



**Welding process**

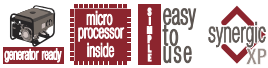
- MIG/MAG short spray manual arc welding
- MIG/MAG short spray synergic arc welding

**Materials**

- Carbon steels
- Aluminized and galvanized steels
- Stainless steels
- Aluminum and aluminum alloys

**Applications**

- Light job shop fabrication
- Medium-heavy job shop fabrication
- Heavy job shop fabrication
- Building sites
- Plants machinery construction
- Railway industry
- Machine and apparatus construction
- Automobile industry
- Repair and overhaul
- Workshops
- Sheet metal working











**Technical features**

- Extremely rugged, reliable and easy-to-use systems
- High power at 100% of duty cycle
- Heavy duty and enviromental conditions, high service life
- High temperature, shockproof, abrasion resistant plastic case
- Excellent performances also with long power supply extension cables
- 230V power supply socket for preheater
- Wire feeder unit (2/4 rolls drive)
- Full parameters control panel on wire feeder unit
- Fully Selco designed wire drive unit
- Ø 200/300 mm wire spool compatible
- Full digital and user-friendly control panel
- Welding parameters digital display
- Last job settings auto-storage at switch-off
- Multiple output choke selection
- 2/4 step operating mode
- Perfect arc ignition (soft start - motor slope)
- Burn-back and droplet detachment correction
- Synergic operations from databank (12 pre-set programs)
- Spot welding mode
- Intermittent welding mode
- Euro adaptor - MIG/MAG torch compatible
- Selco WU cooling unit compatible

**Power source**

			<b>P</b>	<b>X%</b>				<b>I<sub>2</sub></b>	<b>U<sub>o</sub></b>	<b>IP</b>	mm l x w x h	Kg
<b>Unistep 3500XP</b>	3x230V	35A	16,6kVA 15,0kW	40°C	35%	350A	3x10	30-380A	50V	21S	1060x400x780mm	123,0kg
				40°C	60%	300A						
				40°C	100%	240A						
				25°C	40%	350A						
				25°C	60%	320A						
				25°C	100%	260A						
<b>Unistep 3500XP</b>	3x400V	20A	16,6kVA 15,0kW	40°C	35%	350A	3x10	30-380A	50V	21S	1060x400x780mm	123,0kg
				40°C	60%	300A						
				40°C	100%	240A						
				25°C	40%	350A						
				25°C	60%	320A						
				25°C	100%	260A						
<b>Unistep 4500XP</b>	3x230V	50A	24,0kVA 22,9kW	40°C	40%	450A	3x10	30-480A	50V	21S	1060x400x780mm	139,0kg
				40°C	60%	370A						
				40°C	100%	300A						
				25°C	45%	450A						
				25°C	60%	390A						
				25°C	100%	320A						
<b>Unistep 4500XP</b>	3x400V	30A	24,0kVA 22,9kW	40°C	40%	450A	3x10	30-480A	50V	21S	1060x400x780mm	139,0kg
				40°C	60%	370A						
				40°C	100%	300A						
				25°C	45%	450A						
				25°C	60%	390A						
				25°C	100%	320A						






## Wire feeder unit

	<b>P</b>	$\phi$ (m/min)	 mm		$\emptyset$ mm	$\phi$				<b>IP</b>	 mm l x w x h	 Kg
<b>WF 115XP (Unistep 3500/4500)</b> SL 4R-1T (v.2R)	90W	1,5-22,0m/min	200/300mm	2 ● 4 ○	1,0/1,2mm ● 0,6-1,6mm ○ A 0,8-1,6mm ○ Z 1,2-2,4mm ○	●	●		○	23S	600x220x440mm	17,5kg

● = Included ○ = Optional

A = Aluminum Z = Cored

## Cooling unit

		<b>P</b>		<b>IP</b>	 mm l x w x h	 Kg
<b>WU 22</b>	1x230V	1,0kW	4,0l	23S	250x150x700mm	16,0kg

**Part No.**      **Description****Unistep 3500XP - MIG/MAG welding configuration - Gas - 2 roll drive**

51.03.035	UNISTEP 3500 230/400 V
71.01.11202	FEED UNIT - WF 115 XP UNISTEP 4500
71.06.265	CABLE ASSEMBLY 50mm <sup>2</sup> - L.1,3m
71.05.025	WORK CABLE - 50mm <sup>2</sup> - L.4m
81.01.031	MIG/MAG WELDING TORCH MB 26 KD - L.4m - AIR COOLED
72.01.001	PRESSURE LIMITER WITH PREHEATER AND FLOWMETER

**Unistep 3500XP - MIG/MAG welding configuration - Water - 2 roll drive**

51.03.035	UNISTEP 3500 230/400 V
71.01.11202	FEED UNIT - WF 115 XP UNISTEP 4500
71.03.022	COOLING UNIT WU 22
71.06.262	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.1,3m
71.05.025	WORK CABLE - 50mm <sup>2</sup> - L.4m
81.01.061	MIG/MAG WELDING TORCH MB 501 D - L.4m - LIQUID COOLED
72.01.001	PRESSURE LIMITER WITH PREHEATER AND FLOWMETER

**Unistep 4500XP - MIG/MAG welding configuration - Gas - 2 roll drive**

51.03.045	UNISTEP 4500 230/400V
71.01.11202	FEED UNIT - WF 115 XP UNISTEP 4500
71.06.259	CABLE ASSEMBLY 70mm <sup>2</sup> - L.1,3m
71.05.030	WORK CABLE - 70mm <sup>2</sup> - L.4m
81.01.041	MIG/MAG WELDING TORCH MB 36 KD - L.4m - AIR COOLED
72.01.001	PRESSURE LIMITER WITH PREHEATER AND FLOWMETER

**Unistep 4500XP - MIG/MAG welding configuration - Water - 2 roll drive**

51.03.045	UNISTEP 4500 230/400V
71.01.11202	FEED UNIT - WF 115 XP UNISTEP 4500
71.03.022	COOLING UNIT WU 22
71.06.256	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.1,3m
71.05.030	WORK CABLE - 70mm <sup>2</sup> - L.4m
81.01.061	MIG/MAG WELDING TORCH MB 501 D - L.4m - LIQUID COOLED
72.01.001	PRESSURE LIMITER WITH PREHEATER AND FLOWMETER

**Accessories****Torch**

81.01.031	MIG/MAG WELDING TORCH MB 26 KD - L.4m - AIR COOLED
81.01.041	MIG/MAG WELDING TORCH MB 36 KD - L.4m - AIR COOLED
81.01.060	MIG/MAG WELDING TORCH MB 501 D - L.3m - LIQUID COOLED
81.01.061	MIG/MAG WELDING TORCH MB 501 D - L.4m - LIQUID COOLED

**Earth cable**

71.05.025	WORK CABLE - 50mm <sup>2</sup> - L.4m
71.05.030	WORK CABLE - 70mm <sup>2</sup> - L.4m

**Wirefeeder**

71.01.11202	FEED UNIT - WF 115 XP UNISTEP 4500
07.01.507	UPGRADE KIT FROM 2 ROLLS (1 ROLL DRIVE) TO 4 ROLLS (2 ROLLS DRIVE)
73.10.051	FEED UNIT WHEELS - UPGRADE KIT

Part No.	Description
<b>Cable bundle</b>	
71.06.265	CABLE ASSEMBLY 50mm <sup>2</sup> - L.1,3m
71.06.266	CABLE ASSEMBLY 50mm <sup>2</sup> - L.4m
71.06.267	CABLE ASSEMBLY 50mm <sup>2</sup> - L.10m
71.06.259	CABLE ASSEMBLY 70mm <sup>2</sup> - L.1,3m
71.06.260	CABLE ASSEMBLY 70mm <sup>2</sup> - L.4m
71.06.261	CABLE ASSEMBLY 70mm <sup>2</sup> - L.10m
71.06.262	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.1,3m
71.06.263	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.4m
71.06.264	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.10m
71.06.271	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.15m
71.06.272	CABLE ASSEMBLY - WATER COOLED 50mm <sup>2</sup> - L.20m
71.06.256	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.1,3m
71.06.257	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.4m
71.06.258	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.10m
71.06.268	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.15m
71.06.270	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.20m
71.06.276	CABLE ASSEMBLY - WATER COOLED 70mm <sup>2</sup> - L.30m
<b>Cooling unit</b>	
71.03.022	COOLING UNIT WU 22
18.91.001	ANTIFREEZING LIQUID (10kg)
<b>Other</b>	
72.01.001	PRESSURE LIMITER WITH PREHEATER AND FLOWMETER
72.01.007	PRESSURE LIMITER - IT
72.04.001	ARGON-CO2 GAS FITTING