

PowerMTS 252STi



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

It Makes our Competitors Green with Envy.

- ▶ Meet the most powerful Compact MIG, AC/DC TIG, Stick on the market.
- ▶ 4 fan design yields a true industrial duty cycle of 60% (MIG/TIG).
- ▶ 3 Wave form controls to select from in AC TIG for optimum control.
- ▶ Pulse in both AC and DC TIG modes, a class leading feature.
- ▶ Includes all accessories for TIG, MIG and Stick welding.
- ▶ Optional Cart and Water Cooler for industrial applications.
- ▶ Synergic MIG makes setup and operation easy.
- ▶ E6010 Stick welding capability.



Is the competition really rebelling or are they in denial?

There seems to be a lot of confusion, commotion and finger pointing going on with some of our competitors. Why? Because, Everlast is on record as building the first MIG TIG and Stick machine with AC/DC TIG output. It seems as some of our competitors just can't wrap their heads around that fact. For the last couple of years, boasts have been made over and over by our competitors that just didn't hold up to time, scrutiny or reason. Yet, somehow, some competitors are making hard to believe claims, even now. So, what's up? Are they in denial?

Let's cut through the confusion, and go straight to the facts. Back in November 2009, Everlast introduced the first 200 amp compact MIG, DC TIG, Stick machine to the market, years ahead of our competition. During July of 2017, the first PowerMTS model with AC/DC TIG output went on sale and was fully released to the public. 6 months later, the more powerful PowerMTS 252STi was released at the beginning of 2018. The MTS class of welders with AC TIG actually started with a new class of Everlast MTS units released back in 2015 that feature High Frequency DC TIG starting. Fast forward to the present. The PowerMTS 252STi is now the definitive MTS unit by which all competitor models are being judged. It is clearly an industrial machine intended for commercial applications, even though many hobbyists find the price attractive. With Duty cycles of 60% for MIG and TIG and a healthy duty cycle of 40% for stick (at maximum output), the PowerMTS 252STi does not back down from fight. Features such as AC TIG wave form control, AC and DC pulse TIG, synergic MIG, memory and E6010 Stick capability are all hallmarks of a true professional welder designed for serious use and put the PowerMTS 252STi at the top of the class. Ok, now consider the competition's claim of being the "only true industrial" MTS type welder with only 25% duty cycle. Well, let's just say, that's entry level league right there. So, where do the claims of industrial design with such low duty cycle ratings come from? Their claim is largely based off of an international standard rating system of water ingress. For comparison, our units are rated for an IP21S rating, which means that the unit is safe from condensation and light dripping water. This is a long held industrial standard. Many great and historic industrial welding machines from all brands meet that standard. While the higher IP23 rating of the competition is not a exclusive or new standard in welders, very few people are going to be welding while a constant and heavy stream of water is directed at the welder at a 60 degree angle. The IP23 rating is good, but how many are going to be welding in a drenching hurricane? Both ratings are considered safe for day to day use. The issue is that the IP23 rating means that the design typically has to sacrifice duty cycle by restricting angle and number of cooling vents to reach the standard. With an IP21S rating, the design can be "opened" up just enough to allow more air flow and better heat exchange. Ask yourself, if you are in the welding business, which machine would you want for industrial use? One with a 25% duty cycle or 60% duty cycle? One that has an optional water cooler specifically designed to be connected to it if needed or one with no water cooler provision? One that has a long history of development and stability or one of recent but constantly delayed design? If you'd want one with 60% duty cycle, long development history, proven design, with water cooler capability, and at price with a warranty that beats the competition, the PowerMTS 252STi, wins on the facts alone.

Specifications

Process: MIG, AC-DC Pulse TIG, Stick
IIMax(Inrush): 120V, 42.8A / 240V, 44.9A
Wire Diameter: .023" - .045"
OCV: 74V
TIG Pulse Frequency (AC and DC): 5-150Hz
MIG Output 120/240V: 30-150/200A, 15.5V-21.5/26.5V
Fan: Full-Time 4 Fan Design

MIG Duty Cycle @ Max Output: 60%
IEff (Rated): 120V, 34A / 240V, 35A
Recommended Stick Electrode Diameter: 1/16"-5/32"
Stick VRD Voltage (activated): <24V
TIG Pulse Time On: 5-95%
TIG Output 120/240V: DC 10-150/250A, 10.4-16/20V
Ingress Protection: IP21S

TIG Duty Cycle @ Max Output: 60%
Wire Speed 120/240V: 60-400/600 IPM
TIG Torch Type: Water-Cooled 18 Series 12.5ft
TIG AC Wave Form: Adv. Square, Soft Square, Triangular
TIG Pulse Amps: 3-95% of Peak
Stick Range: 10-120/200A, 20.4-24.8/28V
Weight: 84 lbs.

Stick Duty Cycle @ Max Output: 60%
Wire Spool Diameter: 8" and 12" diameter
MIG Torch Type: 25 Series w/ Euro Connector
TIG AC Frequency/AC Balance: 20-200Hz/30-70%
Memory: Save up to 9 programs
Class: Industrial, Commercial, Farm, Fabrication
Dimensions: 27"Hx11"Wx29"L (30" H w/ Handle)

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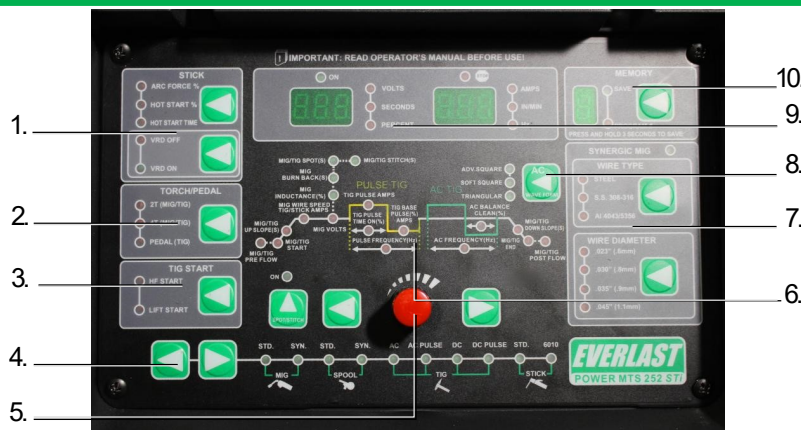
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www.everlastwelders.com

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

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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 Amptrol with a separate torch switch. The Pedal mode allows the TIG mode to be used with a foot pedal or a torch mounted amptrol with an switch incorporated into the amptrol.
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. (0-10S)
2. Start Amps, End Amps. Controls starting amps and ending amps of weld in TIG mode. For MIG, this feature controls wire feed starting speed for smoother starts and crater fill speed. (Min to Max setting of selected 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 before the arc terminates. 0-10 Seconds) With MIG, this controls the initial run in of wire speed after the 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: 10-250A, AC TIG: 20-250A, MIG: 30-200A 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 after arc termination. Improves restarts and prevents 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. (10/20-250A)
9. TIG Pulse Time On. Controls the Balance of the time between Peak and Base stages of the Pulse cycle. Adjust the 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 arc direction and heat input. Also used to improve bead appearance.

Standard Equipment and Options

Standard Kit:

- NOVA TIG Foot Pedal
- 25 Series, 250A MIG Torch
- Ar, Ar/CO2 regulator
- 18 Series, 350A Water-Cooled TIG torch
- 9 ft. Cable with 250 A Stick Electrode Holder
- 9 ft. Cable with 200 A Work Clamp
- 240V to 120V Pigtail Adapter

Customer Favorite Options:

- Air-Cooled NOVA 17 Rota-Flex Torch , 25 ft. Ultraflex cables #RF-17-250-35QD
- Everlast 17/26/18 Stubby Gas Lens Kit #E-WP17-26-18-SKT
- PowerCool 400 Water Cooler #PCW-400-240
- PowerCart 300 #PC-300-M
- Parker DSP 360 Spool Gun EV-PK360-DSP-25

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



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