

MIG

STICK

TIG DC-Lift

CIGWELD

AN ESAB BRAND

BLUEVENOM XF252

MULTI PROCESS WELDING INVERTER

Step up to MIG SINGLE & DOUBLE PULSE with the optional PulseMate™.



DESIGNED & TESTED
IN AUSTRALIA
FOR OVER 100 YEARS



FINALLY, A SIMPLE TO USE,
MODULAR SYSTEM WITH
SERIOUS VERSATILITY!



MIG



STICK



LIFT TIG



PLATE THICKNESS CONTROL



UP TO 14mm PLATE THICKNESS



SPOOL GUN COMPATIBLE



PUSH-PULL GUN COMPATIBLE



PULSEMATE COMPATIBLE

DESIGNED, DEVELOPED & TESTED IN AUSTRALIA!

The new BlueVenom™ XF252 is a 3-in-1 multiprocess welding inverter that has been specifically engineered to be narrower in size for easy access in tight and constrained areas but also as a modular arc station!

As a compact unit you will have access to Xtra Functions that allows the machine to be used for standard MIG / STICK / TIG DC-Lift processes, or as a Synergic MIG with Plate Thickness Selection as standard.

To take it a step further, the XF252 can connect to the All-New 4R-Rover™ remote wirefeed system (sold separately) - a plug n' play, 4 Roll wire drive unit that you can setup where you need it.

Need it on a gantry or boom? No problem, with the 8m interconnection cable and in-built hanging mount, you can! PLUS, its designed specifically with a low mount handle making this little gem as compact a 300mm wire spool system can be!



EASY TO SET for PROFESSIONAL RESULTS

Here's the kicker - want Pulse? Of course you do!

Turn your XF252 arc station into a single and double pulse work horse! Simply plug in the hand-held PulseMate™ pendant (sold separately) equipped with 8m of lead into the XF252 machine or 4R-Rover™ and start getting TIG like looking welds through our simple yet intuitive SimplePulse™ MIG system!

The BlueVenom™ XF252 is the perfect solution for light to medium fabrication, maintenance and industrial repairs in the workshop, worksite, shipyard, or marina without compromising on quality or professional performance! Use it with the included BZ36 MIG Gun or swap it out for a Push-Pull or Spool Gun (each sold separately) for more precise control.



CIGWELD Flame Series BZ24 Spool Gun,
6m with EURO connector



CIGWELD Flame Series BZ36 Push-Pull
Gun, 8m with EURO connector



CIGWELD Data Sheet **BlueVenom XF252 V1-2024**
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DESCRIPTION

The XF252 can deliver awesome arc characteristics in the most popular processes of, MIG - QuickSet & Manual modes, Gas & Gasless operation, Single & Double Pulse MIG with the optional PulseMate™, STICK (MMA with VRD for extra safety) and TIG DC- Lift welding modes.

Additionally, this machine has the following features:

- 4x Roll Wire Drive system
- 300mm Diameter Spool Capability and includes 200mm spool adapter
- MIG Gun holder and cable management bracket
- Engineered Gas Cylinder holder for up to 'G' Size cylinders
- 4-Point Lifting Lugs for safer and convenient maneuverability
- Locking brackets for 4R-Rover to avoid wirefeeder sliding
- MIG Adjustable Wire Burnback
- MIG Crater Fill function in 2T & 4T
- MIG Side door wire installation, side loader
- MIG Anti de-spooling safety feature
- MIG PulseMate™, Spool Gun & Push-Pull Gun Compatible
- STICK with Voltage Reduction Device (VRD) built-in for Safe Welding
- STICK Hot Start
- STICK Arc Force
- TIG Foot Control Compatible
- TIG Dial Remote Torch Compatible

SERIOUS VERSATILITY

The BlueVenom™ XF252 is fitted with Input Supply Rating Settings for 15A or 25A that is selectable via the Advanced Setting Menu using a 3 Digit Pin Code. It delivers a maximum output of 250Amps DC in MIG and TIG Modes, which means the machine is capable of welding metals from 1.0mm up to 14mm. In STICK mode the machine is capable of welding metals from 1.6mm up to 20mm in thickness.

WARRANTY PERIOD

3-Year conditional warranty. See terms and conditions at cigweld.com.au or in the Operating Manual, included with the machine.



XF252 PACKAGE CONTENTS

- BlueVenom™ XF252 Power Source
- MIG Gun BZ36 "Style", 4m, Euro
- Work Clamp 300A with 4m Lead
- Twistlock Electrode Holder 400A with 4m Lead
- Feed Rolls: 0.9/1.2mm V Groove (fitted), 1.0/1.2mm U Groove, 0.9/1.2mm Gasless Knurled
- Gas Regulator/Flowmeter
- Quick Connect Gas Hose 3m
- Operating Manual



ORDERING DETAILS

BlueVenom™ XF252 Power Source

P/N: W1400252



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TECHNICAL SPECIFICATIONS

Power Source Dimensions	(L) 1075mm x (W) 460mm x (H) 865mm	
Power Source Weight	55kg	
Cooling	Fan Cooled	
Standards	AS 60974.1:2020 / IEC 60974-1:2019 EN 60974-10:2021	
Number of Phases	Single Phase	
Nominal Supply Voltage	230/240 VAC ± 15%	
Nominal Supply Frequency	50/60Hz	
Nominal DC Open Circuit Voltage MIG Weld Mode	53V	
Open Circuit Voltage (VRD On) Stick Weld Mode	<35V	
Open Circuit Voltage (VRD Off) Stick Weld Mode	53V	
Open Circuit Voltage Lift TIG Weld Mode	53V	
Supply Lead and Plug Rating	15A Ratings below apply to the Factory Fitted 2.5mm ² Supply Lead & 15A Plug	25A Ratings below apply to an Upgraded 4mm ² Supply Lead & 25A Plug Fitted
Welding Current Range (MIG mode)	30-220A	30 - 250A
Welding Current Range (Stick mode)	20 - 205A	20 - 230A
Welding Current Range (TIG DC Lift)	20 - 250A	20- 250A
Effective Input Current (I _{eff})	14.8 Amps (230VAC) 14.2 Amps (240VAC)	22.7 Amps (230VAC) 21.8 Amps (240VAC)
Maximum Input Current (I _{1max})	33.1 Amps (230VAC) 31.7 Amps (240VAC)	38.4 Amps (230VAC) 36.8 Amps (240VAC)
Minimum Single Phase Generator Requirement for Maximum Output	10kVA@0.8PF	12kVA@0.8PF
MIG (GMAW) Welding Output, 40°C, 10 min	220A @ 20%, 25.0V 127A @ 60%, 20.4V 98A @ 100%, 18.9V	250A @ 35%, 26.5V 191A @ 60%, 23.5V 148A @ 100%, 21.4V
Stick (MMAW) Welding Output, 40°C, 10 min	205A @ 20%, 28.2V 118A @ 60%, 24.7V 92A @ 100%, 23.7V	230A @ 35%, 29.2V 176A @ 60%, 27.0V 136A @ 100%, 25.4V
TIG DC Lift (GTAW) Welding Output, 40°C, 10 min	250A @ 20%, 20.0V 144A @ 60%, 15.8V 112A @ 100%, 14.5V	250A @ 35%, 20.0V 191A @ 60%, 17.6V 148A @ 100%, 15.9V

Protection Class

IP21

**BLUEVENOM
4R-ROVER**

Get the Full Package (sold separately):

BlueVenom™ 4R-ROVER™ Wirefeeder - **P/N: W3200401**

BlueVenom™ PulseMate™ - **P/N: W4200PM1**

BZL36 Push-Pull Gun, 8m - **P/N: W52BP36E8**

BZL24 Spool Gun, 6m - **P/N: W52BS24E6**

**BLUEVENOM
PULSEMATE**



PulseMate™ and 4R-Rover Sold Separately.



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