



DOGMA / DOGMA PULSE

THE FIRST - THE GAME CHANGER



DOGMA



DOGMA PULSE

DOGMA is an innovative welding equipment that barges into the multi-process compact MIG market for the first time in the world.

DOGMA's concept breaks from tradition with its game changing design.

DOGMA is born with the welder's comfort at the centre of its development, keeping CEA's distinctive quality: every feature is aimed to reduce and simplify the operator's preparation time and tasks for a better satisfaction which leads to greater results.

DOGMA is unique and unparalleled in its ability to combine an ergonomic design, together with excellent welding characteristics thanks to its precise and stable arc control. This makes **DOGMA** perfect for all qualified welding applications in all industrial sectors.

DOGMA are standard equipped with the new X VISION interface, simple and complete, for the total control and monitoring of all the welding parameters.

DOGMA offers the possibility to weld in synergic MIG/MAG, TIG Lift and MMA; in addition, **DOGMA** are also available in the **DOGMA PULSE** version with Pulse and Dual-Pulse welding processes.

NEW



vision.PULSE

- Innovative, unique, unparalleled
- Exceptional welding quality
- New level of Ergonomics

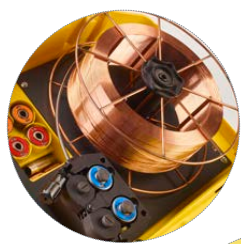


PATENT PENDING:
PA102974IT01



DOGMA INNOVATIVE DESIGN

- Easy-to-load wire coil thanks to the spool holder's top frontal ergonomic position
- Easy to control and insert welding wire into the feeding mechanism thanks to its high frontal position
- Great frontal visibility of the wire feeder compartment and control interface at first glance
- Interface control panel in an inclined frontal position
- The equipment's vertical development saves space and floor area
- High position of the torch connector with inclined exit to optimize the welding wire's flow
- Feeding rolls compartment next to the wire feeding mechanism for quick replacement
- Water cooling equipment integrated in the power source (W version)



**EASY-TO-LOAD
WIRE COIL**



**INCLINED TORCH
CONNECTION**



**GREAT FRONTAL
VISIBILITY**



**REDUCED FLOOR
OCCUPATION**



DOGMA FEATURES

- Multi-process power sources: MMA - TIG LIFT - MIG/MAG Synergic & Manual and for DOGMA PULSE: PULSED MIG and DUAL PULSE
- Digital control of the welding parameters with preset synergic curves
- Feeding mechanism with 4 rolls of large diameter for a precise and constant wire driving
- Double groove rolls replaceable without any tool
- "Energy saving" function to operate the power source cooling fan and torch water cooling only when necessary
- Excellent arc striking always precise and efficient
- Ability to partially or totally lock the equipment with access key by password





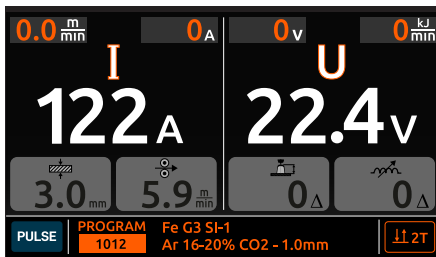
X VISION CONTROL DISPLAY

X Vision control display with "TWO CLICK KNOB" encoders for the pre-setting and monitoring of all the welding parameters:

- User friendly interface
- Welding mode "cycle"
- Personalised welding program storing and recalling
- Possibility of copying job/s easily from one machine to another via USB
- Advance setting infographic



WELDING MODE



WELDING SETTING MODE

MATERIAL	Fe G3 SI-1			
DIAMETER	1.2 mm			
GAS	Ar 16-20% CO2			
PROCESS	MIG PULSE			
PROGRAM	013			
PULSE PROGRAM Fe G3 SI-1 Ar 16-20% CO2 - 1.2mm				
PRG	MODE	FX	JOB	MENU

ADVANCE JOB MANAGEMENT

COPY JOB			
J01	SYNERGIC 1	0.5 s	122A
J01	DOUBLE PULSE	0.3 s	155A
DOUBLE PULSE	PROGRAM 2011	Ar 16-20% CO2 - 0.8mm	↑↓ 2T
J07	MANUAL	0.0 s	12.0 m/min

DOGMA PACKAGE

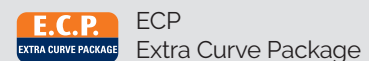
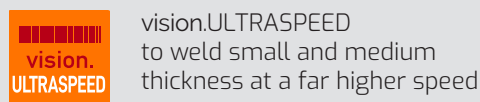
DOGMA XV and **DOGMA XV PREMIUM** are available with the innovative vision.COLD and vision.ULTRASPEED processes, dedicated to anyone looking for a higher performance welding equipment with maximum flexibility on different materials.


DOGMA PULSE XV

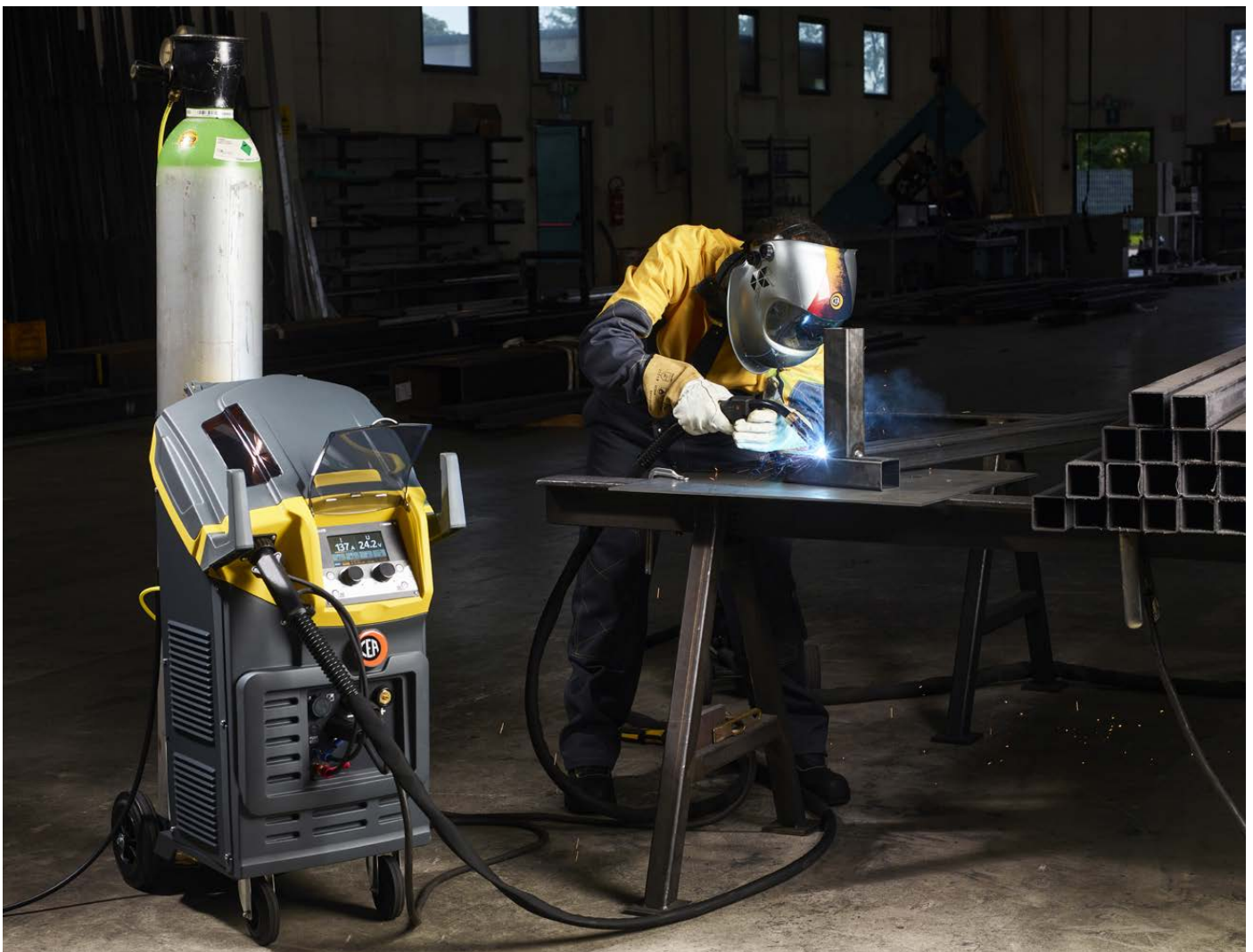
Standard fitted with:
SYNERGIC PROGRAMS Fe - CrNi - AlMg - AlSi

DOGMA XV / DOGMA PULSE XV PREMIUM

Standard fitted with:
SYNERGIC PROGRAMS Fe - CrNi - AlMg - AlSi - CuSi3 - AlBz8 - FCW (Rutil - Basic - Metal) Duplex - Super Duplex



TECHNICAL DATA		DOGMA			DOGMA PULSE		
		272 XV / 272 W XV	322 XV / 322 W XV	402 XV / 402 W XV	276 XV / 276 W XV	326 XV / 326 W XV	406 XV / 406 W XV
Three phase input 50/60 Hz	V +/- 20%	400	400	400	400	400	400
Input Power @ P ² Max	kVA	11,0	12,6	16,8	11,0	12,6	17,3
Delayed Fuse (I _{eff})	A	16	16	20	16	16	20
Power Factor / cos φ		0,74/0,99	0,87/0,99	0,92/0,99	0,74/0,99	0,87/0,99	0,92/0,99
Efficiency Degree		0,89	0,88	0,88	0,89	0,88	0,88
Open circuit voltage	V	60	63	63	60	63	63
Current range	A	10 - 270	10 - 320	10 - 400	10 - 270	10 - 320	10 - 400
Duty cycle at (40°C)	A 100 %	180	240	300	180	240	300
	A 60 %	200	270	340	200	270	340
	A X %	270 (30%)	320 (35%)	400 (35%)	270 (30%)	320 (35%)	400 (35%)
Wire	Ø mm	0,6 - 1,6	0,6 - 1,6	0,6 - 1,6	0,6 - 1,6	0,6 - 1,6	0,6 - 1,6
Standards		EN 60974-1 • EN 60974-5 • EN 60974-10 • 					
Protection Class	IP	23 S	23 S	23 S	23 S	23 S	23 S
Dimensions (L x W x H)	mm	792 x 463 x 1047	792 x 463 x 1047	792 x 463 x 1047	792 x 463 x 1047	792 x 463 x 1047	792 x 463 x 1047
Weight	Kg	45 / 54 (W)	48 / 57 (W)	53 / 62 (W)	45 / 54 (W)	48 / 57 (W)	53 / 62 (W)



ORDER INFORMATION

CODE	DESCRIPTION	DOGMA XV					
		272 AIR	272 W WATER	322 AIR	322 W WATER	402 AIR	402 W WATER
POWER SOURCES							
004621	Power Source DOGMA 272 XV 400V (4 rolls for wire Ø 0,8÷1,0 mm)	●					
004622	Power Source DOGMA 322 XV 400V (4 rolls for wire Ø 0,8÷1,0 mm)			●			
004623	Power Source DOGMA 402 XV 400V (4 rolls for wire Ø 1,0÷1,2 mm)					●	
004626	Power Source DOGMA 272 W XV water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)		≈				
004627	Power Source DOGMA 322 W XV water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)				≈		
004628	Power Source DOGMA 402 W XV water cooled 400V (4 rolls for wire Ø 1,0÷1,2 mm) <i>vision.COLD and vision.ULTRASPEED process and ECP integrated as a standard in all DOGMA 272 - 322 - 402</i>						≈
ALUMINIUM KIT							
030866	Aluminium Kit of Single grooved TWIN rolls (Ø: 1,0)						
030867	Aluminium Kit of Single grooved TWIN rolls (Ø: 1,2)						
MIG MAG WELDING TORCHES							
020458	CEA Torch CX 251/3 3m - wire: Ø 0,6÷1,0 CO2 260A @60% / Mix 200A @60%	●					
020465	CEA Torch CX 353/4 4m - wire: Ø 0,8÷1,2 CO2 340A @60% / Mix 290A @60%			●		●	
020472	CEA Torch CXH 302/4 4m - wire: Ø 0,8÷1,2 water cooled CO2 300A @100% / Mix 250A @100%		≈		≈		
020479	CEA Torch CXH 402/4 4m - wire: Ø 0,8÷1,6 water cooled CO2 500A @100% / Mix 450A @100%						≈
020488	Push Pull Torch PP 401 D 8 m 24 V - wire Ø 0,8÷1,2 water cooled (to be ordered w. 031113)						
031113	Push Pull Synchronizer PC Board KIT 24/42 V (to be ordered with Push Pull torch) <i>For other torches see mig/mag torches</i>						
TIG TORCHES WITH BUILT-IN GAS VALVE FOR TOUCH-START TECHNIQUE							
020568	Torch RTX 26.4 4 m - 180 A 35%						
GROUND CABLES							
239601	35 mm² / 4 m Ground cable with clamp	●	≈				
239603	50 mm² / 4 m Ground cable with clamp			●	≈	●	≈
GAS REDUCERS							
020916	Reducer with flowmeter and 1 manometer	●	≈	●	≈	●	≈
OTHER OPTION[S]							
236590	Metallic spool adaptor						
402275A	Cea CL-1100 cooling liquid - 5 l Tank		≈		≈		≈
	DOGMA 272 XV Suggested air cooled version with torch	●					
	DOGMA 272 W XV Suggested water cooled version with torch		≈				
	DOGMA 322 XV Suggested air cooled version with torch			●			
	DOGMA 322 W XV Suggested water cooled version with torch				≈		
	DOGMA 402 XV Suggested air cooled version with torch					●	
	DOGMA 402 W XV Suggested water cooled version with torch						≈

ORDER INFORMATION

CODE	DESCRIPTION	DOGMA PULSE XV					
		276 AIR	276 W WATER	326 AIR	326 W WATER	406 AIR	406 W WATER
POWER SOURCES							
004855	Power Source DOGMA 276 PULSE XV 400V (4 rolls for wire Ø 0,8÷1,0 mm)	●					
004860	Power Source DOGMA 326 PULSE XV 400V (4 rolls for wire Ø 0,8÷1,0 mm)			●			
004865	Power Source DOGMA 406 PULSE XV 400V (4 rolls for wire Ø 1,0÷1,2 mm)					●	
004870	Power Source DOGMA 276 W PULSE XV water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)		≈				
004875	Power Source DOGMA 326 W PULSE XV water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)				≈		
004880	Power Source DOGMA 406 W PULSE XV water cooled 400V (4 rolls for wire Ø 1,0÷1,2 mm)						≈
STANDARD MODELS include Programs for Fe - CrNi - Al and TIG / MMA functions							
PREMIUM VERSION - POWER SOURCES							
004855PR	Power Source DOGMA 276 PULSE XV PREMIUM 400V (4 rolls for wire Ø 0,8÷1,0 mm)						
004860PR	Power Source DOGMA 326 PULSE XV PREMIUM 400V (4 rolls for wire Ø 0,8÷1,0 mm)						
004865PR	Power Source DOGMA 406 PULSE XV PREMIUM 400V (4 rolls for wire Ø 1,0÷1,2 mm)						
004870PR	Power Source DOGMA 276 W PULSE XV PREMIUM water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)						
004875PR	Power Source DOGMA 326 W PULSE XV PREMIUM water cooled 400V (4 rolls for wire Ø 0,8÷1,0 mm)						
004880PR	Power Source DOGMA 406 W PULSE XV PREMIUM water cooled 400V (4 rolls for wire Ø 1,0÷1,2 mm)						
PREMIUM MODELS included already install - vision.COLD, vision.ULTRASPEED process and ECP							
ALUMINIUM KIT							
030866	Aluminium Kit of Single grooved TWIN rolls (Ø: 1,0)						
030867	Aluminium Kit of Single grooved TWIN rolls (Ø: 1,2)						
MIG MAG WELDING TORCHES							
020458	CEA Torch CX 251/3 3m - wire: Ø 0,6÷1,0 CO2 260A @60% / Mix 200A @60%	●					
020465	CEA Torch CX 353/4 4m - wire: Ø 0,8÷1,2 CO2 340A @60% / Mix 290A @60%			●		●	
020472	CEA Torch CXH 302/4 4m - wire: Ø 0,8÷1,2 water cooled CO2 300A @100% / Mix 250A @100%		≈		≈		
020479	CEA Torch CXH 402/4 4m - wire: Ø 0,8÷1,6 water cooled CO2 500A @100% / Mix 450A @100%						≈
020488	Push Pull Torch PP 401 D 8 m 24 V - wire Ø 0,8÷1,2 water cooled (to be ordered w. 031113)						
031113	Push Pull Synchronizer PC Board KIT 24/42 V (to be ordered with Push Pull torch)						
<i>For other torches see mig/mag torches</i>							
TIG TORCHES WITH BUILT-IN GAS VALVE FOR TOUCH-START TECHNIQUE							
020568	Torch RTX 26.4 4 m - 180 A 35%						
GROUND CABLES							
239601	35 mm ² / 4 m Ground cable with clamp	●	≈				
239603	50 mm ² / 4 m Ground cable with clamp			●	≈	●	≈
GAS REDUCERS							
020916	Reducer with flowmeter and 1 manometer	●	≈	●	≈	●	≈
OTHER OPTION[S]							
236590	Metallic spool adaptor						
402275A	Cea CL-1100 cooling liquid - 5 l Tank		≈		≈		≈
	DOGMA 276 PULSE XV Suggested air cooled version with torch	●					
	DOGMA 276 W PULSE XV Suggested water cooled version with torch		≈				
	DOGMA 326 PULSE XV Suggested air cooled version with torch			●			
	DOGMA 326 W PULSE XV Suggested water cooled version with torch				≈		
	DOGMA 406 PULSE XV Suggested air cooled version with torch					●	
	DOGMA 406 W PULSE XV Suggested water cooled version with torch						≈