

SPARTUS®



EasyMIG
219 Dual
Pulse

**STABILITY, PRECISION
AND RELIABLE WIRE FEEDING
THANKS TO 4 ROLLS**

■ **SPARTUS® EasyMIG 219 Dual Pulse** is a modern, mobile inverter welder designed for users who expect high-quality welds, especially when welding aluminium and stainless steel. The key advantages of this model include the **Dual Pulse mode**, the **Cool Pulse** function, and the **built-in 4-roll wire feeder**, which ensure process stability and full control over the weld pool.

MIG/MAG WELDING

– FULL PROCESS CONTROL

SPARTUS® EasyMIG 219 Dual Pulse offers **synergic MIG/MAG welding**, in which the machine automatically selects operating parameters according to the chosen material, wire diameter, and shielding gas. In addition, a **manual mode** is available, allowing full, hands-on adjustment of welding parameters to suit individual user preferences.

The use of **Pulse / Dual Pulse modes** allows precise control of heat input, ensuring a stable arc, an aesthetic weld face, and reduced spatter – especially when welding aluminium.

At low wire feed speeds, the machine automatically switches to **Cool Pulse mode**, limiting the amount of heat input. This makes it possible to weld thin components in a stable manner with minimal risk of overheating and distortion.

The unit is equipped with **2T/4T functions** allowing the selection of one of two trigger operating modes. Inductance control enables precise shaping of the arc characteristics, affecting spatter levels and metal transfer smoothness. The Post Gas function ensures shielding gas flow after welding is complete, protecting the weld and wire tip from oxidation and improving the quality and appearance of the finished joint.



Additionally, the machine can operate with a Spool Gun, further increasing work comfort in applications requiring maximum control over wire feeding.



SYNERGIC PROGRAMS

MIG SYNERGY

MATERIAL	PROCESS	SHIELDING GAS	WIRE DIAMETER
STEEL	MIG DC	100%CO ₂	0.8 - 1.0mm
STEEL	MIG DC	75%Ar + 25%CO ₂ mixed gas	0.8 - 1.0mm
FLUX-CORE WIRE	MIG DC	N/A	0.8 - 1.0mm

MIG PULSE / DUAL PULSE

MATERIAL	PROCESS	SHIELDING GAS	WIRE DIAMETER
STEEL	MIG DC	80%Ar+20%Co ₂	0.8 - 1.0mm
STAINLESS STEEL	MIG DC	80%Ar+20%Co ₂	0.8 - 1.0mm
STAINLESS STEEL	MIG DC	97.5%Ar+2.5%Co ₂	0.8 - 1.0mm
CuSi	MIG DC	100%Ar	1.0 - 1.2mm
AlSi	MIG DC	100%Ar	1.0 - 1.2mm
AlMg	MIG DC	100%Ar	1.0 - 1.2mm



■ 4-ROLL FEEDER

– STABLE AND PRECISE
WIRE FEEDING

The built-in **4-roll wire feeder** ensures even, stable wire feeding even during dynamic changes in welding parameters. The use of four pressure rolls translates into better control of the MIG/MAG process and high weld repeatability, which is crucial when working with soft aluminium wires and when welding in Pulse and Dual Pulse modes.



■ TIG DC LIFT AND MMA

– ADDITIONAL WELDING CAPABILITIES

SPARTUS® EasyMIG 219 Dual Pulse, in addition to advanced MIG/MAG welding, also offers the possibility of working with **TIG DC Lift** and **MMA** methods, significantly increasing the versatility of the machine. The MMA method is equipped with **Hot Start**, **Arc Force**, and **VRD** functions, which improve arc ignition, welding stability, and operator safety, enabling effective welding with coated electrodes in various conditions.



■ EQUIPMENT

All SPARTUS® Easy series welders are supplied as complete sets, including all necessary components to start work immediately.

Package equipmentd:

- EasyMIG 219DP
- **MIG gun SPE 150 3m**
- graphite wire liner
- steel liner coated
- wire guide rollers 1.0-1.2U fi30 + additionally 2x 0.8-1.0V fi30
- electrode holder
- work clamp
- gas hose
- user's manual

■ **SPARTUS® EasyMIG 219 Dual Pulse** is suitable for a wide range of welding applications – both in the workshop and in the field. The unit performs excellently when welding aluminium, stainless steel, and structural steel, as well as during CuSi brazing, where precise control of heat input and process stability are essential.

Thanks to its compact, mobile design, advanced MIG/MAG functions, and additional TIG DC Lift and MMA methods, **EasyMIG 219 Dual Pulse** is a versatile tool for workshop, installation, and service work, as well as for the production of lightweight structures and thin-walled components, where high quality, weld aesthetics, and repeatable results are key.



EASYMIG 219 DUAL PULSE

TECHNICAL PARAMETER

Input	~1× 230V ± 10% 50 / 60 Hz	TIG Lift	yes
MIG welding current	30 - 200A	TIG welding current	10 - 200A
MIG duty cycle	60%	MMA welding current	10 - 200A
Output working voltage	15.5 - 24V	Arc Force	yes
Wire feeder	built-in, 4-roll gear	Hot Start	yes
Welding wire spool	≤ 5kg / ø200mm	VRD	yes
Wire diameter	0.8, 1.0, 1.2mm	Current consumption	MIG 40A / TIG 30A / MMA 43A
Synergy	yes	Power factor (cosφ)	0.66
2T/4T control	yes	Efficiency η	84.3%
Additional MIG functions	DUAL PULSE, inductance, synergistic program, manual adjustment of parameters, inductance control, spool gun, wire test	Insulation class	H
		Protection class	IP21S
		Weight	13kg
		Dimensions	522 x 225 x 340mm

