Cables

The recommendations below are referring to both intermediary cable, return cable and torch cable. When 10 meter is recommended, this is equal to 10 meter intermediary cable and 7 meter return cable plus 3 meter torch cable. So the total length of cable is 20 meter in the welding circuit.

Calculate the correct copper cross section; see below, in order to limit the voltage loss to LESS than 10V on the complete welding system.

Longer cables can be used, but Migatronic only supports welding performance when the recommended cable lengths are used.

CAN based intermediary cables are supported up to 30 meters only.

Welding process	Distance to work piece	Total cable length in welding circuit
MIG - IAC and pulse	10 meters	20 meters
MIG - non pulse	ANALOG 70 meters CAN 30 meters	140 meters 60 meters
TIG - HF ignition		
Using Ar	15 meters	30 meters
Using ArH2 - ArHe	6 meters	12 meters
TIG - LifTIG ignition	40 meters	80 meters