



SHIFTING THE LIMITS

VARIOSTAR 1500/2500/3100

/ MIG/MAG welding system



/ The step-switched MIG/MAG welding system VarioStar is a byword for rugged design and ease of operation. Particularly when used on light-gauge sheets, VarioStar stands out for its exceptionally good welding properties. Three different amperage ratings are available: 150, 250 and 310 A, optimally harmonised for both mixed gas and CO₂. The VarioStar machines are just about indestructible, being robustly built from only top-grade materials.

OPERABILITY

/ The VarioStar is extremely simple to operate. Only three settings need to be made:

- / switching-steps
- / inductance tap
- / wirefeed speed

/ An integral settings assistant makes the machine even easier to operate.

WELDING PROPERTIES

/ VarioStar has two or three inductance taps. This makes it easier to adapt the arc to the job needing to be done.

/ The ignition process is reliable and absolutely jerk-free: at the start of welding, the wire is fed more slowly and only gets up to speed once the arc has ignited.

/ The end-of-welding sequence is easy to define, with an adjustable wire burn-back.



/ The integral settings assistant makes the machine extremely easy to operate.



/ 2-roller drive ensures excellent wirefeeding.



/ The specially tuned inductance makes it possible: optimum welding with CO₂ and mixed gas.

TECHNICAL DATA

	VST 1500	VST 2500	VST 3100
Mains voltage, reconnectable, + / - 10 %	1 x 230 V	3 x 230 V / 400 V	3 x 230 V / 400 V
Mains frequency	50 / 60 Hz	50 / 60 Hz	50 / 60 Hz
Mains fuse protection (slow-blow)	16 A	16 A	20 A
Primary continuous current (100 % d.c.)	9.6 A (230 V)	5.3 A (400 V)	6.9 A (400 V)
Cos phi	0.99 (140 A)	0.99 (250 A)	0.99 (310 A)
Efficiency	74 % (70 A)	75 % (130 A)	78 % (310 A)
Welding current range	30 - 140 A	25 - 250 A	20 - 310 A
Welding current at 10 min/40°C	20 % d.c. 140 A	27 % d.c. 250 A	30 % d.c. 310 A
	60 % d.c. 90 A	60 % d.c. 150 A	60 % d.c. 220 A
	100 % d.c. 70 A	100 % d.c. 130 A	100 % d.c. 160 A
Open-circuit voltage	34 V	38 V	46 V
Working voltage	15.5 - 21.0 V	15.3 - 26.5 V	15 - 29.5 V
N° of switching steps	6	10	15
IEC 'degree of protection' code	IP 21	IP 21	IP 21
Type of cooling	AF	AF	AF
Insulation class	F	F	F
Dimensions L x W x H	800 x 380 x 680 mm	800 x 380 x 680 mm	800 x 380 x 680 mm
Weight	60.5 kg	74 kg	92 kg



CHECKLIST

- / 2-roller drive
- / Basket-type spool insulator (optional)
- / Extra-wide gas cylinder holder (optional)
- / Gas pre-heating socket (optional)
- / Gasless & currentless feeder inching
- / Inrush current limiter (optional)
- / Overtemperature indicator
- / Overtemperature sensor switch
- / Polarity reverser
- / Thermostat-controlled fan (optional)
- / Transport handle (optional)

OPERATING MODES

- / 2- and 4-step mode
- / Spot welding
- / Stitch welding

ADJUSTABLE PARAMETERS

- / Burn-back time
- / Gas pre-flow time
- / Intermittent welding time
- / Spot-welding time
- / Welding power

/ Battery Charging Systems / Welding Technology / Solar Electronics

WE HAVE THREE DIVISIONS AND ONE PASSION: SHIFTING THE LIMITS.

/ Whether Battery Charging Systems, Welding Technology or Solar Electronics - our goal is clearly defined: to be the technology and quality leader. With more than 3,000 employees worldwide, we shift the limits of what's possible - our 737 active patents are testimony to this. While others progress step by step, we innovate in leaps and bounds. Further information about all Fronius products and our global sales partners and representatives can be found at www.fronius.com



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