



# CITOSTEP

## 355S, 425S & 505S

Premium arc,  
Synergic style

WARRANTY

### Three-phase MIG/MAG step controlled power sources

#### CITOSTEP 355S, 425S & 505S

CITOSTEP power sources along with WF24 & WF24S wire feeders offer unrivalled choice of step controlled MIG machines.

The WF24 and 24S are portable wire feeders with stabilised wire feed speed. They include a rugged 4 roll wire feed unit, featuring cold inch, gas purge and built-in burn back facility. They can be mounted on the power source with a swivelling, wheeled carriage. The Synergic control of the WF24S allows the operator to simply set the welding voltage and start welding: wire feed speed adjusts automatically.



Input

Output

Processes

MIG, FLUX-CORED

#### Advantages

- > Rugged design
- > Equipped with handles & wheels & eyebolts
- > Many features as standard : 2/4 stroke, adjustable burn-back, spot-weld, wire inch and gas test

#### Benefits

- > Reliable also in harsh conditions
- > Easy transport on & offsite
- > Superior arc welding behaviour

# CITOSTEP 355S, 425S & 505S



## Features

- › Products developed with a focus on applications.
- › Superb Arc behaviour with Argon Mix and 100% CO<sub>2</sub>
- › Voltage selectors with multiple steps for precise adjustment
- › Two choke tabs to support superb Arc behaviour
- › Fan as needed (F.A.N.™)
- › Synergic control to support easy control by the welder with WF24S.
- › Bright digital volt and ammeter
- › Completed with an extensive set of features.
- › Large diameter wheels - push/pull bar and lifting eyes
- › Easy to convert to water-cooled - by simply adding the Cooler 25

## To order

Designation	Item Number
<b>CITOSTEP 355S</b>	W000403592
<b>CITOSTEP 425S</b>	W000403593
<b>CITOSTEP 505S</b>	W000404225
<b>WF24</b>	W000403599
<b>WF24S</b>	W000403600
<b>COOLER 25</b>	W000403601
Source/wire feeder cable gas	K10347-PG-xxM*
Source/wire feeder cable water	K10347-PGW-xxM*

\*xx= 5, 10, 15, 20, 25m



## Applications

### Heavy outdoor & indoor applications

- › On site maintenance
- › Service tasks
- › Construction sites
- › General fabrication

## Technical characteristics

Product	CITOSTEP 355S	CITOSTEP 425S	CITOSTEP 505S
Primary Voltage (50-60Hz)	230/400V / 3Ph		
Current Range (A)	30-350	30-420	40-500
Duty cycle at 40 °C	350A@40% 285A@60%	420A@40% 345A@60%	500A@40% 410A@60%
Fuse Size (A) (slow)	40/25	50/32	63/40
Weight (kg)	141	151	160
Dimensions H x W x D (mm)	875 x 700 x 1035		
Protection / Insulation Class	IP23 / H		

Product	WF24	WF24S
Drive rolls	4	
WFS (m/min)	1-20	
Wire size (mm)	0.6-1.6	
Weight (kg)	17	
Dimensions H x W x D (mm)	440 x 275 x 636	
Burn Back	✓	✓
Run in	✓	✓
Meters	✓	✓
2/4 step trigger	✓	✓
Synergy		✓
Cold Feed	✓	✓
Gas Purge	✓	✓
Spot Welding	✓	
Gas Pre Flow		✓



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