

# Power i-MIG 253DPi



DC Digital MIG Series



## A Real Pulse Pounder.

- ▶ Handle new Aluminum alloys with synergic pulse.
- ▶ Control heat and improve appearance with Pulse.
- ▶ Choose single or double pulse for best performance.
- ▶ Full synergic Pulse MIG feature improves control.
- ▶ Pro performance with 60% duty cycle @ 250A.
- ▶ Mig braze high strength carbon steels.
- ▶ Weld Aluminum with a push-pull gun, spool gun.

### Single and Double Pulse Delivers Nothing But Performance.

#### Perfect for those who need to meet new welding requirements for Auto Body Repair.

If you are in the welding field, whether you are a welder in commercial fabrication, aviation or Auto Body repair, you can be guaranteed that the only constant in the business is change. Whether it is the metal alloys themselves or the technology required to weld them, chances are you are going to have to learn something new to stay current and up to date with your learning and professional certifications. At Everlast, we realize this too, and try to offer product for you to stay competitive and up to date in the field. With the latest developments in welding technology and the employment of new high strength steel and aluminum alloys in the auto repair business, basic equipped MIG welders will no longer qualify many welding shops to continue repair on newer vehicles where automotive manufacturers require Pulse MIG technology for Aluminum welding or MIG brazing for repair of their vehicles. The Power i-MIG 253DPi has been specifically brought to market to meet the growing and latest demands of the specialty welding market. Already, many are in professional repair shops and high end fabrication facilities all over the nation. To begin with, the Power i-MIG 253DPi tears down the high price barrier that many shops experience when trying to update their welding fleet to Pulse MIG technology. The price is a fraction of the cost of most competitors on the market.

#### Pick a metal, any metal.

As far as versatility, for those needing an improved appearance on MIG welds, such as those needed in watercraft building, the unit features both pulse-on-pulse (double) and single pulse MIG. This gives the user a choice of excellent heat control, or appearance, or a combination of the two. To set up, choose wire diameter, type and set amps to match metal thickness (in thousandths) and you are on your way to zipping up a new body panel. If you need to make slight adjustments, this welder allows you to adjust arc width and length with the trim and inductance control. If you need a boost of heat at the start and get the puddle started, this unit has a hot start feature too. Burn back, slope and crater fill features are standard. For double pulse operation, you simply set two levels of single pulse to control the puddle freeze to form a "Stack o' Dimes" look, which allows you to closely resemble the appearance of TIG. Almost everything else is set for you after you input of wire type and diameter. For welding/brazing of other metals, setup of the welder is the same. The unit can be equipped with a spool gun, push-pull gun, or special main gun liner designed for aluminum and other soft wire feeding if desired. Either way you choose, the unit will meet and exceed performance expectations. And, just to mention, this welder has excellent stick welding capabilities as well if you ever have

### Specifications

**Process:** GMAW-P/SMAW  
**Input:** I<sub>1</sub>MAX: 45.5A I<sub>1</sub>EFF: 36A  
**OCV:** 80V  
**Wire Feed:** 60-600IPM  
**Weight:** 68 Lbs. (31Kg)

**Everlast Power Equipment**  
380 Swift Ave. Unit 12  
South San Francisco, CA 94080

**Output:** MIG 40-250A/16-30V; Stick 10-250A/20.4-30V  
**Hot Start/DownSlope/Burn Back Features:** Yes  
**MIG Modes:** Syn. Pulse/Syn. Pulse-on-Pulse/Std. MIG/Stick  
**Drive Feeder:** Cast Aluminum/Steel 4 roll (all 4 gear driven)  
**Dimensions:** 11.25"Wx18"Hx26"L

**Duty Cycle:** 60% @250A, 40° C  
**Wire Diameter:** .023"- .045"  
**Use Classification:** Commercial/Industrial  
**Spool Size Capacity:** 8" and 12"  
**Input Cable Length:** 9.5' (3m)

**1-877-755-9353**

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

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

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## Panel Configuration and Details



- Memory. Save and recall up to 10 user defined programs.
- Synergic Selector. Select Standard MIG or Synergic MIG (Non pulse MIG mode Pulse MIG modes are synergic operation only.)
- 2T/4T/4T Special Selector. Determines how the trigger controls various stages of the weld.
- Gas Test/Wire Jog. Check and adjust gas flow without feeding wire. Cold feed wire during reloading of wire spool without gas flow.
- Select Parameter. Select which parameter to adjust.
- Graphic LED Indicator. Highlights parameter being adjusted. Graphic represents the stage of a weld. Includes Pre-Flow, Post – Flow, Hot Start, Inductance. Double Pulse Freq., Double Pulse Time On. Double Pulse Amps, Single Pulse Amps, Crater Fill, Burn – back time and Burn-back Voltage/trim.
- Process Selector. Select and choose between Stick, Single Pulse MIG and Double Pulse. Also select to adjust factory preset parameters.
- Wire Type Selector. Choose between Steel, Stainless, 40XX Aluminum, 50XX Aluminum, Si-Bronze.
- Wire Diameter. Select size of wire being used. .030”, .035”, .045”
- LED Indicators. Right Indicator indicates either Volts (or Trim), Hz, Seconds or %. Left Indicator indicates Amps and Error Status.



## Standard Equipment and Options



### Standard Kit:

- 10 ft. (3m) 24 Series Gun with Euro Connector
- 9 ft. Cable with 200 A Stick Electrode Holder
- 9 ft. Cable with 200 A Work Clamp
- Regulator Ar/CO<sub>2</sub>
- Alternate Drive Rolls (V groove and U groove)
- Aluminum Liner for Torch
- 8” to 12” Adapter for Wire Spool



### Customer Favorite Option:

- PowerCart 250 Sku/Part# PC-250-M

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