



Thunder 255

MULTI-PROCESS

Specifications

Process:	GMAW-P/F-CAW/GTAW-P/SMAW	Input:	240V 1 Phase 50/60Hz	Output Range 240V:	MIG: 30-275A; 15.5-27.8V DC TIG: 10-250A; 10.5-20.0V Stick: 10-220A; 20.4-28V	I1Max (Inrush) 240V:	48A	I1Eff (Rated) 240V:	38A
Duty Cycle:	60% @ Max. Output Each Process	OCV:	80V	Drive Roll Size:	.035-.045" (.023-.030"; .030-.040" opt.)	Wire Spool Size:	12" (30-44 lbs.)	MIG Gun Type:	24 Series 3m.
Digital Display:	Color LCD 4.3" HD TFT	Weight:	65 lbs.	Dimensions:	20" H X 12" W X 27.5" L	Max. Wire Speed:	600 IPM	PowerSet Mode:	Yes
DC TIG Start:	HV (solid start HF type), Lift Start with Remote, Live Lift Start	MIG Pulse Type:	Single, Synergic	TIG Pulse Type:	Fully adjustable, with 0-500Hz capability	E 6010/Cellulose:	Yes, with setting.	Stick VRD:	Yes

Just pulsing with power.

Digital IGBT Inverter Power Output

Three welding processes combined in one unit. The advanced IGBT inverter design allows the unit to be built to "no compromise" performance standards. One process' performance is not compromised in favor of the others.

Large Digital Color Display

The large display 4.3" makes the main settings stand out at a distance so you can always see them at a glance from a distance. Color coding and graphics help you quickly identify and set parameters. New control layout design is not only sharp and clear, it is also easy

Cast Aluminum/Steel 4 Roller Wire Drive

Feed solid wire from .023 to .045" in diameter. For wires smaller than .045", optional drive rolls and guns/liners may be purchased for best spatter free operation.

Spool Gun and Push-Pull Gun Ready

If you need it, the unit is ready to weld with the optional Parker Spool Gun, Parker pistol style push-pull, or the Everlast In-line Premium Push-Pull systems for distance feeding of aluminum wire.

Tool-Free Euro Quick Connect

The best design used for connecting up your MIG gun period. No tools needed! Quickly and easily change the MIG gun with a lower chance of misalignment and leaking of mig gas. This Euro style has been around for 40 years and has proven itself to be one of the most popular designs in both North America and the world.



240V Operation

This unit operates easily on 240V 1 phase power, requiring a standard NEMA 6-50R outlet to power this unit.

Separate MIG and TIG Gas Connections

At the rear of the unit, the unit is equipped with two separate gas connections for independent MIG and TIG operations. No swapping of gas or regulators is required. This includes automatic gas control for TIG.

MIG and TIG Pulse Functions

The unit features a Synergic MIG Pulse Setting and a TIG pulse feature that is fully adjustable in standard mode. The MIG pulse is designed to offer further simplified setup in PowerSet mode.

PowerSet Function

No need to rely on complicated charts and menus to set up your machine. Simply select the desired process, and make basic inputs of wire/electrode size, and metal thickness and the unit adjusts to a useable setting automatically.

Remote Function

The unit supports the use of the included foot pedal or torch switch to control the weld functions and Amperage.

Easy Change of Polarity

Need to quickly change over for Flux-Cored wire, or back to solid wire? Need to change over to TIG from Stick? No problem.



5 Year Parts and Labor Warranty

The best warranty in the business just got better. Who else offers this without paying extra, or giving you a long list of exclusions?

Uses: Fabrication, Home Hobby, Automotive, Motor Sports and Portable Repair

Building a Legacy of Performance

A New Solution to an Old Problem.

When it comes to selecting the best welder for the application, it has always been a struggle trying to balance the needs of shop space, budget and performance expectations against each other. This was partially solved by the introduction of inverter welders into the job space decades ago. The compact size and capability of inverter welders did help alleviate a lot of space concerns and performance concerns, but did very little to address budget issues that many companies and individuals face. And for some having multiple welders in a shop is still a liability rather than an asset.

Focused on tackling these issues, Everlast pioneered a new concept in the 2000's that combined multiple welding processes into one portable unit. Everlast's all-in-one, multi-process inverter welder lineup not only reduced overall foot print in the shop, it also lowered final cost by reducing the total number of discreet parts needed. With this type inverter design, overall performance and reliability are naturally improved with the use of digitally controlled components that can be shared between each process. These digital components can be optimized to output and control each individual processes without forcing a compromise in performance or favoring one process over the other.

With the introduction of the fourth generation MTS from Everlast, the new

Thunder series improves upon the design concepts piloted in the PowerMTS series and further refines control functions with a new user interface. With completely new features and design concepts, the Thunder series build upon the legacy of the PowerMTS. New features such as a large LCD screen, fully synergic single pulse function, MIG spot/stitch timer/ gas shielded flux cored operation, DC pulse TIG with wave form control, push-pull MIG gun compatibility, improved memory with up to 30 saveable programs, Stick E6010 setting and an all new PowerSet function stand-out as new concepts in the Thunder 255 unit. These features are complimented by a long list of other features: foot pedal control, HF/lift with remote/live lift start for TIG, cooler plug in rear for optional water cooler, wire jog, gas purge, run in control and 4 roller drive systems. Other features found on the unit put the professional level user in complete control of the weld cycle, allowing nearly every function to be adjusted to personal preference or required operating style. For users who may be overwhelmed with so many settings, or for users requiring a simple setup process, the new PowerSet function can be used to preset many customizable features on the unit to operate in a more basic manner while delivering pro-level results. Everlast has sought to make the Thunder 255EXT the most complete and affordable Pulse MIG/DC TIG and DC Stick multi-process welder on the market.

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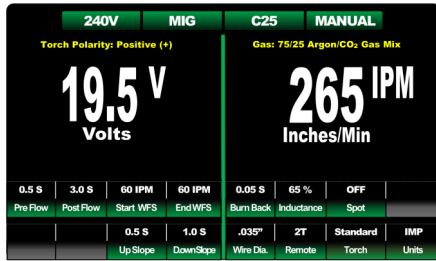
All specifications, accessories and options are subject to change without notice.

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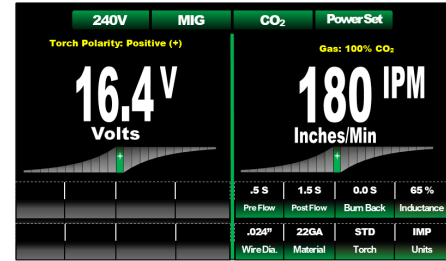
A bit closer up....

MIG Manual Mode



VS.

MIG Power Set Mode



Key Features:

1. The green information bar at the top provides status and process reminders.
2. Torch Polarity and Gas Reminders reduce error when switching processes.
3. Full list of adjustable features including Spot and Stitch Timers.
4. Adjustable Pre and Post Gas Flow improves weld quality.
5. Start/End WFS/A and slope combine to improve arc starts and crater fill.
6. Burn Back control helps prevent wire sticking in weld at stop.
7. Inductance tailors MIG arc characteristics and bead profile to user's needs
8. Select Imperial or Metric units for measurements and wire feed speed.
9. Remote operation selection changes torch trigger operation.
10. Numbers turn yellow to warn that the wire is crossing best short circuit settings and is crossing into spray arc and globular transfer range.
11. Unused settings are grayed-out when not applicable to the particular configuration of the welder. This helps eliminate confusion during setup.

Key Features:

1. Input wire dimensions and material thickness after selecting process and the welder will automatically choose useable settings.
2. The programming automatically limits maximum thickness for different wire diameters and types.
3. All modes feature PowerSet, tailored to the individual process.
4. Unique graphic symbols change colors from green to yellow to red when adjustments reach a critical range that may result in undesirable operation.
5. Range of adjustment is generous for fine tuning, but does offer limits to help prevent non-workable settings by the operator.
6. Many settings are automatically eliminated from the menu and are automatically controlled to make setup easier.



Intuitive Operator Interface



30 Saveable and Lockable Programs



8" (12 lbs) and 12" (44lbs) Spools
4 Roller Drive System



Dual Gas Inlets in Rear

Standard Equipment and Options



Standard Equipment:

- 10 ft (3m) 36 Series MIG Gun, #EV-DSP360A-24-P10-80ER
- 250A Work Clamp and 10 ft (3m) Cable
- 26 Series Air-Cooled TIG torch
- 250A Stick Electrode Holder and 10ft (3m) Cable
- Brass Billet Floating Ball Type Argon Regulator
- Foot Pedal
- Starter Consumable Kit for MIG and TIG

Recommended Options:

- 25 ft. Parker DSP 360A Spool Gun, #EV-DSP360A-24-P10-80ER
- 25 ft. Everlast MPG 300A Push-Pull Gun, #EV-MPG300A-25
- 10 ft. 24 Series Gun (For ≤.035" Wires order blue liner) #EV-MG24-3M
- 10 ft. Blue liner for .035 and under steel/stainless wires. #EV-GMO-500-BSL-10
- .023/.030" V Groove Drive Roll, #EV-DR-VG-0608-1
- .030/.040" V Groove Drive Roll, #EV-DR-VG-0810-1
- .023-.035" Blue Steel Liner, #EV-GM0500-BSL-10

Can this unit be operated on a generator?

The small size and portability of the Thunder makes it a great choice for portable welding. We want you to get the best life and performance out of the unit while operating on a generator, so please follow these guidelines when choosing this welder and using your generator to match.

- The generator must be rated as "Clean Power Output", This means that it provides 5% or less Total Harmonic Distortion. The generator manufacturer determines this rating. Consult with them before your purchase.
- The generator must provide at least 13,000 Surge Watts.
- Switch the welder off before powering down the generator. Do not run the generator out of fuel while the welder is switched on.
- Failure to follow these recommendations may void the welder warranty.

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