

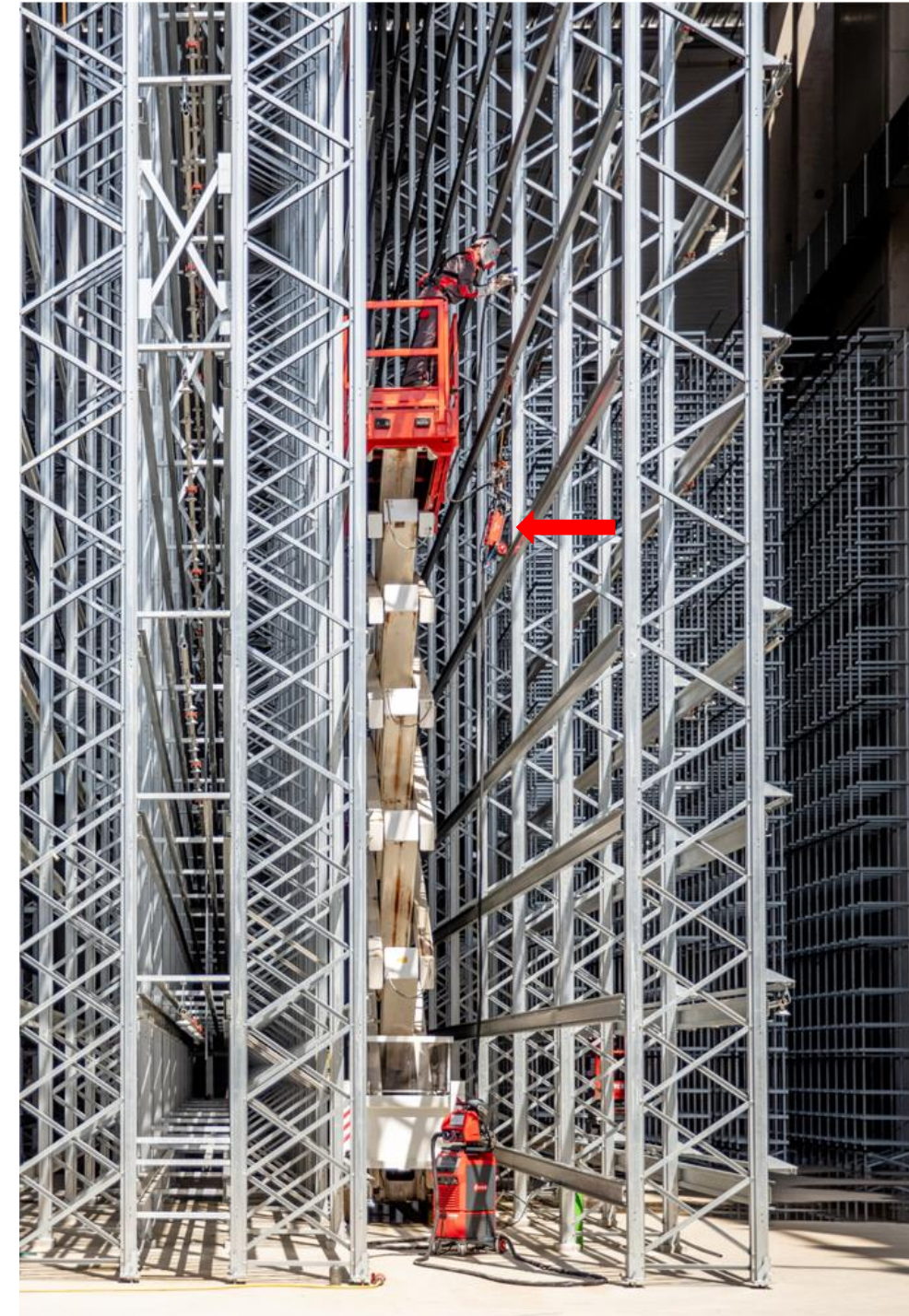
# WF 25i FlexDrive



Fronius International, PM Welding torches  
Information Class: Confidential

# WF 25i FlexDrive

- Small and portable intermediate drive between wire feeder and welding torch
- Extended action radius: Up to 25m distance between main wire feed and welding point
- Hanging up with hooks possible
- Using of wire from drum possible
  - Reduced change cycles
  - Cheaper price per kilo



# Size

Drive unit: 404 x 104 x 128 mm

Incl. cage: 736 x 156 x 149 mm

Incl. cage & wheels: 736 x 303,5 x 235 mm

# Weight

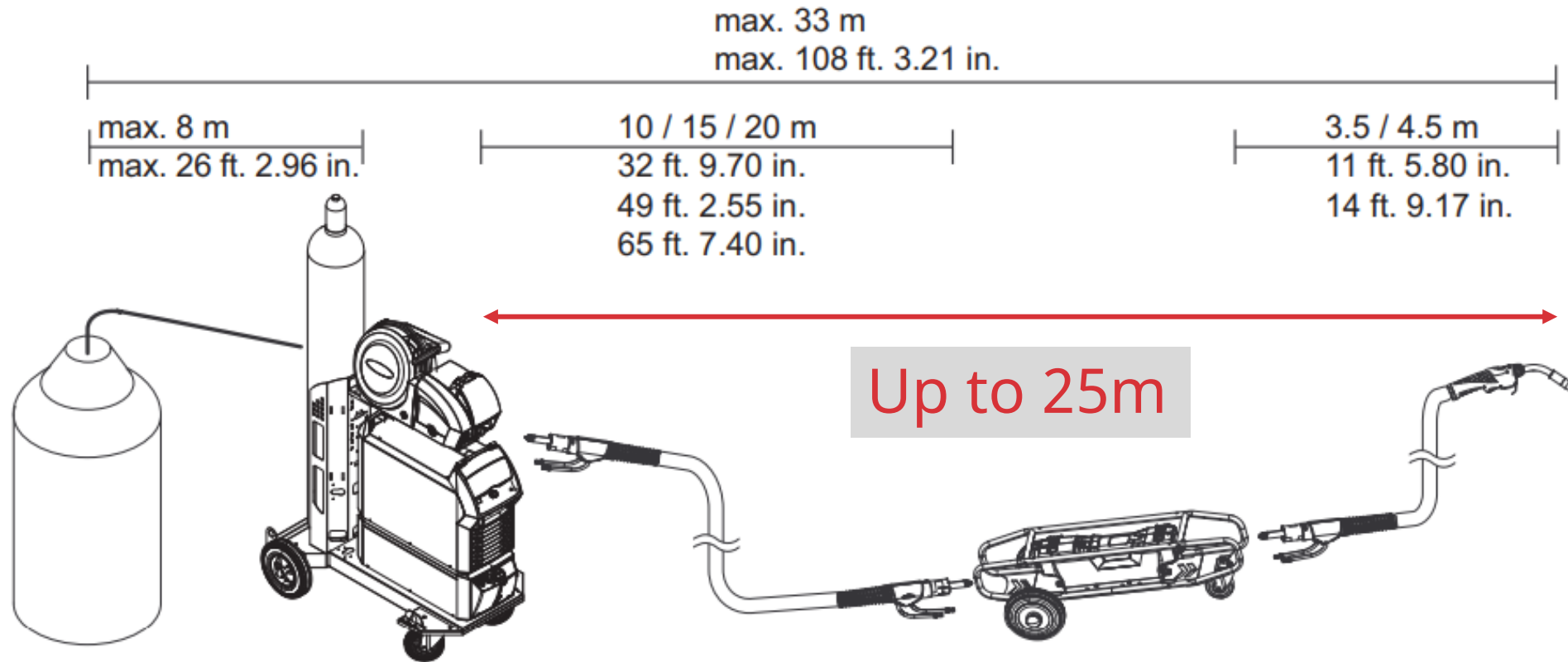
Drive unit: 4,4 kg

Incl. cage: 8,1 kg

Incl. cage & wheels: 10,4 kg



# Systematic description



Compatible with all **TPS/i power sources**

WF 25i and WF 25i FlexDrive are **synchronized**

# WF 25i FlexDrive

- **Technical data**

- **watercooled:**

- 320A 100% duty cycle
    - 400A 60% duty cycle

- **gascooled:**

- 260A 100% duty cycle
    - 400A 40% duty cycle

- Wire diameter: 0,9 – 1,6mm

- Wire feed speed: 1 - 25m/min.

- Protection class: IP 20

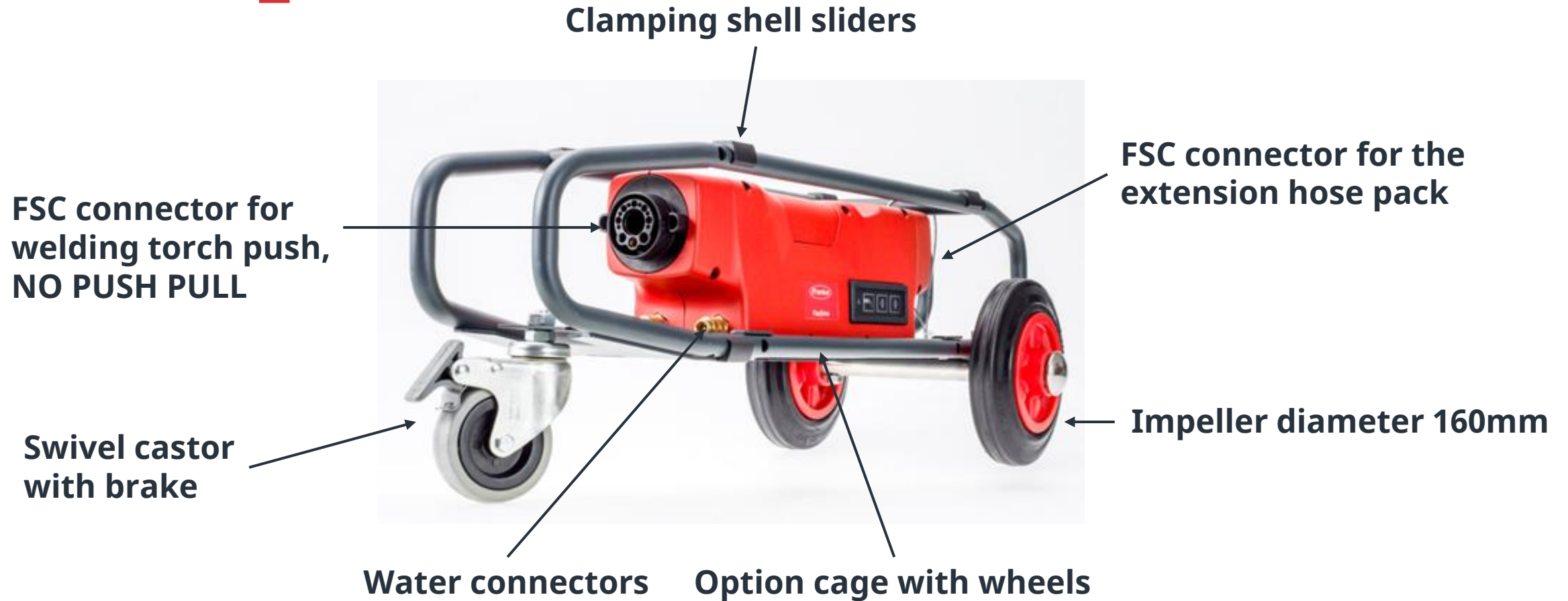
- **Certification:**

- CE
  - CSA planned (no date available)

- Needed Software version 3.2.0

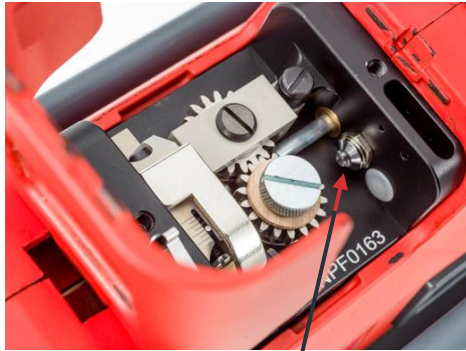


# Setup



# Setup

New wire feed rollers



LED lighting

Arrow for feed direction

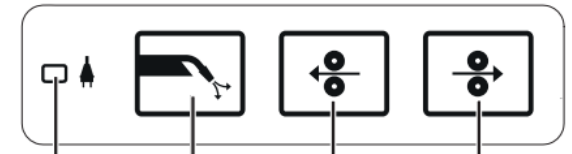


Arrows for feed direction

Jobmaster Userinterface  
(JM Variante)



**Wire feeding interface:**  
Operating status LED, Gas-test  
button, Wire-threading button,  
Wire-return button



# Fields of application

Wagon construction and Locomotive construction

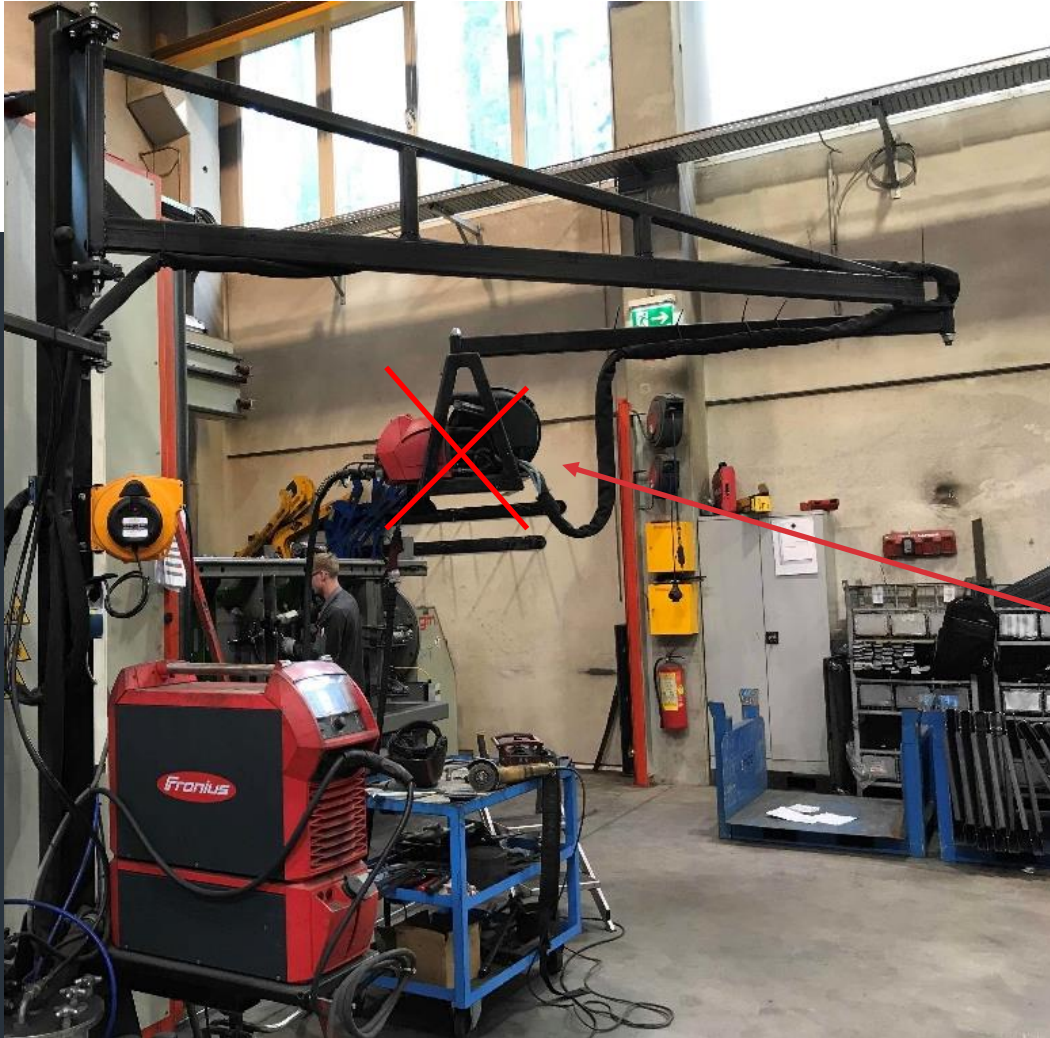


e.g Bombardier



# Fields of application

Welding cells with gallows



No more climbing up to change wire



# Fields of application

General Industry



Bridge construction



Container construction



Shipbuilding



All applications where it is difficult to carry the power source and wire feeder

# Video FlexDrive Practice



# Part numbers

## FlexDrive:

- 4,036,532 WF 25i FlexDrive G/W
- 4,036,533 WF 25i FlexDrive G/W JM



## Cage:

- 44,0350,1760 OPT/i FlexDrive Cage (incl. rollers)



## Protection Bag (without picture):

- 42,0411,0500, Protection Bag FlexDrive



# Part numbers

## Hose pack gascooled:

- 4,051,524 HP FlexDrive FSC/G/10m
- 4,051,525 HP FlexDrive FSC/G/15m
- 4,051,526 HP FlexDrive FSC/G/20m

## Hose pack watercooled:

- 4,051,527 HP FlexDrive FSC/W/10m
- 4,051,528 HP FlexDrive FSC/W/15m
- 4,051,529 HP FlexDrive FSC/W/20m



Hose pack will be equipped with steel inner liner coated (suitable for all materials)

# Part numbers BasicKits

## Steel, stainless steel and CuSi

- 44,0350,1700 BK FlexDrive FE 0,9
- 44,0350,1701 BK FlexDrive FE 1,0
- 44,0350,1702 BK FlexDrive FE 1,2
- 44,0350,1703 BK FlexDrive FE 1,6

## Aluminium

- 44,0350,1704 BK FlexDrive AL 1,0
- 44,0350,1705 BK FlexDrive AL 1,2
- 44,0350,1706 BK FlexDrive AL 1,6

## Flux cored wires

- 44,0350,1707 BK FlexDrive FC 1,0
- 44,0350,1708 BK FlexDrive FC 1,2
- 44,0350,1713 BK FlexDrive FC 1,6

– Basic kit includes wire feed rollers, wire guide tubes, clamping piece

– Basic kit for the Standard welding torch must be ordered additionally.

# FlexDrive

## Protection bag (42,0411,0500)



- Protective bag for FlexDrive protects the drive unit and central connections from dirt



- Robust material protects against sharp edges and makes it easier to glide over obstacles
- There are two viewing windows on the bag so you can operate the buttons from the outside and read the display.

# Mandatory option

## OPT/i PushPull

Attention!

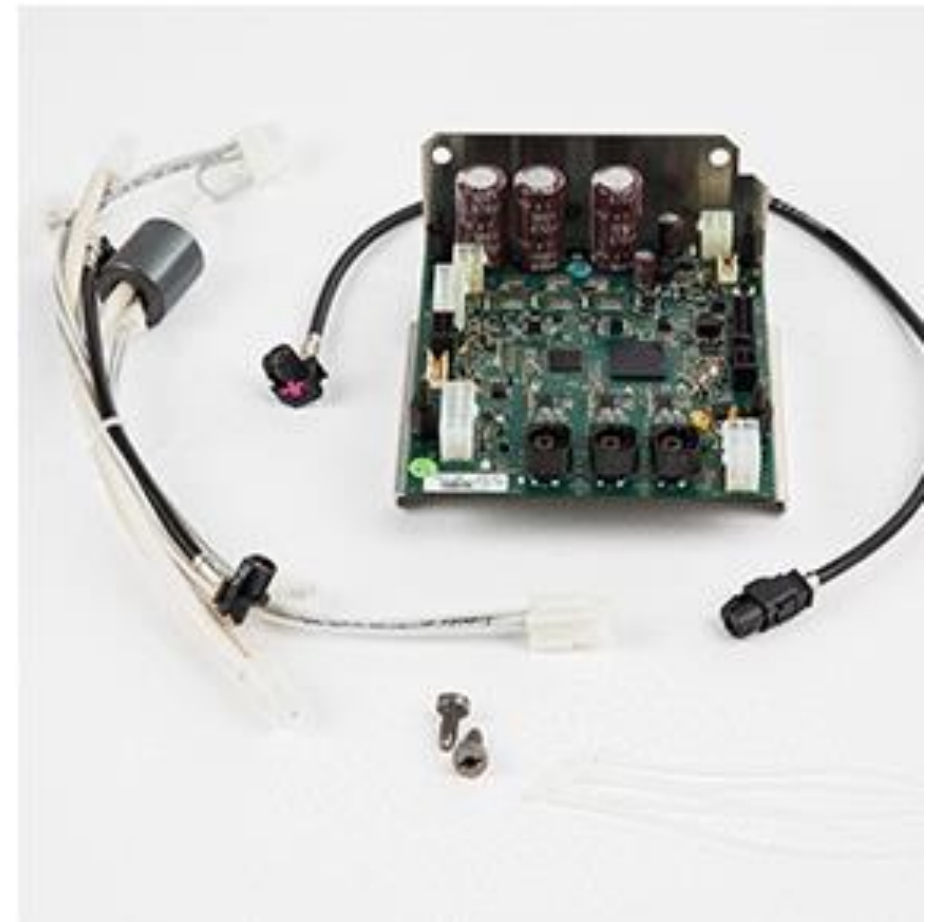
OPT/i PushPull must also be ordered as an option

Compact version – option for power source

– 4,100,803,IK OPT/i TPS 320i C PushPull / IK

Split version – Option for wire feeder

– 4,100,829,IK OPT/i WF PushPull / IK



# Cooling device recommendation

## Selection of cooling units

The following table gives an overview of the cooling unit selection depending on the maximum welding current at the welding torch and the length of the extension hosepack.

| $I_{\max}$ [A] | CU 800t | CU 1100i | CU 1400i Pro | CU 1400i PRO MC | CU 2000i Pro MC Single | CU 2000i Pro MC TWIN |
|----------------|---------|----------|--------------|-----------------|------------------------|----------------------|
|                | 10 m    | 10 m     | 10 m         | 10 m            | 10 m                   | 10 m                 |
| 200            | -       | 15 m     | 15 m         | 15 m            | 15 m                   | 15 m                 |
|                | -       | 20 m     | 20 m         | 20 m            | 20 m                   | 20 m                 |
|                | -       | 10 m     | 10 m         | 10 m            | 10 m                   | 10 m                 |
| 240            | -       | -        | 15 m         | 15 m            | 15 m                   | 15 m                 |
|                | -       | -        | 20 m         | 20 m            | 20 m                   | 20 m                 |
|                | -       | -        | 10 m         | 10 m            | 10 m                   | 10 m                 |
| 280            | -       | -        | -            | -               | 15 m                   | 15 m                 |
|                | -       | -        | -            | -               | -                      | 20 m                 |
|                | -       | -        | -            | -               | 10 m                   | 10 m                 |
| 320            | -       | -        | -            | -               | -                      | 15 m                 |
|                | -       | -        | -            | -               | -                      | 20 m                 |

The values apply for a duty cycle ED = 100%

$I_{\max}$  ... maximum welding current at the welding torch, L = 4.50 m / 14 ft. 9.17 in.

10 / 15 / 20 m ... Length of extension hosepack

CU ... cooling unit to be selected

10 m = 32 ft. 9.70 in., 15 m = 49 ft. 2.55 in., 20 m = 65 ft. 7.40 in.



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