

# Portafeed® VS 212

15-100  
DC

425  
AMP



VS

## Performance, Features . . . and Reliability

**GOLD WARRANTY**  
3 Year\*

**NEW**

### Portafeed® VS 212 comes with:

- Robust injection molded case
- Changeable MIG gun cartridge system
- Digital display
- Heavy duty contactor
- Internal parts storage
- Power cable and drive rolls
- Gas solenoid valve

**Internal parts storage!** On the job storage for drive rolls, tips, nozzles, etc.

**Tough machined feed head & tension arm, geared top and bottom!** Heavy duty drive system designed for maximum performance on both small diameter gas-shielded wires and large diameter self shielded wires.

**Inch & purge switches!** 'Cold' wire inch and gas purge.

**Gun trigger hold (2T/4T)!** Allows standard or latched gun trigger.

**Heavy duty, removable voltage sensing lead!** Standard 25mm dinse sensing lead, easily stored or replaced.

**MIG gun holder!** MIG gun storage while not welding.

**Lifting eye!** Heavy duty lifting eye designed for permanent mounting or just lifting.

**Gas solenoid valve!** Controls 'on/off' flow of shielding gas.

**Wire speed high/low switch!** Allows precise wire feed control for both large diameter self-shielded and small diameter gas-shielded wires.

**Quick change drive rolls!** No tools required for quick changes in the field.

**Arc hour memory feature!** Records arc time for preventative maintenance schedules.

Note: Shown with MIG gun, not included

| Quick Specifications           |   |
|--------------------------------|---|
| <b>Processes</b>               | MIG (GMAW)<br>Flux Cored (FCAW)             |
| <b>Industrial Applications</b> | Construction<br>Field maintenance<br>Mining |
| <b>Drive Rolls</b>             | 2   |
| <b>Wire Speed Range</b>        | 50-800 IPM (1.27-20.32 m/min)               |
| <b>Wire Size Range</b>         | .023"-5/64" (0.6-2.0mm)                     |
| <b>Welding Current</b>         | 425A @ 60% Duty Cycle                       |
| <b>Weight</b>                  | 40 lb (18.2 kg)                             |
| Order Information              |   |
| <b>Part No:</b>                | <b>W3512001</b>                             |
| Description:                   | Portafeed VS 212                            |
| <b>Part No:</b>                | <b>W3512002</b>                             |
| Description:                   | Portafeed VS 212 (with digital meters)      |

**Ready to weld!** Supplied with 2ft (.7m) power cable, Tweco MPC connectors and .045" (1.2mm) drive rolls for hard/tubular wire.

**Super tough injection molded case!** Long lasting and almost indestructible.

**New market leading cartridge system! (Patent pending)** No more gun adapters required, just "plug and play" with multiple types and brands of MIG/FCAW guns.

**Large digital display!** Optimized to be read in direct sunlight. Features wire feed speed, amps, volts with arc time and memory hold.

**Potted printed circuit boards!** Protected from dirt, metallic dust and moisture for longer life.

**Heavy duty contactor!** Long life, 425 amp contactor designed for high output, high duty cycle applications.

\* Limited warranty. Refer to warranty schedule.

**THERMAL ARC**  
By THERMADYNE®

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Portafeed VS 212  
Form No.: 84-2605

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## Features#



Easy grip latches



Cast aluminum heavy duty handle



Recessed control panel for maximum protection



Digital display meter, wire feed speed (IPM or MPM), amperage, voltage, arc time and memory hold



Wire feed speed dial with large rubberized control knob

Super tough case made from 30% glass filled polypropylene, impact tough, flame retardant



Power cable with Tweco connector



Voltage sensing connector, 25mm dinse



Power on/off switch



Inch and Gas purge switch



Gun trigger hold switch (2T/4T)



MIG gun cartridge system (patent pending)

Skid rails

#Subject to change without notification.

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## Features#



Cast aluminum heavy duty handle



MIG gun holder



Insulated lifting eye



Gas valve inlet  
(5/8-18 RH female inert gas)

Power cable and  
TWECO® connectors  
(male and female  
supplied)

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## Features#



Easy open door fasteners



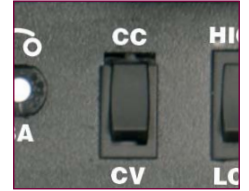
Wire spool hub with locking assembly



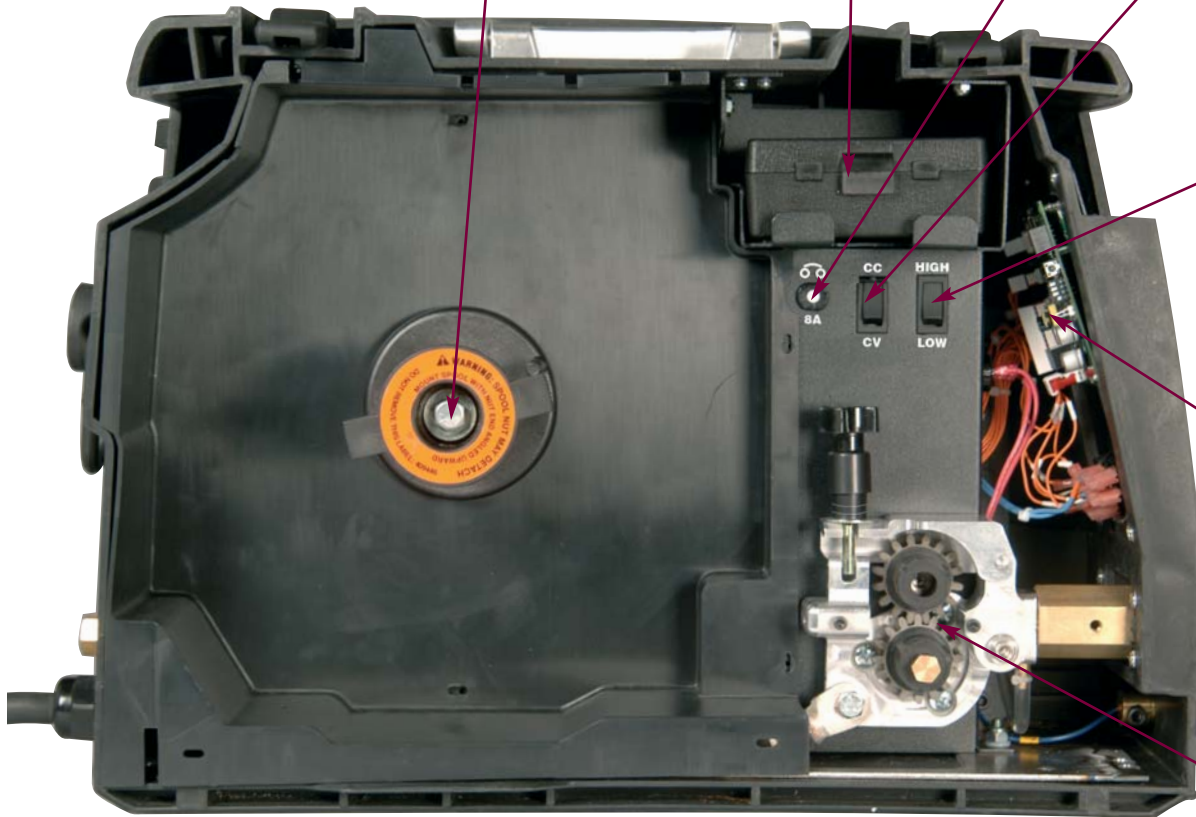
Internal parts storage



Circuit breaker



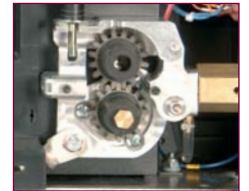
CC/CV mode switch



High/low wire feed speed switch



Meter DIP switch



Precision drive system

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## Features#



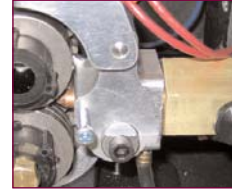
Tension arm



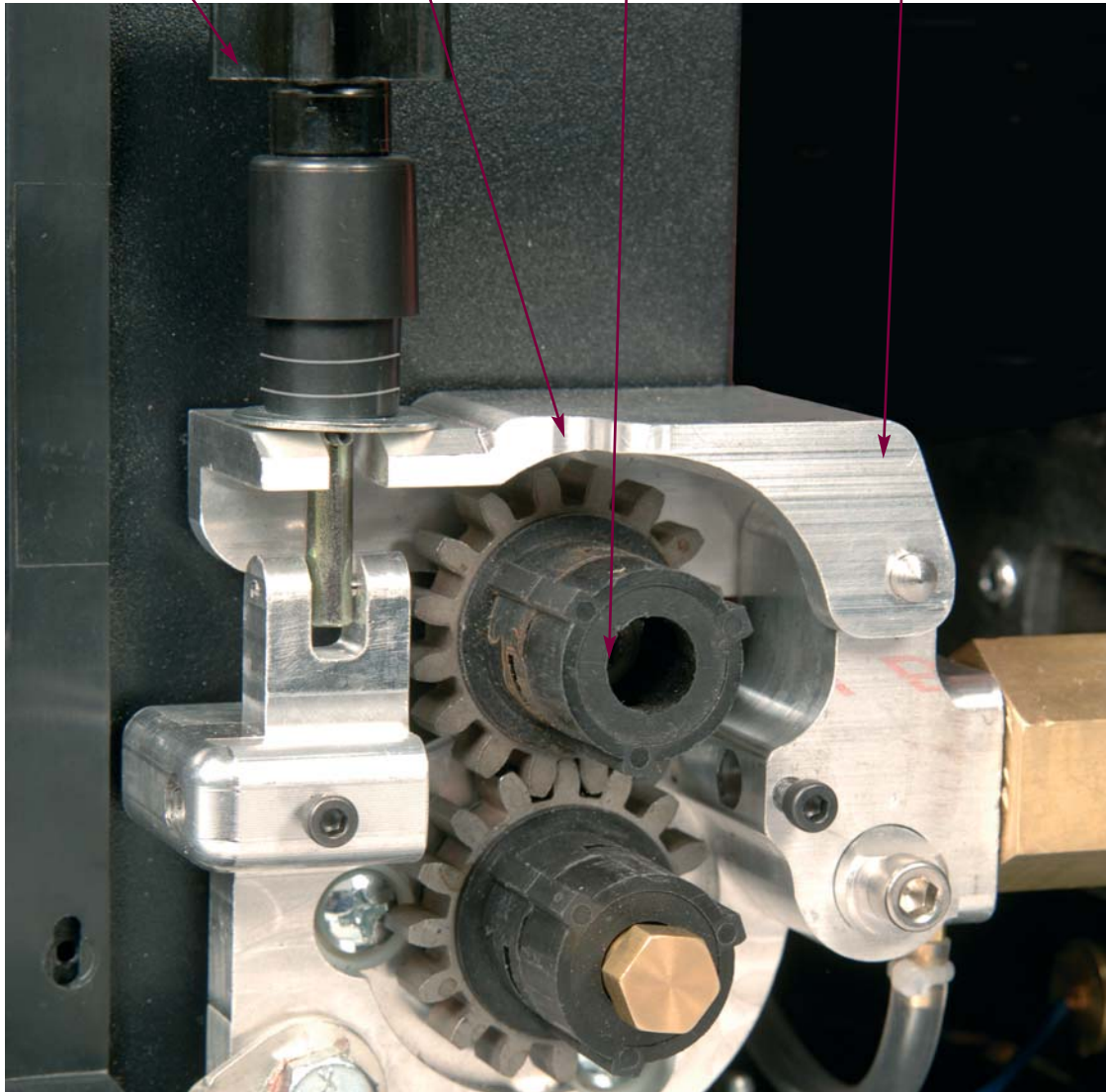
Heavy duty pressure arm



Quick change drive rolls, no tools required



Completely new heavy duty drive system



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## Specifications#



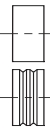





|   |                                  |
|---|----------------------------------|
| <b>VS 212</b>                                     |                                  |
| Input voltage                                     | 15-100 VDC                       |
| Maximum input current                             | 8 amps                           |
| Wire speed range<br>(for all filler wire sizes)   | 50-800 IPM<br>(1.27-20.32 m/min) |
| Wire size range                                   | .023"-5/64"<br>(0.6-2.0mm)       |
| Maximum spool/reel size                           | 44 lb (20.0 kg)                  |
| Drive rolls                                       | 2 gear driven                    |
| Welding current                                   | 425A @ 60%<br>duty cycle         |
| Welding gun inlet size (Std)<br>(Tweco® Style #4) | 5/8" (15.9mm)<br>nominal         |
| Maximum shielding gas<br>inlet pressure           | 100 psi (689 Kpa)                |
| Degree of Protection                              | IP23C                            |
| Approvals   | IEC 60974-1 (CE);<br>NEMA EW-3   |

Removable Gun Cartridge System (Patent Pending), replace with competitive MIG gun cartridges (Miller®, Lincoln®, Euro) for a complete integrated MIG gun connection.

### Dimensions & Weight

|            |       |   |
|------------|-------|---|
| Dimensions | HxWxD | 15.3 x 9.4 x 21.3 in (289 x 239 x 541 mm) |
| Weight     |       | 40 lb (18.2 kg)                           |

## Drive Roll Kits (#375980-Series) 2 Roll

|                                       | Style 1   | Style 2   | Style 3   | Style 4   | Style 5   | Style 6   |
|---------------------------------------|---|---|---|---|---|---|
| <b>Top</b>                            |  |  |  |  |  |  |
| <b>Bottom</b>                         | Double Smooth 'V'   | Double Smooth 'V'   | Double Smooth 'V'   | Double Knurled 'V'  | Double Cog  | Double 'U'  |
| <b>Wire Type</b>                      | Hard  | Hard  | Soft/Hard/Tubular   | Hard/Tubular  | Tubular   | Soft (Aluminum)   |
| <b>Wire Size</b>                      |   |   |   |   |   |   |
| .023" / 0.6mm                         | 375980-031  | -   | -   | -   | -   | -   |
| .030", .035" / 0.8, 0.9mm             | 375980-001  | 375980-003  | 375980-010  | -   | -   | -   |
| .030", .035", .045" / 0.8, 0.9, 1.2mm | 375980-028*   | 375980-029  | -   | -   | -   | -   |
| .035" / 0.9mm                         | 375980-040*   | -   | -   | -   | -   | 375980-032  |
| .035", .045", 3/64" / 0.9, 1.2, 1.2mm | -   | -   | 375980-030  | -   | -   | -   |
| .045" / 1.2mm                         | 375980-002*   | 375980-004  | -   | 375980-092  | 375980-022  | -   |
| 3/64" / 1.2mm                         | -   | -   | 375980-011  | -   | -   | 375980-033  |
| .052" / 1.3mm                         | 375980-090*   | -   | 375980-012  | -   | -   | -   |
| .052", 1/16" / 1.3, 1.6mm             | -   | -   | -   | 375980-017  | 375980-023  | -   |
| 1/16" / 1.6mm                         | 375980-005*   | -   | -   | -   | -   | 375980-034  |
| 5/64" / 2.0mm                         | 375980-006*   | -   | -   | 375980-018  | -   | -   |

**NOTE:** 1. Kit #375980-092 is supplied standard with each wire feeder. 2. Drive roll kits include: drive rolls; input, output & centre guides. \*3. Narrow 30° 'V'

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Portafeed VS 212  
Form No.: 84-2605

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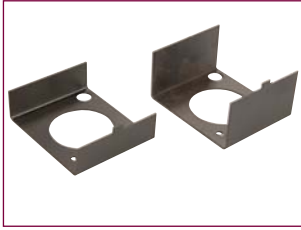
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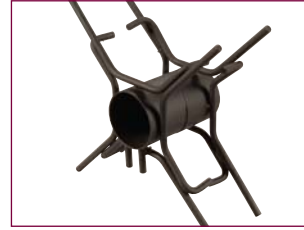
## Options & Accessories#



**Wire Spool Adaptor**  
Part No. 375585-001 10 lb (4.5kg) 8" spool  
Part No. 375864-001 15 lb (6.8kg) 8" spool  
Adaptor used to mount 10 lb or 15 lb, 8" diameter spools to wire feeder.



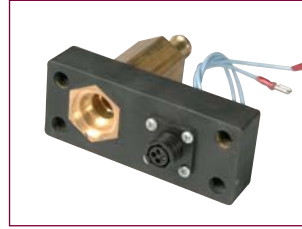
**Wire Feeder Cart**  
Part No. W4000001  
Heavy duty, large caster cart for moving wire feeder around the work area (shown with Ultrafeed VA4000).



**Wire Coil Adaptor**  
Part No. 375942A 14 lb (6.4kg) coil  
14 lb used to mount a Lincoln® 14 lb coil of self shielding wire.



**Roll cage**  
Part No. W4003001  
Protective tube steel roll cage.



**MIG Gun Adaptor Cartridge**  
Part No. W4004001 Tweco® #4 (shown)  
Part No. W4005001 Miller® (shown)  
Part No. W4006001 Lincoln® (gasless)  
Part No. W4006002 Lincoln®  
Integrated cartridge to accept other style MIG guns.



**MIG Gun Adaptor Cartridge**  
Part No. W4007001 Euro-style  
Integrated cartridge to accept other style MIG guns.

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## Ordering Information

| Product                             | Part No.   | Description   | Qty | Price |
|-------------------------------------|------------|---|-----|-------|
| Portafeed® VS 212                   | W3512001   | Two roll voltage sensing wire feeder for operation with most CC/CV welding power sources  |     |       |
| Portafeed® VS 212                   | W3512002   | Two roll voltage sensing wire feeder with digital meters for operation with most CC/CV welding power sources                      |     |       |
| <b>ACCESSORIES</b>                  |            |   |     |       |
| Drive Roll Kits                     | 375980-XXX | One kit (#375980-092) is supplied standard with each wire feeder, see drive roll kit chart to select a different drive roll style |     |       |
| Wire Spool / Coil Adapters          |            |   |     |       |
| 10 lb (4.5kg), 8" spool             | 375585-001 |   |     |       |
| 15 lb (6.8kg), 8" spool             | 375864-001 |   |     |       |
| 14 lb (6.4kg) coil, Lincoln®        | 375942A    |   |     |       |
| Wire Feeder Cart                    | W4000001   | Low profile, large caster cart  |     |       |
| Roll Cage                           | W4003001   | Protective tube steel roll cage   |     |       |
| MIG Gun Adaptor Cartridge           |            |   |     |       |
| Tweco® #4                           | W4004001   | Integrated cartridge to accept other style MIG guns. Wire feeder comes with Tweco #4 cartridge installed                          |     |       |
| Miller®                             | W4005001   |   |     |       |
| Lincoln® (gasless)                  | W4006001   |   |     |       |
| Lincoln®                            | W4006002   |   |     |       |
| Euro-style                          | W4007001   |   |     |       |
| <b>POWER SOURCES</b>                |            |   |     |       |
|                                     |            | Refer to Thermal Arc website for further information.   |     |       |
| ArcMaster® 400S                     |            |   |     |       |
| ArcMaster® 300MST                   |            |   |     |       |
| ArcMaster® 400MST                   |            |   |     |       |
| ArcMaster® 400MSTP                  |            |   |     |       |
| Fabstar® 4030                       |            |   |     |       |
| PowerMaster® Series                 |            |   |     |       |
| Excel-Arc® Series                   |            |   |     |       |
| Scout, Raider 10000 (engine driven) |            |   |     |       |

**TOTAL QUOTE PRICE**



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