



# Kempact RA

## Switch on the new standard

- Modern, energy efficient power source
- Excellent welding performance with mixed or CO<sub>2</sub> shielding gas
- Precise, clean arc ignition
- Maximum output at 35 % duty cycle
- Large, clear LCD display
- WireLine™ service indicator
- GasMate™ chassis design featuring floor level cylinder loading
- Brights™ cabinet lighting
- HotSpot™ heat treatment function
- 2T/4T gun switch latching
- Spot and cycle arc timer
- Parts storage trays
- Designed and manufactured in Finland
- 3 year warranty

## New standards in compact MIG/MAG class

**Designed for the modern welding workshop, Kempact RA expresses stylish and purposeful design** through high build quality and functional user benefits, making weld tasks productive, accurate and efficient.

**Kempact RA is built on Kemppi's latest power source platform, ensuring optimal welding performance and excellent power cost efficiency.** Eleven model options include 250 and 320 ampere power sources, including a choice of either Regular (R) or Adaptive (A) control panel interface, which serve the wide ranging needs of metal fabrication workshops. Welding gun and earth return lead pack are included.

**New technical features include reduced energy costs of more than 10 %** when compared to conventional step controlled power sources, Brights™ cabinet lighting for easy wire loading in low light conditions, WireLine™ service alert function that signals routine wire-path maintenance needs, plus the integrated GasMate™ chassis design, making gas cylinder loading and machine movement easy and safe. Whichever model you select, Kempact RA ensures you get the most from every welding task.





## VALUE FEATURES



### SAVINGS ON ENERGY COSTS

Compared to conventional step-controlled power sources



### 50% FASTER MACHINE SETTING

Using the memory channels



### KEMPPPI WARRANTY 3 YEARS

Covers machine parts and labor



*GasMate chassis design makes gas cylinder collection, storage and movement easy. Gas cylinders are floor level loaded and secured with strong fabric webbing.*

## Turn on the heat with HotSpot

Perfect for vehicle repair and thin sheet fabrication environments, the HotSpot™ function with four different heat settings makes metal shrinking and component heating simple and convenient. Simply fit the carbon electrode set to the FE welding gun and activate HotSpot™ on the control panel. An electrical circuit is created once the carbon electrode touches the work piece, which gently heats the metal's surface. HotSpot™ can also be used to heat and release corroded nuts and bolts and other metal components.

## Floor level design

The GasMate chassis design makes gas cylinder collection, storage and movement easy. Gas cylinders are floor level loaded and secured with a strong fabric webbing system.

## Kempact RA gets the job done

Kempact RA is the ideal solution for a variety of MIG/MAG welding applications. From vehicle repair to light and medium fabrication workshops, Kempact RA gets the job done, simply and reliably.

## Special features in Kempact Adaptive (A) models

In addition to all standard features provided in Regular panels with manual setup, Adaptive panels offer plate thickness control, filler materials selection and four memory channels combined with an adaptive mode setup for your convenience.

## Special features in Kempact Regular (R) models

Regular (R) models have a manual setup function for voltage and wirefeed speed and incorporate a wide range of standard features including GAS type selection, 2T/4T gun latching mode, SPOT/CYCLE arc timer as well as HOT SPOT function, a specialist localised heat treatment function for professional thin sheet fabricators and automotive repair engineers.



*The large and clear LCD control panels make parameter setting and reference easy. Parts trays provide convenient storage and access.*



*The wire cabinet is placed at a convenient easy-to-access height, making wire spool changes and wireline maintenance simple. LED cabinet lighting is also included as standard.*



*Kempact Adaptive (A) models include special features, including plate thickness control, filler material selection or the use of memory channels to help adjust the power setting.*

# Technical specifications

KEMPACT		251R, 251A
Connection voltage	1~, 50/60 Hz	240V (±15 %)
Rated power at max. current	30 % ED I1max (250 A)	8.5 kVA
Supply current	30 % ED I1max (250 A)	36 A
	100 % ED I1eff (150 A)	17 A
Connection cable	H07RN-F	3G2.5 (2.5 mm <sup>2</sup> , 5 m)
Fuse	Type C	20 A
Welding range		10 V / 20 A – 29 V / 250 A
Power factor at max.	250 A / 26.5 V	0.99
Efficiency at 100% ED	150 A / 21.5 V	0.82
Wire feed speed adjustment range		1.0-18.0m/min
Voltage adjustment range		8.0-29.0V
External dimensions	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg
EMC class		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10, IEC 61000-3-12		

Kempact		253R, 253A		323R, 323A
Connection voltage	3~, 50/60 Hz	400V (±15 %)	3~, 50/60 Hz	400V (±15 %)
Rated power at max. current	35 % ED I1max (250 A)	8.5 kVA	35 % ED I1max (320 A)	12 kVA
Supply current	35 % ED I1max (250 A)	11.9 A	35 % ED I1max (320 A)	17.2 A
	100 % ED I1eff (150 A)	6.1 A	100 % ED I1eff (190 A)	8.2 A
Connection cable	H07RN-F	4G1.5 (1.5 mm <sup>2</sup> , 5 m)	H07RN-F	4G1.5 (1.5 mm <sup>2</sup> , 5 m)
Fuse	Type C	10A	Type C	10A
Welding range		10 V / 20 A – 31 V / 250 A		10 V / 20 A – 32.5 V / 320 A
Power factor at max.	250 A / 26.5 V	0.93	320 A / 30 V	0.94
Efficiency at 100% ED	150 A / 21.5 V	0.88	190 A / 23.5 V	0.86
Wire feed speed adjustment range		1.0-18.0m/min		1.0-20.0m/min
Voltage adjustment range		8.0-31.0V		8.0-32.5V
External dimensions	L x W x H	623 x 579 x 1070 mm	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg		44 kg
EMC class		A		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10				



*Kempact 251 models feature the GT02C two roll wire drive unit*



*Kempact 253/323 models feature the Dura-Torque four roll wire drive unit.*

Kempact		253 AMV		323 RMV/AMV
Connection voltage	3~, 50/60 Hz	230 V -15%...400 V +15%	3~, 50/60Hz	230 V -15%...400 V +15%
Rated power at max. current	40% ED I1max (250 A)(230V)	9 kVA	35% ED I1max (320A)(230V)	13.5 kVA
	40% ED I1max (250A)(400V)	8.5 kVA	35% ED I1max (320A)(400V)	12.5 kVA
Supply current	40% ED I1max (250A)(230V)	22.2 A	35% ED I1max (320A)(230V)	33.3 A
	40% ED I1max (250A)(400V)	12.3 A	35% ED I1max (320A)(400V)	17.8 A
	100% ED I1eff (150A)(230V)	10.8 A	100% ED I1eff (190A)(230V)	14.8 A
	100% ED I1eff (150A)(400V)	6.2 A	100% ED I1eff (190A)(400V)	8.3 A
Connection cable	H07RN-F	4G1.5 (1.5 mm <sup>2</sup> , 5 m)	H07RN-F	4G1.5 (1.5 mm <sup>2</sup> , 5 m)
Fuse	Type C (230V)	16 A	Type C (230V)	16 A
	Type C (400V)	10 A	Type C (400V)	10 A
Welding range	10V/20A - 31V/250A		10V/20A - 32.5V/320A	
Power factor at max.	250A/26.5V (230V)	0.94	320A/30V (230V)	0.94
	250A/26.5V (400V)	0.93	320A/30V (400V)	0.94
Efficiency at 100% ED	150A/21.5V (230V)	0.79	190A/23.5V (230V)	0.80
	150A/21.5V (400V)	0.82	190A/23.5V (400V)	0.83
Wire feed speed adjustment range		1.0-18.0m/min		1.0-20.0m/min
Voltage adjustment range		8.0-31.0V		8.0-32.5V
External dimensions	L x W x H	623 x 579 x 1070 mm	L x W x H	623 x 579 x 1070 mm
Weight (without gun and cables)		44 kg		44 kg
EMC class		A		A
Standards: IEC 60974-1, IEC 60974-5, IEC 60974-10				

## Ordering information

Kempact RA		
Kempact 251R, GX 253 G, 3.5m	P2203GX	
Kempact 251R, GX 253 G, 5m	P2204GX	
Kempact 251A, GX 253 G, 3.5m	P2205GX	
Kempact 251A, GX 253 G, 5m	P2206GX	
Kempact 253R, GX 303 G, 3.5m	P2207GX	
Kempact 253R, GX 303 G, 5m	P2208GX	
Kempact 253A, GX 303 G, 3.5m	P2209GX	
Kempact 253A, GX 303 G, 5m	P2210GX	
Kempact 323R, GX 403 G, 3.5m	P2211GX	
Kempact 323R, GX 303 G, 3.5m	P2229GX	Only 300A/35% range
Kempact 323R, GX 403 G, 5m	P2212GX	
Kempact 323R, GX 303 G, 5m	P2230GX	Only 300A/35% range
Kempact 323A, GX 403 G, 3.5m	P2213GX	
Kempact 323A, GX 303 G, 3.5m	P2231GX	Only 300A/35% range

Kempact 323A, GX 403 G, 5m	P2214GX	
Kempact 323A, GX 303 G, 5m	P2232GX	Only 300A/35% range
Kempact 253AMV, GX 303 G, 3.5m	P2217GX	
Kempact 253AMV, GX 303 G, 5m	P2218GX	
Kempact 323RMV, GX 403 G, 3.5m	P2219GX	
Kempact 323RMV, GX 303 G, 3.5m	P2233GX	Only 300A/35% range
Kempact 323RMV, GX 403 G, 5m	P2220GX	
Kempact 323RMV, GX 303 G, 5m	P2234GX	Only 300A/35% range
Kempact 323AMV, GX 403 G, 3.5m	P2221GX	
Kempact 323AMV, GX 303 G, 3.5m	P2235GX	Only 300A/35% range
Kempact 323AMV, GX 403 G, 5m	P2222GX	
Kempact 323AMV, GX 303 G, 5m	P2236GX	Only 300A/35% range
Carbon electrode holder	9592106	
Carbon electrode 10-100	4192160	
Carbon electrode holder M10X1	W020273	