REHM Welding Technology

Developed and manufactured in Germany
Premium brand
MADE IN GERMANY

WELDING EQUIPMENT
COMPLETE PRODUCT RANGE 2024

SIRIUS

FOCUS.ARC

ÖKO DESIGNED
EU-Konform

similar picture

You can find all the important information about ordering, delivery, exchange and service, including prices and additional pricing conditions, here:

https://www.rehm-online.de/de/downloads/englisch/allgemein/order-and-price-conditions.pdf

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These are available in printable form on our website **www.rehm-online.de** at all times. We would be happy to send you a copy of our General Terms and Conditions upon request.

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Dear customers, dear business partners,

We are pleased to present you our current complete product range.

Irrespective of the application, whether plasma cutting, electrode, MIG / MAG or TIG welding, whether with established analogue or modern inverter technology up to the digital operating concept of our current models, we offer you the perfect equipment for every application and every requirement.

Our machines are characterised by their innovative technologies, their ease of operation and their practical applicability in the tough everyday workshop or on the construction site and, last but not least, by their delivery of perfect welding results. In the process we are constantly pursuing the direction towards the digitalisation of equipment and Industry 4.0.

To advance this standard, all of our departments work in a customer-oriented manner and deliver quality 100% Made in Germany - from development to production and sales. This enables us to set the standard for modern welding every day.

Now take a look at the current developments from REHM and use our equipment to ensure your company works more efficiently to produce products and services with greater quality, enhanced employee health protection and added ability to communicate.

Because we care about the environment, all of our devices meet all the requirements of the EU Ecodesign Directive thanks to their high efficiency.

Do not hesitate to contact us if you have any questions or require further information.

Your REHM Team

REHM – The benchmark for modern welding

[1] The proper handling, treatment and use of our equipment in accordance with our operating instructions are prerequisite for granting warranties. Wear and consumable parts are excluded from warranty. The statutory warranty provisions according to our general terms and conditions remain unaffected. Our warranty provisions can be viewed on our website ander www.rehm-online.de. We will also send our warranty provisions on request.

Revolution in welding technology

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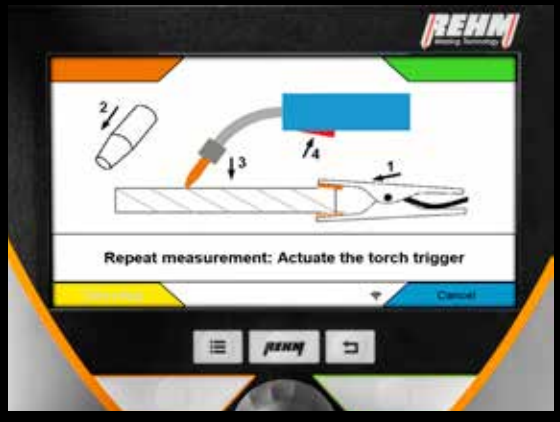
SIRIUS opens up new potentials

SIRIUS simplifies the operation of complex processes by visualization and assist functions.

Modern, digitally controlled machines offer a multitude of optimisation possibilities. These are a must in modern manufacturing. Increase your competitiveness by bringing out the unused potential of SIRIUS.

The SIRIUS display shows everything at a glance - in day and night mode

Parameters to be optimized are transparent and graphic-dynamic visualized



The relevant parameters are always in the foreground, which can be recognized from distance by the operator

Equipped with *Open Connect* SIRIUS is fully compliant with Industry 4.0

The possibilities to communicate digitally through SIRIUS are endless. The interface architecture of SIRIUS can be configured and expanded in any way.

Easy integration into existing systems through integrated server module. SIRIUS communicates via all common interfaces via Ethernet, USB, CAN bus, LAN, W-LAN, 2.4 GHz radio technology.

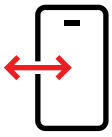
- SIRIUS is not an isolated solution that is only used for the documentation of welding data
- SIRIUS can be fully integration into the operational process chain
- SIRIUS creates easy integration into CAD and ERP systems
- SIRIUS has freely programmable interfaces
- SIRIUS digitizes and communicates machine and process data to all networks

Ingenious

- Simplifies the operation of complex digitally controlled processes
- Graphically dynamic and transparent visualization
- Assist functions
- Maximum user acceptance

Flexible

- Ready for I 4.0
- Simple integration into all systems / production chains and processes
- Freely configurable interface



Smarter

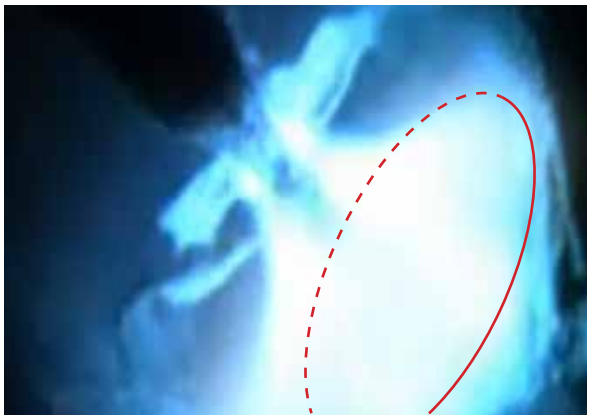
- Download the REHM app and get started
- Communicates with all networks and mobile devices
- LAN, W-LAN

A first impression of our simple and intuitive operation can be found here:
www.rehm-online.de/de/technologie/sirius.html

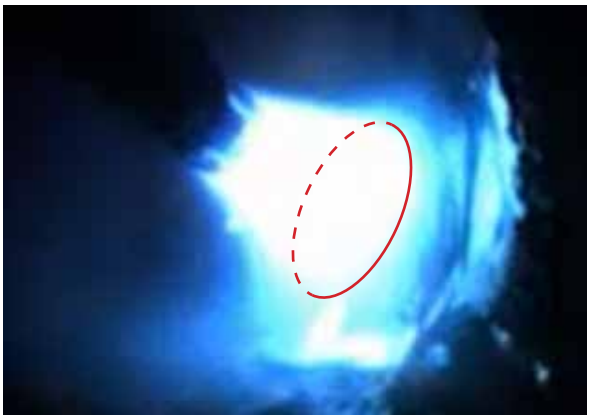
Just better welding

FOCUS ! ARC

Unlike conventional welding processes used until now FOCUS technology bundles the energy at the centre of the arc.



Previously: Conventional welding process
a wide arc with energy dispersed at the edge



Now: FOCUS.ARC welding process
Concentrated arc with the energy at the centre

Advantages of the REHM FOCUS welding processes*:

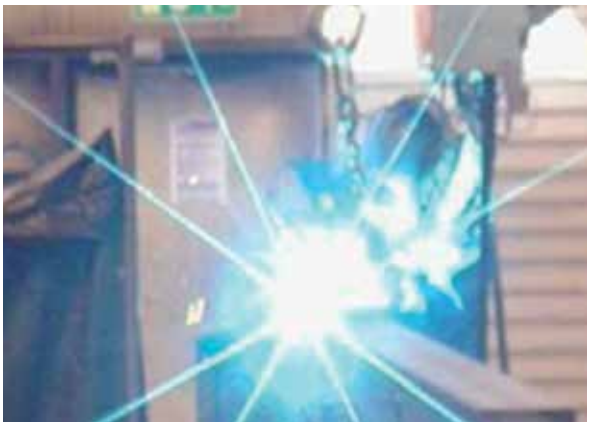
Digitally controlled welding processes.
- Controlled particle transfer
- Controlled short circuit resolution
- Controlled heat input

Reduction of rework.
- The percentage of rework can be reduced by 80 %.

Increased quality.
- Improved process visibility
- Improved arc control
- Less faults

Improving health protection.
- The formation of health-endangering welding fumes can be reduced by up to 70 %
- Grinding dust contamination is reduced by up to 80 %
- Weld spatter can be reduced by up to 100 %

Previously: Significant development of welding fumes
during conventional welding process.



Now: Welding fumes reduced by 70 %
by the FOCUS.ARC welding process.

*Information only applies in conjunction with REHM FOCUS.PULS

Whether increasing performance, quality improvement or responsible health protection - the fully digitally regulated FOCUS.ARC welding processes ensure your competitive advantage.

Faster

- Increased revenue of up to 50 %
- More meters of welding seam per hour
- Less rework
- REHM potential analysis

Better

- Better view into the welding process
- Better arc control
- Less faults
- Higher quality

Healthier

- Exposure to welding fumes reduced by up to 70 %
- Elimination of problems caused by weld spatter
- 80 % less grinding dust pinlution

FOCUS.ARC is not just a promise, it proves its performance capability. Because only the result counts!

Digitally controlled welding processes for all applications

FOCUS.PULS

High performance welding process for steel construction

- Accurate with adjustable heat input
- Heat input reduced by 30 %
- Melting disposition rate up to 60 % increased
- Welding with reduced seam opening angle
- Significant improved quality
- Overweldable spots
- REHM generates a profit potential analysis

FOCUS.ROOT

Almost spatter free welding process for thin materials and root welding

- Very good bridging of gaps
- Significant weld speed increase at down welding
- Root welding also with reduced seam opening angle
- Save penetration
- No spatters

POWER.PULS

Very good modulation of the welding process for steel, stainless steel and aluminium

- Faster welding of stainless steel with weld seam surface almost similar to TIG
- Very little temper colour, electrochemically eliminable
- Adjustable heat input
- Welding seams in TIG optic, by using double pulse
- Overweldable spots
- Full optimization for special applications

FOCUS.ARC

Welding in unmatched dimensions

- Welding with a short, powerful arc
- Safe root detection
- Particularly deep penetration
- Safe edge detection
- Reduced penetration

Application examples www.rehm-online.de/en/application-reports

MIG/MAG
WELDING EQUIPMENT

// Smart process

// More speed

// Higher efficiency

REHM – The benchmark for modern welding

Technology you can count on – robust, durable and state of the art! Made in Germany by REHM.

The FOCUS.ARC® P

The revolution in welding technology. The digital operating system SIRIUS and the fully digitally controlled welding process FOCUS.ARC provides advantages that secure your competitiveness.

- **Faster**
  Increased revenue of up to 50 %
- **Better**
  Better view into the welding process
- **Healthier**
  Exposure to welding fumes reduced by up to 70 %
- **Ingenious**
  Assist functions
- **Flexible**
  Ready for I 4.0
- **Smarter**
  Download the REHM app and get started

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL FOCUS.ARC® P 300-450 WS

Further information on the SIRIUS operating system can be found on pages 06-07.

1 Menu button | 2 Home button | 3 Return button | 4 Selection buttons | 5 R-Pilot encoder

6

Impact protected full colour display | Self-explanatory presentation | Dynamic displays | Smart Assist function

FOCUS.ARC® P 300-450 WS

TECHNICAL DATA		300	350	400	450
Setting range	[A]	20-310	20-360	20-410	20-460
Duty cycle (ED) at Imax.	[%]		80		60
Weld current at 100 % ED	[A]	280	320	370	400
Open-circuit connection	[V]	89		75	
Wire feed	[Ø mm]	1.0 / 1.2			
Mains connection	[V]	3 x 400			
Mains voltage tolerance	[%]	+15 / -25			
Fuse	[A]	32			
Protection type		IP 23			
Power factor	[cos phi]	0.99			
Power consumption at Imax.	[kVA]	11	13.7	16.8	20.6
Weight without undercarriage	[kg]				
Compact gas-cooled		46		49	
Compact water-cooled (W)		56		59	
With wire feed case gas-cooled (S)		57		60	
With wire feed case water-cooled (WS)		70		73	
Dimensions without undercarriage LxWxH	[mm]				
Compact gas-cooled		650 x 330 x 624			
Compact water-cooled (W)		650 x 330 x 820			
With wire feed case gas-cooled (S)		650 x 330 x 1,100			
With wire feed case water-cooled (WS)					
Item no.					
Compact gas-cooled		1307055	1307065	1307075	1307085
Gas-cooled with wire feed case (S)		1307057	1307067	1307077	1307087
Compact water-cooled (W)		1307056	1307066	1307076	1307086
Water-cooled with wire feed case (WS)		1307058	1307068	1307078	1307088

Operation as standard in wire feed case. Choose undercarriage separate.

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standard.

W = with water cooling, WS = with water cooling and separate wire feed case, S = with separate wire feed case

The FOCUS.ARC® P

Undercarriage

Various undercarriage options are available for the FOCUS.ARC® P:

UNDERCARRIAGE OPTIONS	Undercarriage Advanced	Undercarriage Profi	Trolley	Upright stand	Retrofit kit driving carriage for wire feed case
Base plate	not required	not required	not required	✓	not required
Wheels: Front 160 mm with fixing brake Rear 260 mm	✓	✓	2 rolls	–	4 rolls
Gas bottle mount up to 50 l	✓	✓	✓	–	–
Wheel arches in the back	✓	–	–	–	–
Brakes on the front wheels	✓	–	–	–	–

UNDERCARRIAGE ADVANCED

Loading rack for gas bottles
- Helps prevent back injuries
- Avoids work accidents

Integrated crane hooks

Breaks on the front wheels
- Prevents the unit rolling away when being transported or changing the gas bottle

Gas bottle mount
- Robust mount for gas bottles up to 50 litres

Wheel arches in the back
- Prevents the power supply cable being crushed when manoeuvring

Large wheels
- Front 160 mm with fixing brake
- Rear 260 mm

Undercarriage Advanced in practical use

OPTIONS

TECHNICAL DATA		Undercarriage Advanced	Undercarriage Profi	Trolley
Weight	[kg]	31.5	30	30
Dimensions LxWxH	[mm]	900 x 560 x 1,020	950 x 611 x 1,100	770 x 660 x 1,330
Item no.				
		1381102	1381101	1381386

TECHNICAL DATA		Upright stand	Retrofit kit driving carriage for wire feed case
Weight	[kg]	0.8	3.36
Dimensions LxWxH	[mm]	544 x 30 x 43	480 x 120 x 140
Item no.			
		1381100	1381150

OPTIONS

	Item no.
Gehäuse	
Operation in the machine FOCUS.ARC	1381153
Without undercarriage	1381100
Preparation for trolley	1381385
Trolley including preparation	1381386
Undercarriage Profi 50 l	1381101
Undercarriage Advanced 50 l (with loading rack and fixing brake)	1381102
Top shock proof cover display FOCUS.ARC	1381107
Bottom shock proof cover display FOCUS.ARC	1381108
Toolbox for compact machines	1381143
Air pre-filter	1381144
Crane lifting lugs for wire feed unit	1381146
Drum wire feed-through (wire feed unit)	1381147
Option undercarriage for wire feed case	1381150
Holder for torch and hose pack SP² 250-450/MA²/MPF M16/SP/IVP	1180214

INTERMEDIATE HOSE PACK SELECTION TABLE

Maximum welding current for the workplace

Duty cycle	100 A	150 A	200 A	250 A	300 A	350 A	400 A	450 A	500 A
10 %	50 mm²	50 mm²	50 mm²	50 mm²	50 mm²	50 mm²	70 mm²	70 mm²	95 mm²
20 %	50 mm²	50 mm²	50 mm²	50 mm²	50 mm²	70 mm²	70 mm²	95 mm²	95 mm²
35 %	50 mm²	50 mm²	50 mm²	50 mm²	70 mm²	70 mm²	70 mm²	95 mm²	95 mm²
60 %	50 mm²	50 mm²	50 mm²	50 mm²	70 mm²	70 mm²	95 mm²	95 mm²	95 mm²
80 %	50 mm²	50 mm²	50 mm²	50 mm²	70 mm²	70 mm²	95 mm²	95 mm²	95 mm²

This selection table serves for orientation based on the welding current to be expected at the respective workplace.
We recommend increasing the cross section for intermediate hose packages of 15 m in length or longer.

Maximum welding currents in practice

	Steel	CrNi	Alu
0.8 mm	240 A	230 A	-
1.0 mm	340 A	300 A	270 A
1.2 mm	380 A	340 A	330 A
1.6 mm	450 A	400 A	350 A

ACCESSORIES

	Item no.
Intermediate hose pack gas-cooled	
Intermediate hose pack MIG / MAG 50mm² 1,4m G 12p FA/MA/SP	7505000
Intermediate hose pack MIG / MAG 50mm² 5m G 12p FA/MA/SP	7505001
Intermediate hose pack MIG / MAG 50mm² 10m G 12p FA/MA/SP	7505002
Intermediate hose pack MIG / MAG 70mm² 1,4m G 12p FA/MA/SP	7505010
Intermediate hose pack MIG / MAG 70mm² 5m G 12p FA/MA/SP	7505011
Intermediate hose pack MIG / MAG 70mm² 10m G 12p FA/MA/SP	7505012
Intermediate hose pack MIG / MAG 70mm² 15m G 12p FA/MA/SP	7505013
Intermediate hose pack MIG / MAG 70mm² 20m G 12p FA/MA/SP	7505014
Intermediate hose pack MIG / MAG 95mm² 10m G 12p FA/MA/SP	7505022

ACCESSORIES

	Item no.
Intermediate hose pack water-cooled	
Intermediate hose pack MIG / MAG 50mm² 1,4m W 12p FA/MA/SP	7505030
Intermediate hose pack MIG / MAG 50mm² 5m W 12p FA/MA/SP	7505031
Intermediate hose pack MIG / MAG 50mm² 10m W 12p FA/MA/SP	7505032
Intermediate hose pack MIG / MAG 70mm² 1,4m W 12p FA/MA/SP	7505040
Intermediate hose pack MIG / MAG 70mm² 5m W 12p FA/MA/SP	7505041
Intermediate hose pack MIG / MAG 70mm² 10m W 12p FA/MA/SP	7505042
Intermediate hose pack MIG / MAG 70mm² 15m W 12p FA/MA/SP	7505043
Intermediate hose pack MIG / MAG 70mm² 20m W 12p FA/MA/SP	7505044
Intermediate hose pack MIG / MAG 95mm² 1,4m W 12p FA/MA/SP	7505050
Intermediate hose pack MIG / MAG 95mm² 5m W 12p FA/MA/SP	7505051
Intermediate hose pack MIG / MAG 95mm² 10m W 12p FA/MA/SP	7505052
Intermediate hose pack MIG / MAG 95mm² 15m W 12p FA/MA/SP	7505053
Torch MIG / MAG gas-cooled	
Torch MAG MB 24D 3m G 50° KGK	7601566
Torch MAG MB 24D 4m G 50° KGK	7601567
Torch MAG MB 24D 5m G 50° KGK	7601568
Torch MAG MB 26D 3m G 50° KGK	7601569
Torch MAG MB 26D 4m G 50° KGK	7601570
Torch MAG MB 26D 5m G 50° KGK	7601562
Torch MAG MB 36D 3m G 50° KGK	7601571
Torch MAG MB 36D 4m G 50° KGK	7601561
Torch MAG MB 36D 5m G 50° KGK	7601572
Torch MAG MB 24D 3m UD G 50° KGK	7601024
Torch MIG / MAG water-cooled	
Torch MAG W 340D 3m	7601716
Torch MAG W 340D 4m	7601718
Torch MAG W 340D 5m	7601720
Torch MAG W 440D 3m	7601722
Torch MAG W 440D 4m	7601724
Torch MAG W 440D 5m	7601726
Torch MAG W 540D 3m	7601728
Torch MAG W 540D 4m	7601730
Torch MAG W 540D 5m	7601732
Torch MAG W 340D 7 3m UD	7601717
Torch MAG W 340D 7 4m UD	7601719
Torch MAG W 340D 7 5m UD	7601721
Torch MAG W 440D 7 3m UD	7601723
Torch MAG W 440D 7 4m UD	7601725
Torch MAG W 440D 7 5m UD	7601727
Torch MAG W 540D 7 3m UD	7601729
Torch MAG W 540D 7 4m UD	7601731
Torch MAG W 540D 7 5m UD	7601733
Wear parts sets for torch	
Wear parts set RC/MB 24D/240WD	7700416
Wear parts set RC/MB 26D	7700418
Wear parts set RC/MB 36D	7700419
Wear parts set W340	7700621
Wear parts set W440	7700622
Wear parts set W540	7700623

ACCESSORIES

	Item no.
Earth cable	
Earth cable 35mm² 4m 13mm with 400A clamp	7810102
Earth cable 50mm² 4m 13mm with 500A clamp	7810109
Earth cable 70mm² 4m 13mm with 600A clamp	7810104
Earth cable 95mm² 4m 13mm with 600A clamp	7810150
Pressure reducer	
Pressure reducer Optimator Argon/CO_2	7967932
Pressure reducer Argon/CO_2 G1/4" 0-30/200bar	7530500
Pressure reducer, Argon/CO_2 G3/8" 0-30/200bar NL	7830164
Basket spool adapter	
Basket spool adapter Industry	7516000
Basket spool adapter Professional	7516004
Gas hose	
Gas hose ISO3821 6x3,5 2x 1/4" 1,8m	3250001
Inert gas filter G1/4" RH	7501111
Cooling liquid	
Cooling liquid, RCL, 5l	1680051
Cooling liquid, RCL, 25l	1680251
Remote control	
SET MIG-FP1 + Interface	7501101
Set consists of handheld remote controller 7501004 with 2 controllers and interface 1381285	
Hand-held remote control MIG-FP1 for Interf. FP1	7501004
Hand-held remote control with 2 controls. (requires the interface 1381285)	
Undercarriage	
Trolley	7532026
Mounting kit FA/MA trolley	2103040

FEED ROLLERS FOR WIRE FEED UNIT

	Item no.
Single feed rollers for massive wire	
Feed roller 0,6/0,8mm massive 4/2	7503054
Feed roller 0,8/1,0mm massive 4/2	7503055
Feed roller 1,0/1,2mm massive 4/2	7503053
Feed roller 1,2/1,6mm massive 4/2	7503056
Feed roller 0,9/1,1mm massive 4/2	7503065
Single feed rollers for tube wire	
Feed roller 1,2/1,6mm tube 4/2	7503066
Single feed rollers for aluminium wire	
Feed roller A 1,0/1,2mm alu 4/2	7503069
Feed roller A 1,2/1,6mm alu 4/2	7503070
Feed roller A 1,6/2,4mm alu 4/2	7503071

UPGRADE EQUIPMENT

	Item no.
Retrofit kit holder for torch and hose pack	7501129
Retrofit kit shock proof cover display top/bottom FOCUS.ARC	7501130
Retrofit kit air pre-filter	7501132
Metal filter FA P (two pieces per attachment)	7503057
Retrofit kit toolbox for compact machines	7501131
Wire feed case	
Retrofit kit driving carriage for wire feed case SP²/MA²	7501502
Interfaces	
Interfaces - SET FA to URe series	7504015
Programmed interface including 5m connection cable and installation manual	
Interface FP1 standard 5m	1381285
Start, current flows, two analog values with 5m control line	

SPARE PARTS FOR WIRE FEED UNIT

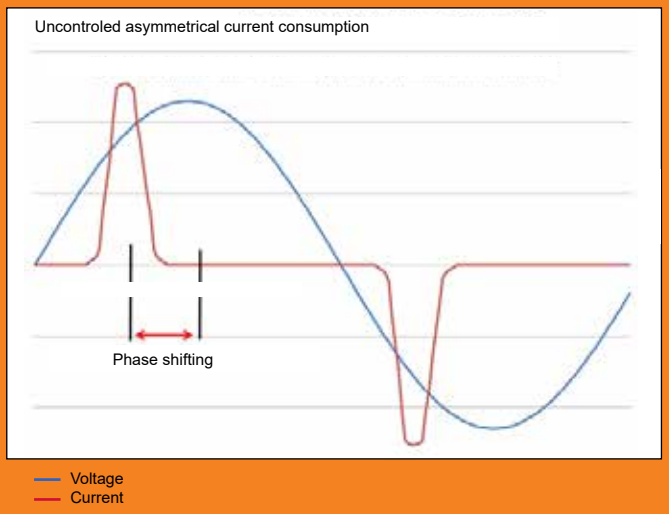
	Item no.
Capillary tube up to 1,6mm	7503067
Support tube for teflonfeeder up to 4mm outer diameter	7503068
Clamping pulley left 4/2	7503086
Clamping pulley right 4/2	7503087
Inlet blue ID ø 2.0mm	4000222
Middle wire feed, blue, ID ø 2.0mm	4000223
Pressure unit complete, red SS4-ST4	4000220

POWER FACTOR CONTROLLER (PFC)

The benchmark for efficient welding

**Benefit from the use of the Power Factor Controller (PFC) in many of our welding machines.
No matter whether you weld TIG or MIG / MAG.**

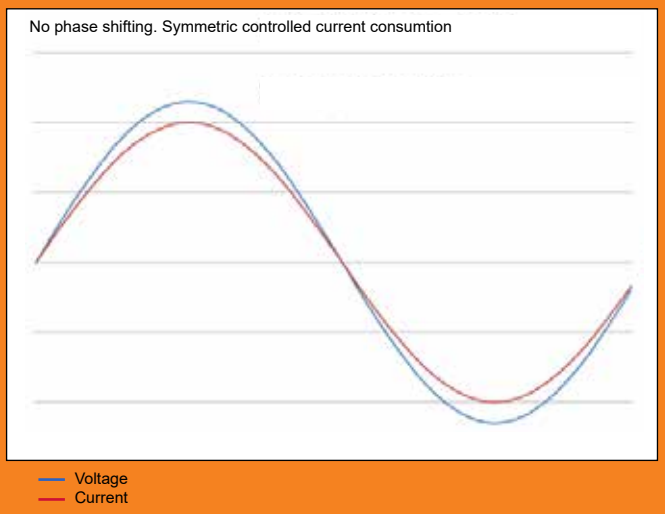
The progress of current and voltage without PFC



Primary inverters are for the power supply network a capacitive load. This generates a phase shifting between current and voltage. The result is reactive power.
Another effect is that the consumption of current is not controlled. The current curve is like a peak.
The result is that the fuse is dropping earlier.

- The consumption of current is not controlled. This causes a faster tripping of the fuse in the supply.
- Caused from the phase shifting appears a high level of reactive power, which is in the future not allowed anymore

The progress of current and voltage with PFC



A PFC is able to correct the phase shifting as well as the peaks from the current.

Via a very fast measurement is the PFC sensing the voltage and the current consumption.
According to the measurement is the current consumption regulated according to the voltage at each moment.
The PFC also stores energy, this can be used, if needed from the machine.

- The consumption of current is controlled
- No phase shifting
- More load at same connection is possible

Reduced power consumption

In addition to the other advantages offers the PFC also a reduced power consumption:

1. The maximal current consumption is 12,5 % reduced
2. The effective current consumption is 25 % reduced
3. The maximal power consumption is 15 % reduced

Pulse welding for perfect MIG / MAG welding results.

The MEGA.ARC P 300-450 WS

Just right for users who want to work with modern technology in a highly professional manner.
Designed for professional use by industrial customers.

- **Faster**
  More meters of welding seam per hour
- **Better**
  Better arc control
- **Healthier**
  80 % less grinding dust
- **Flexible**
  Ready for I 4.0 (optional)

SIRIUS

FOCUS.ARC

ENERGY EFFICIENCY by PFC

WPQR EN 1090 zertifiziert · certified

Everything you need to know about the qualification of welding processes. The REHM WPQR package, see page 62.

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

MEGA.ARC P 300-450 WS

TECHNICAL DATA		300	350	400	450
Setting range	[A]	20-310	20-360	20-410	20-460
Duty cycle (ED) at Imax.	[%]		80		60
Weld current at 100 % ED	[A]	280	320	370	400
Open-circuit connection	[V]	89		75	
Wire feed	[Ø mm]	1.0 / 1.2			
Mains connection	[V]	3 x 400			
Mains voltage tolerance	[%]	+15 / -25			
Fuse	[A]	32			
Protection type		IP 23			
Power factor	[cos phi]	0.99			
Power consumption at Imax.	[kVA]	11	13.7	16.8	20.6
Compact gas-cooled		46		49	
Compact water-cooled (W)		56		59	
With wire feed case gas-cooled (S)		57		60	
With wire feed case water-cooled (WS)		70		73	
Dimensions without undercarriage LxWxH	[mm]				
Compact gas-cooled		650 x 330 x 624			
Compact water-cooled (W)		650 x 330 x 820			
With wire feed case gas-cooled (S)		650 x 330 x 1,100			
With wire feed case water-cooled (WS)					
Item no.					
Compact gas-cooled		1307155	1307165	1307175	1307185
Gas-cooled with wire feed case (S)		1307157	1307167	1307177	1307187
Compact water-cooled (W)		1307156	1307166	1307176	1307186
Water-cooled with wire feed case (WS)		1307158	1307168	1307178	1307188

Operation as standard in wire feed case. Choose undercarriage separate.

Information on the control panel can be found on page 12

See pages 14-15 for information about the various undercarriage options.

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

W = with water cooling, WS = with water cooling and separate wire feed case, S = with separate wire feed case

OPTIONS

Housing	see page 16

INTERMEDIATE HOSE PACK SELECTION TABLE

Intermediate hose pack selection table	see page 16

ACCESSORIES

Intermediate hose pack gas-cooled Intermediate hose pack water-cooled Torch MIG / MAG gas-cooled Torch MIG / MAG water-cooled Wear parts sets for torch Earth cable Pressure reducer Basket spool adapter Gas hose Cooling liquid Remote control Undercarriage	see pages 16-18

FEED ROLLERS FOR WIRE FEED UNIT

Single feed rollers for massive wire Single feed rollers for tube wire Single feed rollers for aluminium wire	see page 18

UPGRADE EQUIPMENT

Wire feed case Interfaces	see page 19

SPARE PARTS FOR WIRE FEED UNIT

Spare parts for wire feed unit	see page 19

Eco-designed with savings potential

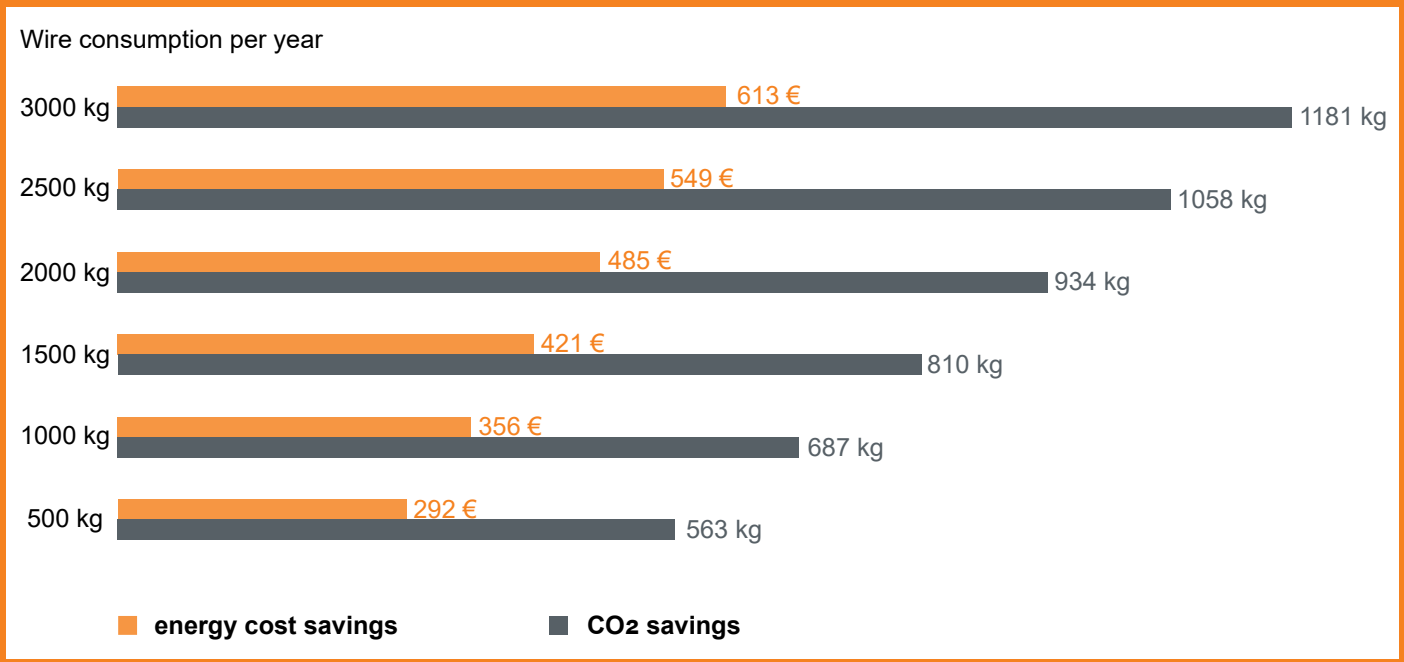
Top technology „Made in Germany“

Thanks to its high efficiency, the SYNERGIC.ARC meets all the requirements of the EU directive for eco-design*

- **≥ 85 % efficiency**
- **≤ 50 W stand-by**
- Up to **30 % energy savings during welding** compared to existing devices
- Up to **80 % energy savings at idle,** thanks to intelligent stand-by management
- **Maximum duty cycle** thanks to the low-loss REHM inverter

*Directive 2009/125/EC of the European Parliament and of the Council of October, 21st, 2009

Cost savings through reduced energy consumption and saving of environmentally harmful CO_2 through the use of state-of-the-art inverter technology.



NEW PRODUCT

MIG / MAG-welding with the best in its class!

The new SYNERGIC.ARC series

Find the right performance class for you and experience the best heavy duty machines for MIG / MAG welding.
The SYNERGIC.ARC convinces with its robustness and durability as well as perfect welding results and easy operation!

SIRIUS

FOCUS.ARC

ÖKO DESIGNED EU-Konform

SYNERGIC.ARC 304-504 WS - Heavy duty machines
for tough industrial use

SYNERGIC.ARC 251-351 - The all-rounders for industry and craft,
for thin sheet metal and medium sheet thicknesses

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL SYNERGIC.ARC SERIES

Another brilliant operation from REHM

SIRIUS shows at SYNERGIC.ARC its strengths: with two operators in one machine.
And thanks to the 7-inch display, you always have everything in view, even from a great distance.

Further information on the SIRIUS operating system can be found on pages 06-07.

1 Menu button | 2 Home button | 3 Return button | 4 QUICK CHOICE buttons | 5 Selection buttons

Figure: Operation 1, based on stepless devices

6 R-Pilot encoder | 7 Impact-protected full colour display | Self-explanatory presentation | Dynamic displays | Smart Assist function

Figure: Operation 2, based on step-switched devices

NEW PRODUCT

The heavy duty machines for tough industrial use:

SYNERGIC.ARC 304-504 WS

The high-quality and robust components used in the SYNERGIC.ARC can be used even in tough use.

- With FOCUS.ARC, the welding process for more performance in conventional welding.
- Highest continuous load.
- Robust and proven 4-roller wire drive.
- Undercarriage with large wheels (front 160 mm, rear 250 mm), designed for 50 l gas bottles.
- The entire control panel is built for tough use.
- Increasing the reach of the feed case by connecting the intermediate hose package on the front.

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

SYNERGIC.ARC 304-504 WS

TECHNICAL DATA		304	404	504
Setting range	[A]	20-300	20-400	20-500
Duty cycle (ED) at Imax.	[%]	50		30
Welding current at 100 % ED	[A]	270	330	400
Wire feed		4 rollers		
Mains connection	[V]	3 x 400		
Fuse	[A]	32		
Torch cooling		gas / water		water
Protection type		IP 23		
Weight power source without undercarriage	[kg]			
Compact gas-cooled		46		-
Compact water-cooled (W)		56		
With wire feed unit gas-cooled (S)		57		-
With wire feed unit water-cooled (WS)		70		
Dimensions power source LxWxH	[mm]			
Compact (with floor stand)		640 x 340 x 720		
With wire feed unit (with floor stand)		640 x 340 x 1,280		
Compact (with undercarriage)		950 x 560 x 920		
With wire feed unit (with undercarriage)		950 x 560 x 1,480		
Item no.				
Compact gas-cooled		1122240	1122260	-
Gas-cooled with wire feed unit (S)		1122242	1122262	-
Compact water-cooled (W)		1122241	1122261	1122265
Water-cooled with wire feed unit (WS)		1122243	1122263	1122267

RECOMMENDED PREMIUM SET (only available in combination with welding machines)	Item no.	Recommended for
RC SET 1 RC 24/4/UD MaKa 25mm² Drumi	1184250	304, 304 S
RC SET 2 RC 36/4/UD MaKa 50mm² Drumi	1184251	404, 404 S
RC SET 3 RC 240W/4/UD MaKa 50mm² Drumi	1184252	304 W, 304 WS
RC SET 4 RC 401W/4/UD MaKa 70mm² Drumi	1184253	404 W, 404 WS, 504 W, 504 WS

Sets consist of: REHM RC torch 4 m with Up/Down module, earth cable 4 m, pressure reducer

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

W = with water cooling, WS = with water cooling and separate wire feed case, S = with separate wire feed case

OPTIONS

	Item no.
Housing	
Floor stand SA	1381110
Operation in the machine SA	1381111
Top shock proof cover display SA	1381113
Bottom shock proof cover display SA	1381114
Toolbox for compact machines SA	1381115
Holder for torch and hose pack	1180214
Air pre-filter	1381144
Crane lifting lugs for wire feed unit	1381146
Drum wire feed through (wire feed unit)	1381147
Option undercarriage for wire feed case	1381150
Option undercarriage Advance (Undercarriage is equipped with brakes and ramp)	1381119
Option reverse pole + electrode	1381121
Option gas preheater gas cooled SA	1381120
Option gas preheater water cooled SA	1381117
Premium sets (only available in combination with welding machines)	
Option RC SET 1 RC 24/4/UD MaKa 25mm² Drumi	1184250
Option RC SET 2 RC 36/4/UD MaKa 50mm² Drumi	1184251
Option RC SET 3 RC 240W/4/UD MaKa 50mm² Drumi	1184252
Option RC SET 4 RC 401W/4/UD MaKa 70mm² Drumi	1184253
Option RC SET 5 RC 555W/4/UD MaKa 95mm² Drumi	1184254
Option RC SET 6 RC 26/4/UD MaKa 35mm² Drumi	1184255
Pressure reducer in the Netherlands version instead of standard	1180050
Pressure reducer in the GUS version instead of standard	1180052

ACCESSORIES

	Item no.
Intermediate hose pack gas-cooled	
Intermediate hose pack MIG/MAG 50mm² 1,5m G 12p FA/MA/SA/SP	7505000
Intermediate hose pack MIG/MAG 50mm² 5m G 12p FA/MA/SA/SP	7505001
Intermediate hose pack MIG/MAG 50mm² 10m G 12p FA/MA/SA/SP	7505002
Intermediate hose pack MIG/MAG 70mm² 1,5m G 12p FA/MA/SA/SP	7505010
Intermediate hose pack MIG/MAG 70mm² 5m G 12p FA/MA/SA/SP	7505011
Intermediate hose pack MIG/MAG 70mm² 10m G 12p FA/MA/SA/SP	7505012
Intermediate hose pack MIG/MAG 70mm² 15m G 12p FA/MA/SA/SP	7505013
Intermediate hose pack MIG/MAG 70mm² 20m G 12p FA/MA/SA/SP	7505014
Intermediate hose pack MIG/MAG 95mm² 10m G 12p FA/MA/SA/SP	7505022
Intermediate hose pack water-cooled	
Intermediate hose pack MIG/MAG 50mm² 1,5m W 12p FA/MA/SA/SP	7505030
Intermediate hose pack MIG/MAG 50mm² 5m W 12p FA/MA/SA/SP	7505031
Intermediate hose pack MIG/MAG 50mm² 10m W 12p FA/MA/SA/SP	7505032
Intermediate hose pack MIG/MAG 70mm² 1,5m W 12p FA/MA/SA/SP	7505040
Intermediate hose pack MIG/MAG 70mm² 5m W 12p FA/MA/SA/SP	7505041
Intermediate hose pack MIG/MAG 70mm² 10m W 12p FA/MA/SA/SP	7505042
Intermediate hose pack MIG/MAG 70mm² 15m W 12p FA/MA/SA/SP	7505043
Intermediate hose pack MIG/MAG 70mm² 20m W 12p FA/MA/SA/SP	7505044
Intermediate hose pack MIG/MAG 95mm² 1,5m W 12p FA/MA/SA/SP	7505050
Intermediate hose pack MIG/MAG 95mm² 5m W 12p FA/MA/SA/SP	7505051
Intermediate hose pack MIG/MAG 95mm² 10m W 12p FA/MA/SA/SP	7505052
Intermediate hose pack MIG/MAG 95mm² 15m W 12p FA/MA/SA/SP	7505053
RC torch MIG / MAG gas-cooled	
Torch RC MAG-24 4m U/D	7601530
Torch RC MAG-26 4m U/D	7601532
Torch RC MAG-36 4m U/D	7601531
Torch MIG / MAG gas-cooled	
Torch MAG MB 25D 3m G 50° KGK	7601564
Torch MAG MB 25D 4m G 50° KGK	7602546
Torch MAG MB 25D 5m G 50° KGK	7601565
Torch MAG MB 26D 3m G 50° KGK	7601569
Torch MAG MB 26D 4m G 50° KGK	7601570
Torch MAG MB 26D 5m G 50° KGK	7601562
Torch MAG MB 36D 3m G 50° KGK	7601571
Torch MAG MB 36D 4m G 50° KGK	7601561
Torch MAG MB 36D 5m G 50° KGK	7601572
RC torch MIG / MAG water-cooled	
Torch RC MAG-240W 4m U/D	7601750
Torch RC MAG-401W 4m U/D	7601751
Torch RC MAG-555W 4m U/D	7601752

ACCESSORIES

	Item no.
Torch MIG / MAG water-cooled	
Torch MAG W 340D 3m	7601716
Torch MAG W 340D 4m	7601718
Torch MAG W 340D 5m	7601720
Torch MAG W 440D 3m	7601722
Torch MAG W 440D 4m	7601724
Torch MAG W 440D 5m	7601726
Torch MAG W 540D 3m	7601728
Torch MAG W 540D 4m	7601730
Torch MAG W 540D 5m	7601732
Wear part sets for torch	
Wear parts set RC/MB 24D/240W	7700416
Wear parts set MB 25D	7700417
Wear parts set RC/MB 26D	7700418
Wear parts set RC/MB 36D	7700419
Wear parts set RC/MB 401WD/501WD	7700421
Wear parts set RC/MB 555WD	7700429
Wear parts set W 340	7700621
Wear parts set W 440	7700622
Wear parts set W 540	7700623
Earth cable	
Earth cable 16mm² 4m 13mm with 200A clamp	7810100
Earth cable 25mm² 4m 13mm with 400A clamp	7810101
Earth cable 35mm² 4m 13mm with 400A clamp	7810102
Earth cable 50mm² 4m 13mm with 500A clamp	7810109
Earth cable 70mm² 4m 13mm with 600A clamp	7810104
Earth cable 95mm² 4m 13mm with 600A clamp	7810106
Pressure reducer	
Pressure reducer Optimator Argon/CO_2	7967932
Pressure reducer Arg/CO_2 G1/4" 0-30/200bar	7530500
Pressure reducer Arg/CO_2 G3/8" 0-30/200bar NL	7830164
Basket spool adapter	
Basket spool adapter Industrie	7516000
Basket spool adapter Professional	7516004
Gas hose	
Gas hose ISO3821 6x3.5 2x 1/4" 1.8m	3250001
Inert gas filter G1/4" RH	7501111
Cooling liquid	
Cooling liquid, RCL, 5l	1680051
Cooling liquid, RCL, 25l	1680251
Housing	
Bracked for intermediate hose SYNERGIC.ARC	2109104

FEED ROLLER FOR WIRE FEED UNIT

	Item no.
Single feed rollers for massive wire	
Feed roller 0,6/0,8mm massive 4/2	7503054
Feed roller 0,8/1,0mm massive 4/2	7503055
Feed roller 1,0/1,2mm massive 4/2	7503053
Feed roller 1,2/1,6mm massive 4/2	7503056
Feed roller 0,9/1,1mm massive 4/2	7503065
Single feed rollers for tube wire	
Feed roller 1,2/1,6mm tube 4/2	7503066
Single feed rollers for aluminium wire	
Feed roller A 1,0/1,2mm alu 4/2	7503069
Feed roller A 1,2/1,6mm alu 4/2	7503070
Feed roller A 1,6/2,4mm alu 4/2	7503071

UPGRADE EQUIPMENT

	Item no.
Housing	
Retrofit kit air pre-filter	7501132
Metal filter cell M2	7503057
Retrofit kit holder for torch and hose pack	7501129
Wire feed case	
Retrofit kit driving carriage for wire feed case SP²/MA²	7501502

SPARE PARTS FOR WIRE FEED UNIT

	Item no.
Capillary tube up to 1,6mm	7503067
Support tube for teflonfeeder up to 4mm outer diameter	7503068
Pressure arm set plastic SF SS4 right / left complete	4000201
Inlet blue ID ø 2.0mm	4000222
Middle wire feed, blue, ID ø 2.0mm	4000223
Pressure unit complete, red SS4-ST4	4000220

The new REHM torch range RC is the ideal addition to the SYNERGIC.ARC range of applications.

The advantages of REHM RC torches:

- Robust, ergonomically shaped handle shell
- High-dimensioned cables for welding current
- Buckling-resistant lines for coolant transport
- No additional control cables required
- No manufacturer-specific wear parts required

With the RC torches, the welding current on the SYNERGIC.ARC can be infinitely adjusted.
Or be switched between the stages at lightning speed, in step-switched operating mode.

REHM RC torches save money

All REHM SYNERGIC.ARC can be fitted with a REHM RC torch set.
This means enormous potential for the user compared to a device without an RC torch or a step-switched device.
With just 5 changes of setting per hour, you save around €400 a year.

SET VARIANTS (Sets consist of: REHM RC torch 4 m with Up/Down module, earth cable 4 m, pressure reducer)

Designation	Item no.
RC SET 1 RC 24/4/UD MaKa 25mm² Drumi	1184250
RC SET 2 RC 36/4/UD MaKa 50mm² Drumi	1184251
RC SET 3 RC 240W/4/UD MaKa 50mm² Drumi	1184252
RC SET 4 RC 401W/4/UD MaKa 70mm² Drumi	1184253
RC SET 5 RC 555W/4/UD MaKa 95mm² Drumi	1184254
RC SET 6 RC 26/4/UD Maka 35mm² Drumi	1184255

REHM RC TORCHES

Designation	Cooling	Imax. CO_2	Imax. Mixgas	Duty cycle	Item no.
Torch RC MAG-24 4m U/D	Gas	250 A	220 A	60 %	7601530
Torch RC MAG-26 4m U/D	Gas	270 A	240 A	60 %	7601532
Torch RC MAG-36 4m U/D	Gas	320 A	290 A	60 %	7601531
Torch RC MAG-240W 4m U/D	Water	300 A	270 A	100 %	7601750
Torch RC MAG-401W 4m U/D	Water	400 A	350 A	100 %	7601751
Torch RC MAG-555W 4m U/D	Water	550 A	500 A	100 %	7601752

NEW PRODUCT

The all-rounders among the workshop machines!

SYNERGIC.ARC 251-351

The right choice for industry and craft when it comes to thin sheet metal and medium sheet thicknesses.

- ✓ Simple welding parameter setting through predefined synergy characteristics.
- ✓ Pre-programmed settings for weldable materials (Fe, CrNi, Alu, CuSi3).
- ✓ Optimum arc even with filigree applications.
- ✓ Easily fit under any workbench.
- ✓ Robust and proven 4-roller wire drive.
- ✓ The undercarriage is designed for 20 l gas bottles.
- ✓ Equipped with 2 operating variants as standard.

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

SYNERGIC.ARC 251-351

TECHNICAL DATA		251	311	351
Setting range	[A]	20-250	20-300	20-350
Duty cycle (ED) at Imax.	[%]		40	
Welding current at 100 % ED	[A]	200	240	280
Wire feed			4 rolls	
Mains connection	[V]		3 x 400	
Fuse	[A]	16	32	
Torch cooling			Gas	
Protection type			IP 23	
Weight power source with undercarriage	[kg]			
Compact gas-cooled			50	
Dimensions power source LxWxH	[mm]			
Compact gas-cooled			830 x 340 x 710	
Item no.				
Compact gas-cooled		1122230	1122231	1122232

RECOMMENDED PREMIUM SET (only available in combination with welding machines)	Item no.	Recommended for
RC SET 1 RC 24/4/UD MaKa 25mm² Drumi	1184250	251, 311
RC SET 2 RC 36/4/UD MaKa 50mm² Drumi	1184251	351

Sets consist of: REHM RC torch 4 m with Up/Down module, earth cable 4 m, pressure reducer

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

OPTIONS

	Item no.
Housing	
Holder for torch and hose pack	1180214
Bottom shock proof cover display SA	1381114
Toolbox for compact machines SA	1381115
Option reverse pole + electrode	1381121
Air pre-filter	1381144
Premium sets (only available in combination with welding machines)	
Option RC SET 1 RC 24/4/UD MaKa 25mm² Drumi	1184250
Option RC SET 2 RC 36/4/UD MaKa 50mm² Drumi	1184251
Option RC SET 6 RC 26/4/UD MaKa 35mm² Drumi	1184255
Pressure reducer in the Netherlands version instead of standard	1180050
Pressure reducer in the GUS version instead of standard	1180052

ACCESSORIES

	Item no.
RC torch MIG / MAG gas-cooled	
Torch RC MAG-24 4m U/D	7601530
Torch RC MAG-26 4m U/D	7601532
Torch RC MAG-36 4m U/D	7601531
Wear part sets for torch	
Wear parts set RC/MB 24D/240W	7700416
Wear parts set RC/MB 26D	7700418
Wear parts set RC/MB 36D	7700419
Earth cable	
Earth cable 25mm² 4m 13mm with 400A clamp	7810101
Earth cable 35mm² 4m 13mm with 400A clamp	7810102
Earth cable 50mm² 4m 13mm with 500A clamp	7810109
Earth cable 70mm² 4m 13mm with 600A clamp	7810104
Pressure reducer	
Pressure reducer Optimator Argon/CO_2	7967932
Pressure reducer Arg/CO_2 G1/4" 0-30/200bar	7530500
Pressure reducer Arg/CO_2 G3/8" 0-30/200bar NL	7830164
Basket spool adapter	
Basket spool adapter Industrie	7516000
Basket spool adapter Professional	7516004
Gas hose	
Gas hose ISO3821 6x3.5 2x 1/4" 1.8m	3250001
Inert gas filter G1/4" RH	7501111

FEED ROLLER FOR WIRE FEED UNIT

	Item no.
Single feed rollers for massive wire	
Feed roller 0,6/0,8mm massive 4/2	7503054
Feed roller 0,8/1,0mm massive 4/2	7503055
Feed roller 1,0/1,2mm massive 4/2	7503053
Feed roller 1,2/1,6mm massive 4/2	7503056
Feed roller 0,9/1,1mm massive 4/2	7503065
Single feed rollers for tube wire	
Feed roller 1,2/1,6mm tube 4/2	7503066
Single feed rollers for aluminium wire	
Feed roller A 1,0/1,2mm alu 4/2	7503069
Feed roller A 1,2/1,6mm alu 4/2	7503070
Feed roller A 1,6/2,4mm alu 4/2	7503071

UPGRADE EQUIPMENT

	Item no.
Housing	
Retrofit kit air pre-filter	7501132

SPARE PARTS FOR WIRE FEED UNIT

	Item no.
Capillary tube up to 1,6mm	7503067
Support tube for teflonfeeder up to 4mm outer diameter	7503068
Pressure arm set plastic SF SS4 right / left complete	4000201
Inlet blue ID ø 2.0mm	4000222
Middle wire feed, blue, ID ø 2.0mm	4000223
Pressure unit complete, red SS4-ST4	4000220

TIG
WELDING EQUIPMENT

// Higher productivity

// Faster welding processes

// Uniform quality

REHM – The benchmark for modern welding

NEW PRODUCT

Cutting-edge inverter technology and SIRIUS:

INVERTIG i 260-450 DC and AC/DC HIGH

The INVERTIG i represents REHM's fourth SIRIUS generation.
It offers the user even more options for achieving the best welding results quickly and reliably in the easiest way.

The new HIGH series impresses with its **ease of use** and the **best energy efficiency** as well as a **large number of welding processes**, in which all the know-how and experience of us as a technology leader in the TIG area is invested.

SIRIUS

FOCUS.ARC

ÖKO DESIGNED EU-Konform

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL INVERTIG i

Further information on the SIRIUS operating system can be found on pages 06-07.

1 Menu button | 2 Home button | 3 Return button | 4 QUICK CHOICE buttons | 5 Selection buttons

6 R-Pilot encoder | 7 Impact-protected full colour display | Self-explanatory presentation | Dynamic displays | Smart assist feature

QUICK CHOICE buttons

The Quick Choice buttons that REHM first introduced on its welding equipment in 2008 make it extremely easy to save and call up programs in the INVERTIG i.

INVERTIG i 260-450 DC and AC/DC HIGH

TECHNICAL DATA		260 DC + AC/DC HIGH	310 DC + AC/DC HIGH	350 DC + AC/DC HIGH	450 DC + AC/DC HIGH
Setting range	[A]	5-260	5-310	5-350	5-450
Duty cycle (ED) at Imax.	[%]	80			45
Welding current at 100 % ED	[A]	230	290	340	400
Open-circuit voltage	[V]	88.5			
Mains voltage	[V]	3 x 400			
Mains voltage tolerance	[%]	+15 / -25			
Fuse (slow-blow)	[A]	16		32	
Protection type		IP 23			
Power factor	[cos phi]	0.99			
Power consumption at Imax.	[kVA]	6.5	8.5	10.2	15.1
Power consumption at 100 % duty cycle	[kVA]	5.5	7.7	9.7	12.5
Weight without undercarriage	[kg]				
Water-cooled DC		55			59
Water-cooled AC/DC		56			60
Dimensions LxWxH	[mm]				
Without undercarriage		570 x 330 x 580			
Undercarriage Advanced		900 x 560 x 1,020			
Undercarriage Profi		950 x 611 x 1,100			
Upright stand		544 x 30 x 43			
Item no.					
DC		1422526	1422531	1422535	1422545
AC/DC		1422528	1422533	1422537	1422547

RECOMMENDED PREMIUM SET (only available in combination with welding machines)	Item no.	Recommended for
Premium set 251W UD 8m/35mm² Drumi	1184260	260 DC, 260 AC/DC
Premium set 301W UD 8m/50mm² Drumi	1184261	310 DC, 310 AC/DC 350 DC, 350 AC/DC
Premium set 451W UD 8m/70mm² Drumi	1184262	450 DC, 450 AC/DC

Sets consist of: TIG torch R-TIG 8 m with Up/Down module, earth cable 4 m, pressure reducer

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

OPTIONS

	Item no.
Housing	
Holder for torch and hose pack	1180214
Without undercarriage	1381100
Undercarriage Profi (50 l)	1381101
Undercarriage Advanced (50 l with loading rack and fixing brake)	1381102
Bottom shock proof cover display	1381108
Toolbox for compact machines	1381143
Air pre-filter	1381144
Premium-Sets (nur in Verbindung mit Schweißgerät bestellbar)	
Premium set 251W UD 8m/35mm²	1184260
Premium set 301W UD 8m/50mm²	1184261
Premium set 451W UD 8m/70mm²	1184262
Premium set 260W SC UD 8m/50mm²	1184265
Premium set 450W SC UD 8m/95mm²	1184266
Pressure reducer in the Netherlands version instead of standard	1180050
Pressure reducer in the GUS version instead of standard	1180052

ACCESSORIES

	Item no.
Torch TIG water-cooled with REHM Quick Connect	
Torch TIG R TIG-251w 19 4m UD HF	7636220
Torch TIG R TIG-251w 19 8m UD HF	7636225
Torch TIG R TIG-251w 19 4m DD HF	7636260
Torch TIG R TIG-251w 19 8m DD HF	7636265
Torch TIG R TIG-301w 19 4m UD HF	7636230
Torch TIG R TIG-301w 19 8m UD HF	7636235
Torch TIG R TIG-301w 19 4m DD HF	7636270
Torch TIG R TIG-301w 19 8m DD HF	7636275
Torch TIG R TIG-451w 19 4m UD HF	7636290
Torch TIG R TIG-451w 19 8m UD HF	7636295
Torch TIG R TIG-451w 19 4m DD HF	7636280
Torch TIG R TIG-451w 19 8m DD HF	7636285
Torch TIG extraction torch water-cooled with REHM Quick Connect (only in connection with an extraction system)	
Torch TIG RAB R TIG-301w 4m U/D HF	7600580
Torch TIG RAB R TIG-301w 4m U/D HF	7600581
Wear part sets for torch	
Wear parts set R SR 20	7700440
Earth cable	
Earth cable 35mm² 4m 13mm with 400A clamp	7810102
Earth cable 50mm² 4m 13mm with 500A clamp	7810109
Earth cable 70mm² 4m 13mm with 600A clamp	7810104
Earth cable 95mm² 4m 13mm with 600A clamp	7810106
Pressure reducer	
Pressure reducer Optimator Argon/CO_2	7967932
Pressure reducer Arg/CO_2 G1/4" 0-30/200bar	7530500
Pressure reducer Arg/CO_2 G3/8" 0-30/200bar NL	7830164
Gas hose	
Gas hose ISO3821 6x3.5 2x 1/4" 1.8m	3250001
Inert gas filter G1/4" RH	7501111
Cooling liquid	
Cooling liquid, RCL, 5l	1680051
Cooling liquid, RCL, 25l	1680251

ACCESSORIES

	Item no.
Remote control	
Foot remote control TIGER® 180/182/230	7531051
Torch adapter cable	
Torch duo-cable 19 pin (foot remote control+torch) For simultaneous use of foot remote control and torch trigger	3600615
Torch adapter cable for INVERTIG.PRO® 12 pin to TIGER® 19 pin For use with torches with 12-pin plug (INVERTIG.PRO)	3600650

UPGRADE EQUIPMENT

	Item no.
Housing	
Retrofit kit shock proof cover display top/bottom	7501130
Retrofit kit holder for torch and hose pack	7501129
Retrofit kit air pre-filter	7501132
Metal filter M2	7503057
Retrofit kit toolbox for compact machines	7501131

ULTRA and HIGH versions

ULTRA version:
- Everything you could wish for
- Full range of functions
- High-end for mobile TIG welding

HIGH version:
- Alternative, optimised for pipeline construction and assembly areas

REHM TIGER® ULTRA / HIGH features

Function	ULTRA	HIGH
Gas pre-flows	Yes	Fix
Ignition power	Yes	Fix
Starting current	Yes	Fix
Starting current time	Yes	Fix
Upslope	Yes	Fix
Welding current 1	Yes	Yes
Pulse time 1	Yes	Yes
Welding current 2	Yes	Yes
Pulse time 2	Yes	Yes
Time pulses	Yes	Yes
HYPER.PULS	Yes	No
HYPER.PULS frequency	Yes	No
Downslope	Yes	Yes
End-crater current	Yes	Yes
End-crater current time	Yes	No
Gas post flow time	Yes	Yes
TIG with HF	Yes	Yes
TIG without HF	Yes	Yes
TIG DC	Yes	Yes
TIG AC	Yes	Yes
Current display	Yes	Yes

Function	ULTRA	HIGH
DualWave	Yes	No
AC time DualWave	Yes	No
DC time DualWave	Yes	No
Electrode with safety hold	Yes	Yes
Electrode with booster function	Yes	Yes
2 cycle with/without HF	Yes	Yes
4 cycle with/without HF	Yes	Yes
Spot welding	Yes	Yes
Interval welding	Yes	No
Spot welding time	Yes	Fix
Interval Pause time	Yes	No
AC waveform	Yes	Auto
AC balance	Yes	Yes
AC frequency	Yes	Yes
Automatic frequency adjustment	Yes	Yes
UP/Down control	Yes	Yes
P1 to P4	Yes	Yes
Assist	Yes	Yes
Program memory	Yes	No
Setup	Yes	Yes

The benchmark in the TIG compact class:

TIGER® *digital*

Thanks to the record-breaking lightweight, the primary TIG inverter is ideal for portable use.
The integrated process options, ranging from the HYPER.SPOT to REHM 17.5 kHz HYPER.PULS process, are the benchmark in the TIG compact class.
The TIGER® is available in DC and AC/DC as well as optionally with a very light, modular cooling unit.

- ✓ Maximum mobility thanks to compact design and light weight.
- ✓ Problem-free working with extension cables up to 100 m.
- ✓ Very light, modular cooling unit (optional).
- ✓ Can be used anywhere thanks to PFC.
- ✓ Robust, functional design protects even in the case of falls from a height of 90 cm.
- ✓ Easier mobile use thanks to a comfortable carrying strap and a secure grip.
- ✓ Ventilation system protects the inside of the device from dust and dirt particles.
- ✓ Practical, integrated drawer under the handle.

THE LIGHTEST TIG-DEVICE IN HIS CLASS
from 7.5 kg
TIGER
The benchmark for modern welding

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL TIGER® *digital*

Intuitive operating concept for optimised TIG welding

The user-friendliness of the welding equipment and the clear design of the display contribute significantly to efficiency when TIG welding. The REHM Inverter TIGER® *digital* fulfils these requirements through its intelligent and patented display design.

Further information on the SIRIUS operating system can be found on pages 06-07.

1 QUICK CHOICE buttons | 2 Selection buttons | 3 R-Pilot encoder | 4 Home button | 5 Menu button

Figure: ULTRA version

6

- Impact protected full colour display
- Self-explanatory presentation
- Dynamic displays
- Smart Assist feature

TIGER® *digital* 182/230 DC and AC/DC

TECHNICAL DATA		182 DC + AC/DC HIGH *digital*	182 DC + AC/DC ULTRA *digital*	230 DC + AC/DC HIGH *digital*	230 DC + AC/DC ULTRA *digital*
Setting range TIG Electrode BOOSTER Electrode (fuse hold operation)	[A]	4-180 20-150 20-140		4-230 20-180 20-150	
Duty cycle (ED) at Imax. TIG Electrode BOOSTER Electrode (fuse hold operation)	[%]	40 30 60		35 40 60	
Weld current at 100 % ED TIG Electrode (BOOSTER) Electrode (fuse hold operation)	[A]	140 130 130		160 140 140	
Fuse	[A]	16			
Torch cooling		Gas			
Protection type		IP 23 S			
Power factor	[cos phi]	0.99			
Power consumption at Imax.	[kVA]	6.1		5.8	
Mains connection	[V]	1 x 230			
Mains frequency	[Hz]	50 / 60			
Insulation class		F			
Control socket	[pin.]	19			
Welding cable socket	[mm]	13			
Weight DC AC/DC	[kg]	7.5 7.9			
Dimension LxWxH	[mm]	480 x 160 x 320			
Item no.					
DC without accessories		1503518	1503519	1503555	1503556
AC/DC without accessories		1503528	1503529	1503565	1503566
		Set options see page 48			

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1, EN 60 974-2, EN 60 974-9 and EN 60 974-10 standards.

ADDITIONAL EQUIPMENT

Figure: RWK mobile with TIGER *digital* 182/230

	Item no.
Water cooling unit to attach to TIGER® for mobile use	
RWK mobile TIGER 180/182/230 (with centrifugal pump and energy management)	7532316

OPTIONS

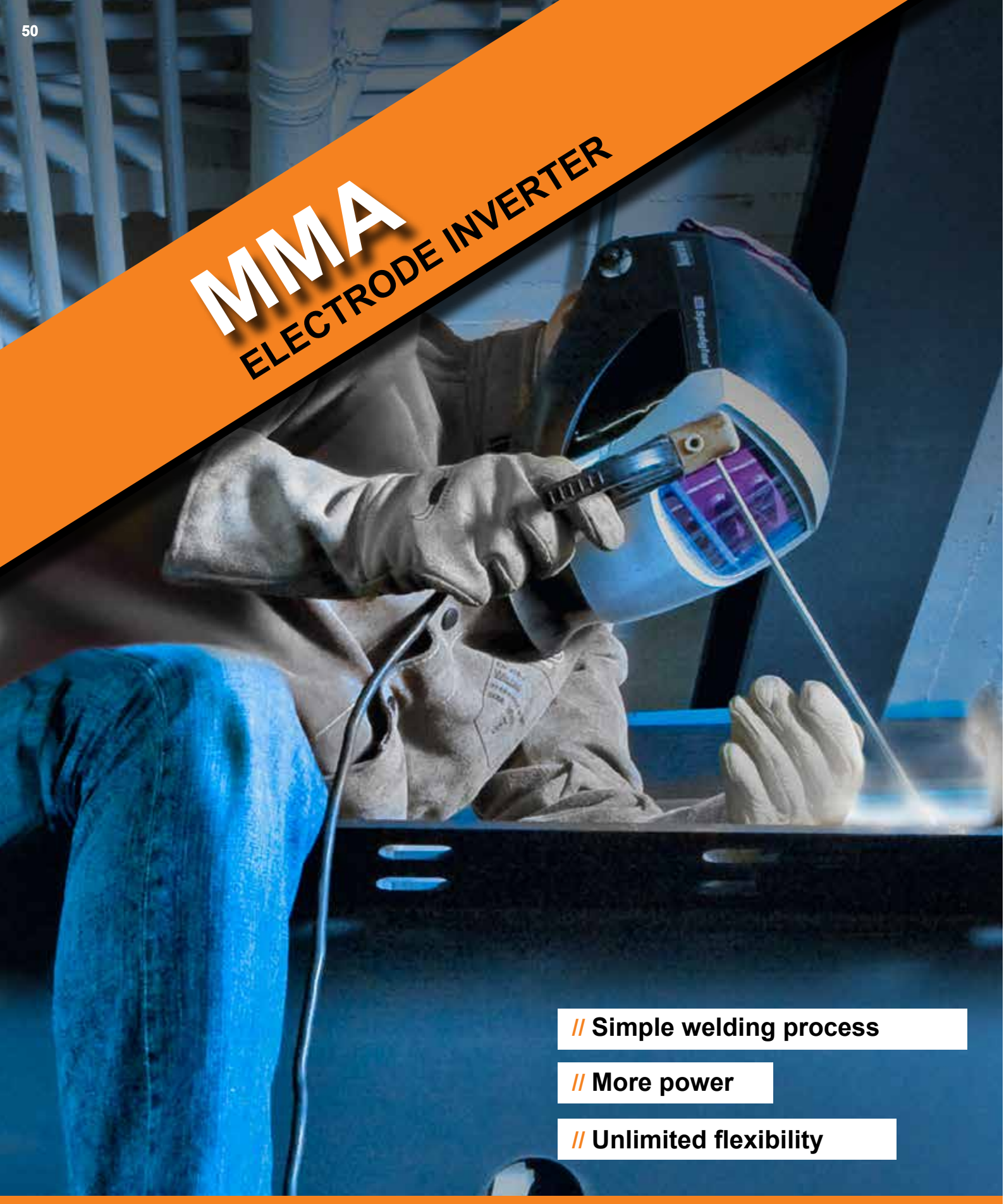
	Item no.
Set (only available in combination with welding machines)	
SET TIGER digital standard (without machine) Torch R TIG 211 19 4m UD HighFlex leather, earth cable 25 mm², pressure reducer 200 bar, 32 l/min, case	1485440
Set TIGER digitally configured (without machine) with case and earth cable 25 mm²	1485442
Pressure reducer in the Netherlands version instead of standard	1180050
Pressure reducer in the GUS version instead of standard	1180052
Water cooling	
Cooling device connection RWK mobile TIGER 180/182/230	1480197

ACCESSORIES

	Item no.
Torch TIG with 19 pins connector for TIGER® 180/182/230, gas-cooled up to max. 150A DC	
Torch TIG R TIG-141 19 4m UD HF	7636200
Torch TIG R TIG-141 19 8m UD HF	7636205
Torch TIG R TIG-141 19 4m DD HF	7636240
Torch TIG R TIG-141 19 8m DD HF	7636245
Torch TIG R SR 17 19 4m UD HF	7631848
Torch TIG R SR 17 19 8m UD HF	7631849
Torch TIG R TIG 150 19 4m UD GL HF	7631802
Torch TIG R TIG 150 19 8m UD GL HF	7631803
Torch TIG with 19 pins connector for TIGER® 180/182/230, gas-cooled up to max. 240A DC	
Torch TIG R TIG-211 19 4m UD HF	7636210
Torch TIG R TIG-211 19 8m UD HF	7636215
Torch TIG R TIG-211 19 4m DD HF	7636250
Torch TIG R TIG-211 19 8m DD HF	7636255
Torch TIG AE 210 19 4m UD HF	7633133
Torch TIG AE 210 19 8m UD HF	7633134
Torch TIG R SR 26 19 4m UD HF	7631850
Torch TIG R SR 26 19 8m UD HF	7631851
Torch TIG R TIG 200 19 4m UD G HF	7631804
Torch TIG R TIG 200 19 8m UD G HF	7631805

ACCESSORIES

	Item no.
Torch TIG with 19 pins connector for TIGER® 180/182/230, water-cooled	
Torch TIG R TIG-251w 19 4m UD HF	7636220
Torch TIG R TIG-251w 19 8m UD HF	7636225
Torch TIG R TIG-251w 19 4m DD HF	7636260
Torch TIG R TIG-251w 19 8m DD HF	7636265
Torch TIG R TIG-301w 19 4m UD HF	7636230
Torch TIG R TIG-301w 19 8m UD HF	7636235
Torch TIG R TIG-301w 19 4m DD HF	7636270
Torch TIG R TIG-301w 19 8m DD HF	7636275
Torch TIG R TIG-451w 19 4m UD HF	7636290
Torch TIG R TIG-451w 19 8m UD HF	7636295
Torch TIG R TIG-451w 19 4m DD HF	7636280
Torch TIG R TIG-451w 19 8m DD HF	7636285
Torch TIG AQ 310W 19 4m UD HF	7633135
Torch TIG AQ 310W 19 8m UD HF	7633136
Torch TIG R SR 20W 19 4m UD HF	7631852
Torch TIG R SR 20W 19 8m UD HF	7631853
Torch TIG R TIG 260W 19 4m UD GL HF	7631806
Torch TIG R TIG 260W 19 8m UD GL HF	7631807
Torch TIG R TIG 260SC 19 4m UD G HF	7631808
Torch TIG R TIG 260SC 19 8m UD G HF	7631809
Wear parts sets for torch	
Wear parts set R SR 17/26	7700435
Wear parts set R SR 20	7700440
Wear parts set R TIG 200	7700426
Wear parts set R TIG 150/260W	7700425
Earth cable	
Earth cable 25mm² 4 m 13mm with 400A clamp	7810101
Electrode cable	
Electrode cable 25mm² 5m 13mm with 260A clamp	7810201
Pressure reducer	
Pressure reducer Optimator Argon/CO_2	7967932
Pressure reducer Argon/CO_2 G1/4" 0-30/200bar	7530500
Pressure reducer Argon/CO_2 G3/8" 0-30/200bar NL	7830164
Mounting cases	
Mounting case T3	2600423
Casetrolley	2600455
Gas hose	
Gas hose ISO3821 6x3,5 2x 1/4" 1,8m	3250001
Inert gas filter G1/4" RH	7501111
Cooling liquid	
Cooling liquid, RCL, 5l	1680051
Cooling liquid, RCL, 25l	1680251
Remote control	
Foot remote control TIGER® 180/182/230	7531051
Adapter for accessories	
Torch duo-cable 19 pin TIGER® 180/182/230	3600615
Torch adapter cable for INVERTIG.PRO® 12 pin to TIGER® 19 pin	3600650
Torch adapter cable for TIGER® to TIGER® 19 pin water cooled	3600628
Torch adapter cable for TIGER® to TIGER®19 pin gas cooled	3600629
Undercarriage	
Universal undercarriage	8620717



MMA
ELECTRODE INVERTER

// Simple welding process

// More power

// Unlimited flexibility

REHM – The benchmark for modern welding

NEW PRODUCT

Electrode welding for professionals:

The new BOOSTER.PRO 230

SIRIUS

ENERGY EFFICIENCY by PFC

The BOOSTER.PRO 230 the lightweight with only 6.7 kg in the proven TIGER design.
The electrode welding machine for professionals - with a new, expanded range of functions.

- ✓ Fully digital technology
- ✓ Energy cost saving IMS-inverter technology with PFC
- ✓ Maximum mobility due to light weight
- ✓ Suitable for generators
- ✓ Works with 100 m mains cable
- ✓ With the wide-range voltage range suitable for worldwide use
- ✓ REHM Pre-Save-System protects the electronics from falls from up to 90 cm
- ✓ Integrated ventilation duct separates dirty cooling air from the electronics
- ✓ Large range of functions (time pulses, REHM HYPER.PULS as well as fuse hold, BOOSTER, VRD and TIG function)
- ✓ Synergy characteristics for basic and rutile electrodes
- ✓ Extensive setting parameters
  (Welding current, Hotstart, ArcForce, Anti-Stick, pulse times I1 and I2 as well as HYPER.PULS frequency up to 17,500 Hz)

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL BOOSTER.PRO 230

Further information on the SIRIUS operating system can be found on pages 06-07.

1

- Impact protected full colour display
- Self-explanatory presentation
- Dynamic displays

2 R-Pilot encoder

BOOSTER.PRO 230

TECHNICAL DATA		230
Setting range	[A]	
TIG		4-230
Electrode (BOOSTER)		20-180
Electrode (fuse hold operation)		20-150
Duty cycle (ED) at Imax.	[%]	
TIG		35
Electrode (BOOSTER)		40
Electrode (fuse hold operation)		60
Weld current at 100 % ED	[A]	
TIG		160
Electrode (BOOSTER)		140
Electrode (fuse hold operation)		140
Fuse	[A]	16
Protection type		IP 23S
Power factor	[cos phi]	0.99
Power consumption at Imax.	[kVA]	5.8
Mains connection	[V]	1 x 230
Mains frequency	[Hz]	50-60
Mains voltage tolerance	[%]	+15 / -25
Mains voltage tolerance with reduced power	[V]	110-260
Insulation class		F
Welding cable socket	[mm]	13
Weight	[kg]	6.7
Dimension LxWxH	[mm]	480 x 160 x 320
Item no.		
		1513240

Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

MMA electrode inverter
BOOSTER.PRO 230

OPTIONS

	Item no.
Set	
BOOSTER.PRO 230 Set incl. case, earth and electrode cable 25mm², wire brush, chipping hammer	1513241

ACCESSORIES

	Item no.
TIG torch with separate gas regulation	
Torch TIG R TIG 141 4m VS26 + gas 3m	7636186
Torch TIG R TIG 211 4m VS26 + gas 3m	7636174
Earth cable	
Earth cable 25mm² 4m 13mm with 400A clamp	7810101
Electrode cable	
Electrode cable 25mm² 5m 13mm with 260A clamp	7810201
Mounting case	
Mounting case T3	2600423
Casetrolley	2600455

Excellence technology cuts weight in half!

The electrode inverter BOOSTER2

At 2.3 kg the most portable and lightest booster from REHM. The simple handling of proven REHM technology enables you to start immediately. The optimal device for every requirement, whether in the workshop or on the construction site.

- Automatic Hot-Start
- Integrated Anti-Stick and ArcForce function
- Intelligent ignition management (ICS)
- Ultra-fast, low-induction inverter
- Generator compatible
- Fully insulated, protection class 2
- Fuse hold function

TECHNICAL DATA		150
Setting range	[A]	5-150
Duty cycle (ED) at Imax.	[%]	20
Weld current at 100 % ED	[A]	100
Weld current at 60 % ED	[A]	117
Fuse	[A]	16
Protection type		IP 23
Power factor	[cos phi]	0.7
Power consumption at Imax.	[kVA]	4.2
Mains connection	[V]	1 x 230
Mains frequency	[Hz]	50/60
Control socket	[pin.]	without
Welding cable socket	[mm]	9
Weight	[kg]	2.3
Dimension LxWxH	[mm]	275 x 120 x 185
Item no.		
		1503115

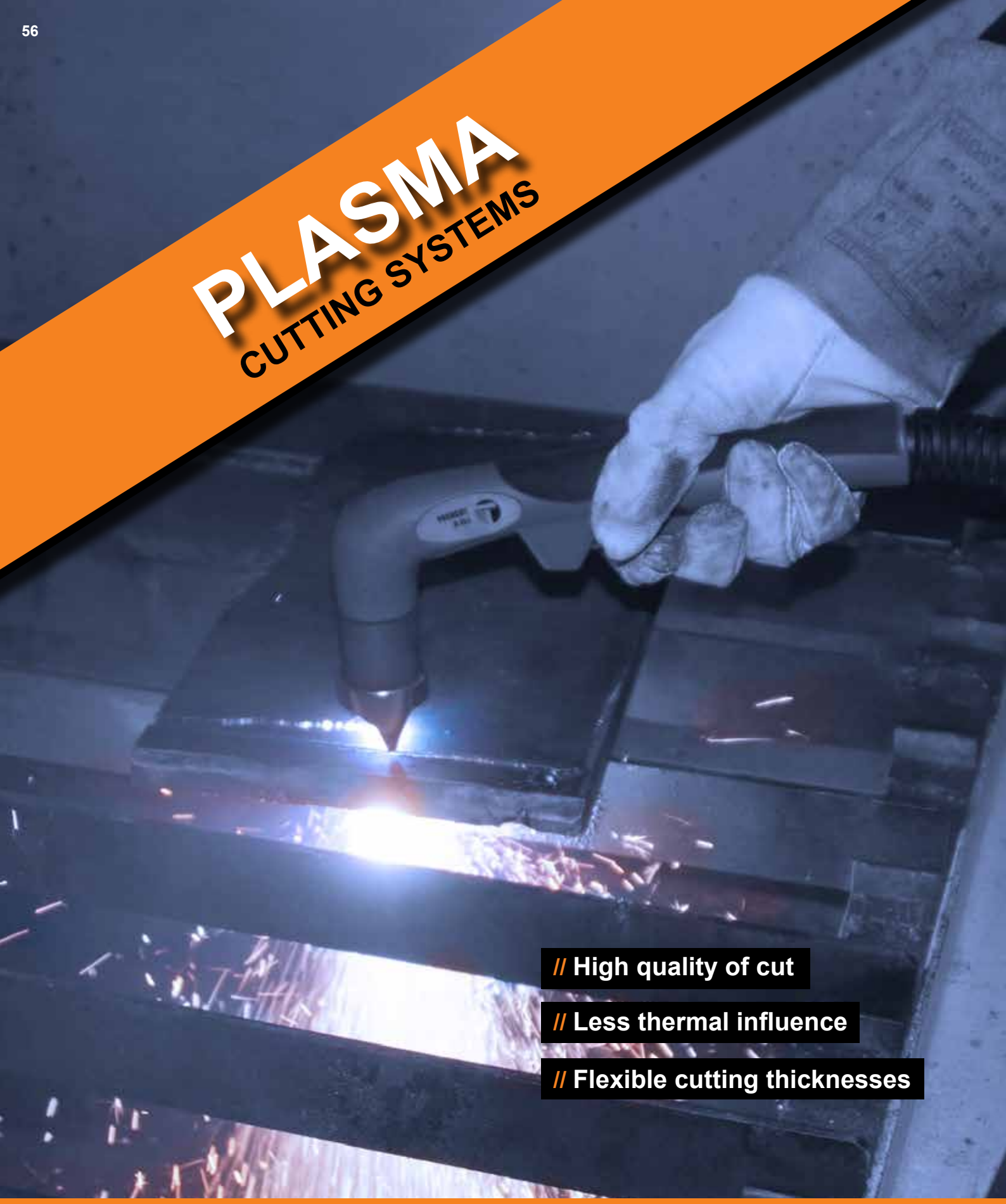
ACCESSORIES

	Item no.
Welding equipment set	
Welding equipment set 16mm²x5m 9mm-plug (Earth and electrode cables, wire brush, chipping hammer, hand protection shield with glasses)	7580442
Earth cable	
Earth cable 16mm² 4 m 9mm with 200A clamp	7810107
Electrode cable	
Electrode cable 16mm² 5m 9mm with 260A clamp	7810205

MMA

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help. Subject to technical changes. All REHM welding equipment listed bears the CE and S markings and complies with the EN 60 974-1 and EN 501 99 standards.

PLASMA
CUTTING SYSTEMS



// High quality of cut

// Less thermal influence

// Flexible cutting thicknesses

REHM – The benchmark for modern welding

NEW PRODUCT

Compact, efficient and powerful:
The new BARRACUDA® 45i-125i

ENERGY EFFICIENCY by PFC

Mobility, maximum efficiency and excellent cutting quality are particular features of the REHM plasma cutting machines.
The new compact BARRACUDA® is available in two sizes and four performance classes.
Large power components and 100% tested quality guarantee the reliability of the BARRACUDA® in the demanding conditions found in industry and craft.

- For universal use with unalloyed and high-alloy steels, aluminium, copper, brass, bronze, nickel, non-ferrous metals and all other electrically conductive metals, also with painted surfaces.
- Optimum cut quality thanks to precisely regulated, infinitely adjustable cutting current and optimized plasma cutting torch.
- With high power reserves – even at the critical end of the cut.
- Immediate start of cutting, the material can be cut without prior heating.
- High cutting speed with a long service life and the best cutting quality.
- No technical gas required, only compressed air.
- Suitable for generator use.
- Mobile thanks to its compact design, easy to carry with the stable handle and lightweight at just 8.1 kg (BARRACUDA® 45i).

PFC is only available in BARRACUDA® 45i.

None of the illustrations show the standard equipment.

The welding power sources must be maintained once a year in accordance with DGUV V3 and EN 60974-4. Our service department can help.

CONTROL PANEL BARRACUDA® 45i-125i

1. Digital display of current
2. Function display 2 cycle, 4 cycle, perforated sheet metal, gouging (105i/125i)
3. Digital display of pressure

4. Signal current flows
5. Selection button functions
6. Controller current selection
7. Compressed air test

BARRACUDA® 45i-125i

TECHNICAL DATA		45i	65i	105i	125i
Setting range	[A]	20-40 (20-30*)	20-65	20-100	20-120
Duty cycle (ED) at Imax.	[%]	35 (30*)	90	60	
Fuse	[A]	16		32	
Protection type		IP 21S			
Tension at 100 % ED	[V]	92 (88*)	104	106	118
Current at 100 % ED	[A]	30 (20*)	61	65	95
Power factor	[cos phi]	0.99	0.65	0.78	0.7
Power consumption at Imax.	[kVA]	4.8	7.8	11	17.5
Mains connection	[V]	230 (110*)	400		
Mains frequency	[Hz]	50/60			
Required generator power	[kVA]	>4.8	>12.5	>18.9	>25
Welding cable socket	[mm]	13			
Weight	[kg]	8.1	26.5	32.1	32.4
Dimensions LxWxH	[mm]	490 x 150 x 290		740 x 260 x 484	
Item no.					
		1610045	1610065	1610105	1610125
Included		Earth cable 4m, torch plasma ErgoCut S65, 6 m	Earth cable 4m, torch plasma PlusCut 85, 6 m	Earth cable 4m, torch plasma PlusCut 105, 6 m	

*Information applies to operation with 110V mains connection

Please note: BARRACUDA® 45i is initially supplied with a plasma ErgoCut S65 torch.

Subject to technical changes. All REHM plasma cutting systems listed bear the CE and S markings and comply with the EN 60 974-1 and EN 501 99 standard.

ACCESSORIES

	Item no.
Torch plasma	
Torch plasma ExpresCut S65 6m	7660890
Torch plasma PlusCut 85 6m	7660870
Torch plasma PlusCut 85 12m	7660871
Torch plasma PlusCut 105 6m	7660880
Torch plasma PlusCut 105 12m	7660881
Wear parts sets for torch	
Wear part kit plasma PlusCut 65/85	7766754
Wear part kit plasma PlusCut 105	7766755
Wear parts set plasma EC S65	7700476
Wear parts set plasma PC 65/85	7700474
Wear parts set plasma PC 105	7700475
Earth cable	
Earth cable 16mm² 4m 13 200A clamp	7810100
Earth cable 25mm² 4m 13 400A clamp	7810101
Circle cutting attachment	
Plasma circle cutting kit ErgoCut	7766790
Plasma circle cutting kit PlusCut	7766780

REHM - benefit from our high standards

Our products are characterised by high quality and low downtime.
Nevertheless, even the best devices require regular professional maintenance.
Only this way can permanently reliable usage is ensured.
With REHM Service that is tailored individually, you receive exactly those services that meet your personal needs.

REHM – your expert for maintenance and repair

An equipment failure is always connected with high cost and a certain amount of inconvenience. The regular maintenance of your welding and cutting power source and torch ensures trouble-free operation and prevents costly repairs. Even if they are regularly used in extreme conditions.

Our team of experts can help you to plan the maintenance intervals.
In this way you can optimise your individual job planning and minimise the risk of unforeseen costs of expensive downtime.

Customised maintenance contracts for your company

In recent decades, together with our excellently trained service technicians REHM has developed into a specialist for all brands of welding technology.
Just one argument of many why, with us, your equipment is in the very best hands.

Repair and maintenance of
- welding and cutting power sources of all brands,
- TIG torches,
- MIG / MAG torches and
- oxyacetylene torches

is only part of the services we offer. Our service package also includes individual consultations and practical training.

Take advantage of our strengths

Thanks to our numerous locations, we can offer you a comprehensive range of all our services including repair and maintenance.

- The proximity to our customers is the basis for extremely short reaction times.
- At the locations in Uhingen, Speyer, Leipzig and Magdeburg you have direct access to the manufacturer.
- We use only certified original spare and replacement parts!
- After maintenance or repair of the torch a detailed inspection is carried out in accordance with VBG4 and VDE0544.

Our strengths become your benefit!

We look forward to hearing from you on +49 (0) 7161 3007-85.

REHM DIN EN 1090 WPQR / WPS PACKAGE

Everything you need to know about the qualification of welding processes

The REHM DIN EN 1090 WPQR / WPS package contains welding instructions (WPS) on standard welding procedures according to DIN EN ISO 15612:2004-10 as well as the associated welding procedure tests (WPQR) according to DIN EN ISO 15614-1:2012-06.
According to DIN EN 1090-2:2011-06 (Point 7.4.1.2, Table 12), these welding instructions can be used as standard welding procedures for the qualification of the materials S235, S275 and S355 in EXC 1 and EXC 2.

On more than 500 pages you will find the following content:

- Certificate of the Leipzig Chamber of Skilled Crafts
- Requirements for equipment manufacturers
- Five steps to CE marking
- My way to the WPS
- REHM customer service
- For whom is which EXC-class valid?
- Regulation of liability
- Welding instructions (WPS)
- Welding procedure qualification tests (WPQR)
- Creating your own welding instructions

REHM DIN EN 1090 WPQR / WPS PACKAGE	Item no.
Two languages German / English	1330463

THE REHM PERFORMANCE PROGRAM

- **REHM MIG / MAG welding machines**
- **REHM TIG welding machines**
- **REHM MMA electrode inverter**
- **REHM PLASMA cutting systems**
- **Welding accessories and consumables**
- **Welding fume extraction**
- **Technical welding advice**
- **Torch repairs**
- **Service**

WEEE-Reg.-Nr. DE 42214869

REHM 11/2024 • Item no. 9907044

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REHM – The benchmark for modern welding

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