Gun 20 ft. #SM200N-20

Everlast proudly offers optional accessories and products from NOVA Welding Industries.



Everlast makes every effort to ensure accuracy of stated specifications and kit contents at time of publication. However, due to continual our efforts to improve our products and offerings, stated specifications, accessory kit content or product appearance may change without notice. Any change in specification, kit contents, appearance, length, etc. can be verified by calling toll-free @ 877-755-9353. *In the event of these changes, Everlast will not be liable to provide product, kit contents, or accessories exactly as depicted or described in this publication.* Please review warranty details @ <https://www.everlastgenerators.com/> standard-warranty. The 5 year parts and labor warranty covers only the power source and does not cover accessories or consumables. While this publication may be used in multiple distribution markets, the 5 year warranty only applies to US products only. Canada and other countries maintain different warranty periods and policies. Consult directly with your country's distributor about warranty details. Accessories, including all NOVA products are covered under a separate warranty. Consumables and consumable kits are not warranted except against manufacturing defect. Since Everlast cannot know or predict every situation and detail of customer's application, any statement of other warranty, expressed or implied, or statement concerning suitability of this product for a specific customer use or application is specifically disclaimed. The