

MP-XQ MULTIPROCESS COMBINATION WELDING MACHINES

MIG/MAG AND TIG IN PERFECT COMBINATION



XQ
MIG/MAG
+
TIG

MP-XQ MULTIPROCESS COMBINATION WELDING MACHINES

MIG/MAG and TIG in perfect combination

EWM MP-XQ multiprocess combination welding machines combine all the advantages, welding procedures and options of EWM MIG/MAG and TIG welding machines.

Request your own desired combination with the individual options of your choice.



Xnet ready

3 Years // **5 Years**
transformer
and rectifier
ewm-warranty*
3 shifts / 24 hours / 7 days
*For details visit www.ewm-group.com

Industry
4.0
ewm

Blue Evolution®

YOUR BENEFITS +

- All EWM MIG/MAG and TIG welding processes in a single welding machine
- Simultaneous connection of MIG/MAG and TIG welding torches
- Optional connection of a separate Drive XQ wire feeder (LP, HP or Expert 2.0)*
- Cylinder cart for two shielding gas cylinders (MIG/MAG and TIG)
- Uncompromising MIG/MAG operation (LP, HP or Expert 2.0)
- Uncompromising Comfort 2.0 TIG operation
- Only one grounding cable
- Only one water cooling unit
- Only one mains plug

EXAMPLE CONFIGURATIONS+

MP XQ multiprocess combination systems

Item number

MP XQ multiprocess Titan XQ 350C puls + Tetrix 300 DC	090-S05608-05173
MP XQ multiprocess Titan XQ 400C puls + Tetrix 300 DC	090-S05609-05174
MP XQ multiprocess Titan XQ 350C puls + Tetrix 300 AC/DC	090-S05608-05175
MP XQ multiprocess Titan XQ 400C puls + Tetrix 300 AC/DC	090-S05609-05176
MP XQ multiprocess Phoenix XQ 350C puls + Tetrix 300 DC	090-S05647-05177
MP XQ multiprocess Phoenix XQ 400C puls + Tetrix 300 DC	090-S05648-05178
MP XQ multiprocess Phoenix XQ 350C puls + Tetrix 300 AC/DC	090-S05647-05179
MP XQ multiprocess Phoenix XQ 400C puls + Tetrix 300 AC/DC	090-S05648-05180
MP XQ multiprocess Taurus XQ 350C Synergic + Tetrix 300 DC	090-S05653-05181
MP XQ multiprocess Taurus XQ 400C Synergic + Tetrix 300 DC	090-S05654-05182
MP XQ multiprocess Taurus XQ 350C Synergic + Tetrix 300 AC/DC	090-S05653-05183
MP XQ multiprocess Taurus XQ 400C Synergic + Tetrix 300 AC/DC	090-S05654-05184



Drive XQ
15 kg/D300
Wire spool



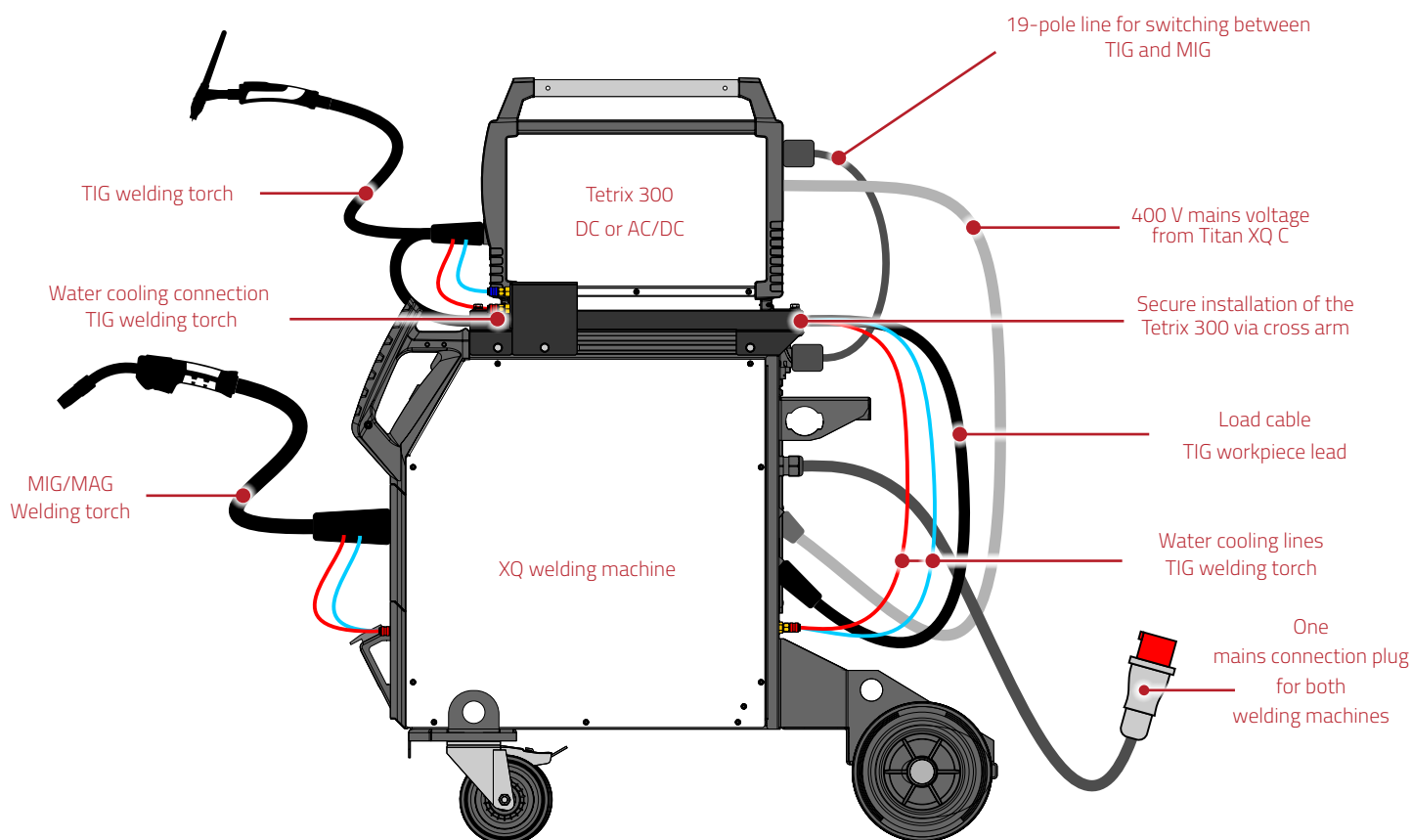
Drive XQ IC 200
5 kg/D200
Wire spool

Optional separate wire feeder

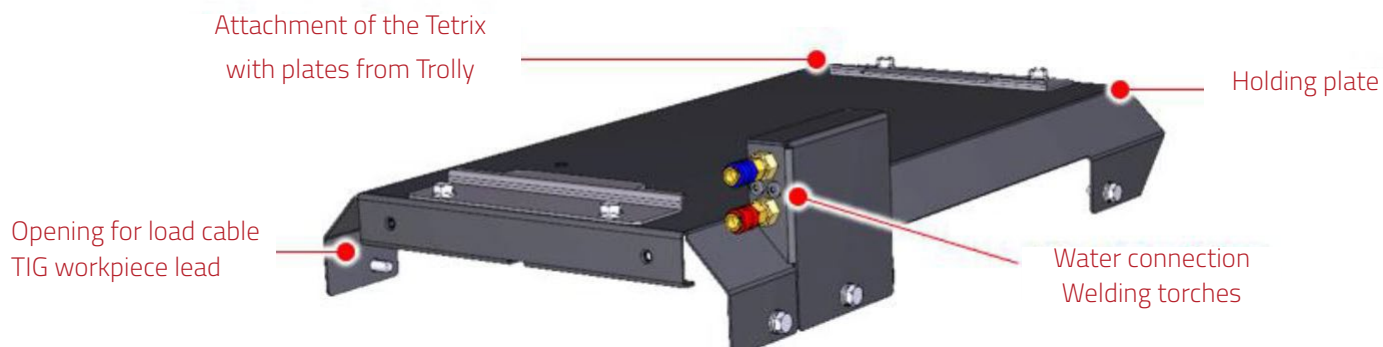
*In addition to the integrated wire feeder of the compact welding machine, the connection of a separate wire feeder is also possible on request.

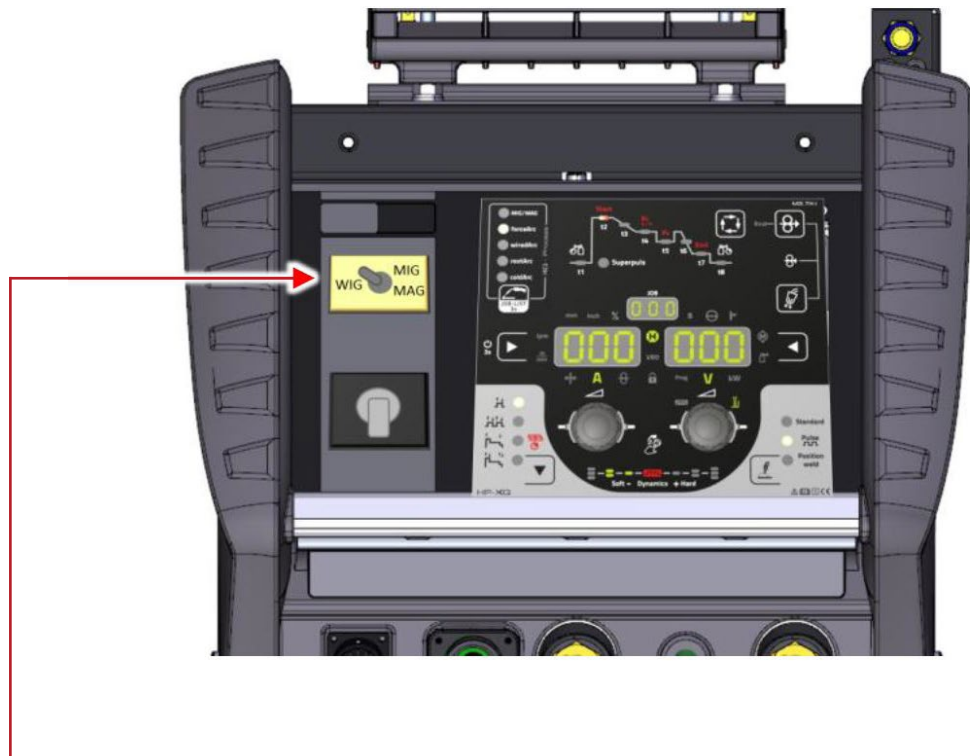
LAYOUT OF THE COMBINATION SYSTEMS

Basic layout:



Adapter plate





Switching between TIG and
MIG/MAG directly on the
front of the control

THE XQ WELDING PROCESSES.

PROCEDURES AND PROCESSES FOR OPTIMUM WELDING RESULTS.

Maximum operating convenience, a long service life and all pulse, standard and innovative welding processes optimised and included in the machine at no extra charge. Here, perfect weld seams are already pre-programmed for low- to high-alloy steels and aluminium in all material thicknesses and all positions.

Titan XQ puls

XQ - Process

all in

rootArc® XQ/rootArc® puls XQ

coldArc® XQ/coldArc® puls XQ

forceArc® XQ/forceArc® puls XQ

wiredArc XQ/wiredArc puls XQ

Standard (MIG/MAG)

Pulse

Positionweld

superPuls

TIG

MMA

Gouging

Phoenix XQ puls

XQ - Process

all in

rootArc® XQ/rootArc® puls XQ

forceArc® XQ/forceArc® puls XQ

Standard (MIG/MAG)

Pulse

Positionweld for aluminium

superPuls

TIG

MMA

Gouging



rootArc® XQ/rootArc® puls XQ

Perfect root welding/easy-to-execute filler and final passes



forceArc® XQ/forceArc® puls XQ

Powerful, high-performance arc with deep penetration



coldArc® XQ/coldArc® puls XQ

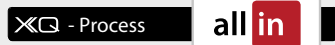
Heat-minimised arc for thin metal sheet welding



wiredArc XQ/wiredArc puls XQ

High-performance arc with penetration independent of stick-out thanks to dynamic wire control (penetration stabilisation)

Taurus XQ Synergic



rootArc[®] XQ

forceArc[®] XQ

Standard (MIG/MAG)

superPuls

TIG

MMA

Gouging

Taurus XQ Basic



Standard (MIG/MAG)

TIG

MMA

Gouging



superPuls

Heat-reduced interval welding between two operating points: high-current and low-current phases freely adjustable (control dependent)



Pulse

Low-spatter pulsed arc



Positionweld

Simple positional welding without the "Christmas tree" technique



Standard

Perfect short and spray arcs

XQ

MIG/MAG
+
TIG

TETRIX 300

PROCEDURES AND PROCESSES



Tetrix 300 AC/DC Comfort 2.0

AC/DC WELDING PROCEDURE

WELDING PROCEDURES
TIG AND MMA

AC amplitude balance

AC balance

AC-Balling

AC frequency

AC special

AC waveforms

Standard AC

Pulsed TIG AC welding

activArc®

Automatic pulsing

HF start

Lift arc

Average value pulse welding

spotArc®

spotmatic

Standard DC

Thermal pulsing

TIG Antistick

Pulsed TIG DC welding

Antistick

Arcforce

Cellulose electrode compatible

MMA pulse welding

Hot start

Standard MMA

WELDING PROCEDURES
OVERVIEW



AC amplitude balance

Enables adjustment of negative and positive welding current level.



AC balance

The perfect balance between the penetration profile and achievable cleaning effect.



AC-Balling

Ensures optimum tungsten balling and therefore a stable, easy-to-handle arc.



AC frequency

Adjustment of the arc force – ideal for thin metal sheets and fillet welds.



AC waveforms

Optimum stability and reduced noise level thanks to adjustable AC waveforms (sine, trapezoidal, square and customised).



AC special

Switch between AC in the pulsing phase and DC in the fundamental current phase.



activArc®

Dynamic TIG arc with automatic arc stabilisation.



Automatic pulsing

To increase the arc stability and the penetration characteristics with low currents, the current is pulsed automatically.



HF start

Prevents tungsten contact arc ignition.



Lift arc

Simple ignition of the arc by pulling up the electrode without touching the workpiece.



Average value pulse

Allows the user to weld in pulsed mode according to WPS requirements.



spotArc®

Minimised time required for welding due to independent points with the tool.



Tetrax 300 DC Comfort 2.0

DC WELDING PROCEDURE

activArc [®]	Antistick
Automatic pulsing	Arcforce
HF start	Cellulose electrode compatible
Lift arc	MMA pulse welding
Average value pulse welding	Hot start
spotArc [®]	Standard MMA
spotmatic	
Standard DC	
Thermal pulsing	
TIG Antistick	
Pulsed TIG DC welding	

inclusions through non-con-

the arc without HF by
ding torch electrode after
piece.

se welding
implement, for example,
s extremely easily, even in

quired for tacking and spot
individual triggering of the tack
rch trigger.



spotmatic
Reproducible welding of uniform tack points.



Standard AC
Aluminium welding in just one click thanks to perfect
presets. Easy adjustment of AC parameters for special
applications.



Standard DC
Perfect TIG welding with ignition parameters adapted
depending on power output.



Thermal pulsing
The freely adjustable pulsed current and rele-
vant time can be adapted in accordance with
the welding power. These precision settings
allow for unique weld appearances.



TIG Antistick
Prevents damage to tungsten elec-
trode in case of inadvertent contact
with the workpiece.



Pulsed TIG AC welding
Reduced distortion and discolouration
through energy per unit length and heat
input.



Pulsed TIG DC welding
Decreases the heat input which re-
duces distortion and discolouration.

XQ

MIG/MAG

+
TIG

TECHNICAL DATA



COMPACT

**TITAN XQ
PHOENIX XQ
TAURUS XQ**

**350 puls C
350 puls C
350 Synergic C**

**400 puls C
400 puls C
400 Synergic C**

Setting range for welding current	5 A – 350 A	5 A – 400 A
Duty cycle 40 °C, 100%	320 A	320 A
Duty cycle 40 °C, 80%	350 A	350 A
Duty cycle 40 °C, 60%	–	400 A
Open circuit voltage	82 V	
Mains voltage	3 x 400 V (- 25 % – + 20 %)* 3 x 460 V (- 25 % – + 15 %) 3 x 500 V (- 25 % – + 10 %)	
Mains frequency	50 Hz/60 Hz	
Wire feed speed	0.5 m/min. – 25 m/min. 19.685 ipm – 984.253 ipm	
Factory-installed roll equipment	1.0-1.2 mm UNI (steel)	
Spool diameter	D200/D300	
Torch connection	Euro torch connector	
Protection classification	IP23	
Safety identification		
EMC class	A	
Dimensions (L x W x H) mm	1150 x 678 x 972	
Dimensions (L x W x H) inch	45.276 x 26.693 x 38.268	
Weight, approx.	131 kg**/288 lbs** 128 kg***/282 lbs***	
Standards	IEC 60974-1, -5, -10 CLA	

*Ex works

**Weight specification of TITAN XQ 350 puls C/TITAN XQ 400 puls C


***Weight specification of PHOENIX XQ 350 puls C–400 puls C/Taurus XQ 350 Synergic C–400 Synergic C

TECHNICAL DATA



Tetrix 300 DC

Tetrix 300 AC/DC

Setting range for welding current	5 A to 300 A
Duty cycle 40 °C, 100%	210 A
Duty cycle 40 °C, 60%	260 A
Duty cycle 40 °C, 35%	300 A
Open circuit voltage	63 V
Mains voltage	3 x 400 V (–25% to +20%)
Mains frequency	50 Hz/60 Hz
Protection classification	IP23
Safety identification	
EMC class	A
Dimensions (L x W x H) mm	539 x 210 x 415
Dimensions (L x W x H) inch	21.2 x 8.3 x 16.3
Weight, approx.	22.6 kg 49.8 lbs
Standards	IEC 60974-1, -3, -10 CLA



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EWM is your partner for the best welding technology. With EWM, you'll weld more efficiently, more reliably and produce higher-quality results. EWM's innovative systems, high-performance welding procedures, digital technologies and services, and expert consultation all support you in achieving perfect results from your welding tasks.

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The content of this document has been researched, prepared and reviewed with all reasonable care. The information provided is subject to change; errors excepted.