Stationary Spot Cum Projection Welding Machines

MAIN FEATURES

- Formed Brackets Instead of fabricated for better strength
- Use of Oil-less bushes for cylinder ram movement for less friction, wear and increased reaction time.
- Improved Holder assembly for easier approach to JOB
- Improved design of secondary circuit for better welding current
- Improved design of secondary circuit for better water cooling
- Improved design of Transformer for better water flow (increased water flow of 25%) to increase the efficiency and life
- Modified programme selector switch
- Weld on/off toggle switch on pendent
- Error reset/ restart switch on pendent
- Microprocessor Based Sophisticated Control Unit with Constant Current Operation
- Single Board SMD Construction for Very High Reliability
- Diagnosis Mode for Troubleshooting
- Program Sequence Operation
- Advanced Diagnostic Data Display of every spot
- 63 Programs Memory with 31 Direct Recalls (10 Recalls Provided on Machine)
- Hardware Lock with Universal Key to prevent unintentional/unauthorised changes.

TECNA WELDCON
INDIA PRIVATE LIMITED

Years long Experience Cast into the Future...!

Technical Data

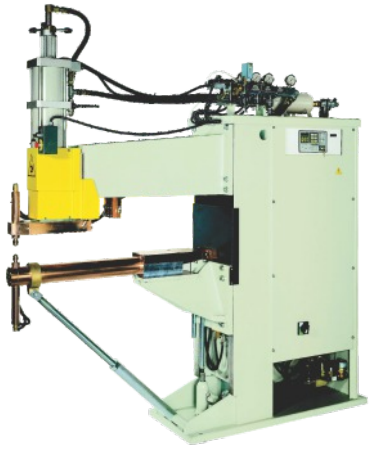
		Eco Model				Std. Model				High Force Model			
Model No. SCP		35 E	50 E	75 E	35 S	50 S	75 S	100 S	150 S	50 H	75 H	100 H	150 H
Frame		E	E	E	E	E	E	S	S	S	S	B	B
Controller		TE 90				TE 550				TE 550			
Nominal Power	Kva	35	50	75	35	50	75	100	150	50	75	100	150
Rated Duty Cycle	%	50	50	50	50	50	50	50	50	50	50	50	50
Rated Primary Voltage	V	440	440	440	440	440	440	440	440	440	440	440	440
No Load Sec. Voltage	V	6.4	6	9.2	6.4	6	9.2	14.8	21	6	9.2	14.8	21
Max Short Circuit Current	KA	13	18	22	13	18	22	25	25	18	22	25	25
Cylinder Dia	mm	63	100	100	63	100	100	125	125	125	125	150	150
Force at 6 bar	Kgf	300	470	470	300	470	470	736	736	736	736	1060	1060
Throat Depth	mm	400	475	475	400	475	475	475	475	475	475	475	475
Throat Depth Adj. Range	mm	0	50	50	0	50	50	50	50	50	50	50	50
Throat Gap	mm	290	200	200	290	200	200	200	200	200	200	200	200
Throat Gap Adj. Range	mm	0	50	50	0	50	50	50	50	50	50	50	50
Supply Voltage +/-10%	V	415	415	415	415	415	415	415	415	415	415	415	415
Supply Frequency +/- 3	Hz	50	50	50	50	50	50	50	50	50	50	50	50
Cooling Water Pressure	Bar	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
Cooling Water Flow	LPM	15	15	20	15	15	20	23	23	15	20	23	23
Inlet Water Temp.		30	30	30	30	30	30	30	30	30	30	30	30

3 Phase DC Welding Machines

Main Welder Features

DC Three-phase welding machines, offering the following additional features:

- High power factor
- Reduced load on plant primary electrical service.
- Balanced load distribution on the three phases.
- Reduced effect of magnetic materials between arms on the welding current.
- Reduced installation costs.

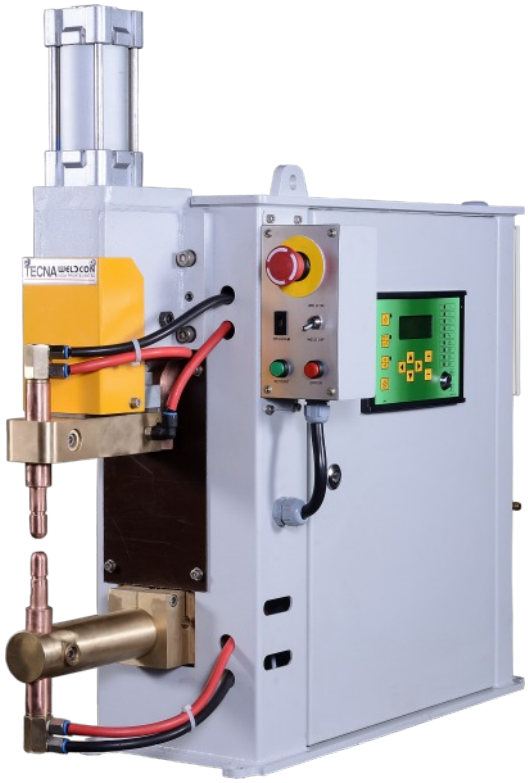


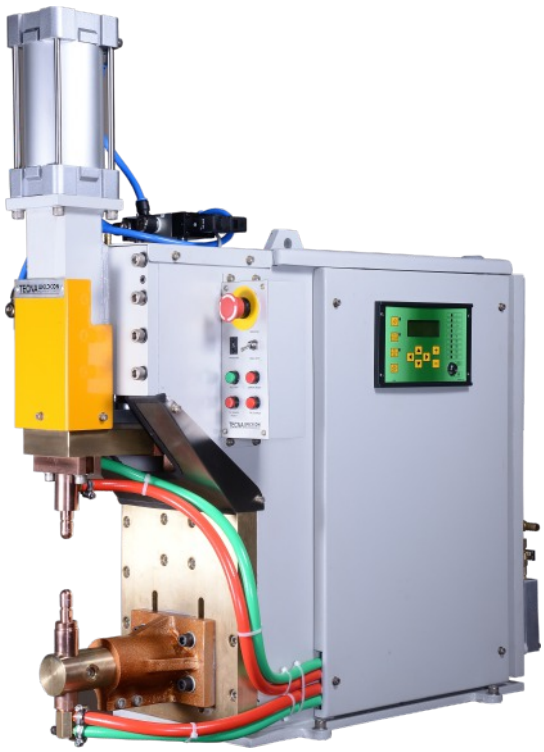
Features And Technical Data

Normal power at 50%	kVA	100	160	250	260	480	630
Spot welder		•	•	•			
Projection welder		•	•	•	•	•	•
Maximum welding power	kVA	450	700	1090	1800	1900	2100
Short circuit current	kA	60	90	106	150	190	200
Max. welding current on steel	kA	48	72	85	120	150	160
Thermal current 100%	kA	11	13	15	18	24	26
No load secondary voltage	V	6.3 5.5	7.3 6.3 5.9	8.8 8 7.1	10 8.6 7.4 6.4	9.5 8.4 7.6 6.8	10.5 9.5 8.4 7.6
Supply voltage 50Hz**	**V	400	400	400	400	400	400
Cables section L=30 m	mm^3	50	75	120	2 x 120	3 x 95	3 x 95
Delayed fuses	A	125	200	250	400	630	630
Cylinder	N° daN	4/736 6/1206 7/1885	4/736 6/1206 7/1885	6/1206 7/1885 8/3388	6/1206 7/1885 8/3388 9/2945	8/3388 9/2945 10/5509	8/3388 9/2945 10/5509
Water cooling	l/min	10	14	16	25	30	33
ø supply hose	mm	25	25	25	25	25	25
Compressed air supply	bar	6.5	6.5	6.5	6.5	6.5	6.5
ø hose	mm	25	25	25	25	25	25

** Different voltages available on request

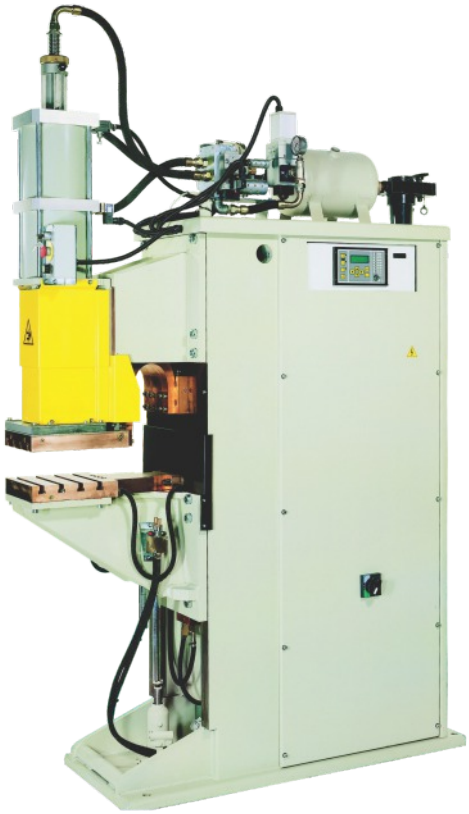
Bench Spot & Projection Welders





♦ 35KVA to 100KVA Models
♦ Space Saving Design
♦ Advanced Controller for Precise Welding Current Control in Smaller Jobs

MFDC Welding Machines



WELDER MAIN FEATURES

- Medium frequency welders, designed to obtain high quality welding.
- Modular design of mechanical structure, arms, brackets, cylinders.
- Cylinder with chrome plated stem for heavy duty works and long life; adjustable anti-rotation device.
- Lubrication free pneumatic components to eliminate oil mist and to protect the environment.
- Adjustable double-stroke cylinder with key control.
- Electrodes descent without pressure for both maintenance and set-up.
- Built-in compressed air filter unit and tank. Compressed air disconnection device.
- Water-cooled transformer, plates, electrode-holders and electrodes; transformer with epoxy resin coated windings.

Technical Data

ITEM 6121		6121	6122	6123	6124	6125	6126
Spot welder				●			●
Spot-projection welder		●	●		●	●	
Nomial power at 20%	kVA	142	142	142	285	285	285
Nomial power at 50%	kVA	90	90	90	180	180	180
Short circuit current	kA	32	32	32	60	60	60
Thermal current 100%	kA	6.6	6.6	6.6	12	12	12
No load secondary voltage	V	9.4	9.4	9.4	9.4	9.4	9.4
Supply voltage 50Hz*	V	400	400	400	400	400	400
Cables section L = 30m	mm^2	35	35	35	95	95	95
Delayed fuses	A	100	100	100	200	200	200
Minimum gap	mm	175	175	175	175	175	175
Maximum gap	mm	475	475	475	475	475	475
Depth L	mm	388	538	803	388	538	803
Depth D	mm	262	412	––	262	412	–––
Max. electrode force 6 bar (standard)	daN	736	736	736	736	736	736
Max. electrode force 6 bar with option 6135	daN	1242	1242	1242	1242	1242	1242
Maximum stroke	mm	100	100	100	100	100	100
Double stroke (standard)	mm	0+80	0+80	0+80	0+80	0+80	0+80
Compressed air supply	bar	6.5	6.5	6.5	6.5	6.5	6.5
Air for 1000 spots (6 bar) Standard version							
Stroke 20 mm	Nm^3	4.6	4.6	4.6	4.6	4.6	4.6
Max stroke	Nm^3	15.4	15.4	15.4	15.4	15.4	15.4
Option 6135							
Stroke 20 mm	Nm^3	9.4	9.4	9.4	9.4	9.4	9.4
Max stroke	Nm^3	21.7	21.7	21.7	21.7	21.7	21.7
Ø supply hose	mm	16	16	16	16	16	16
Water cooling	l/min	10	10	10	10	10	10
Net weight (approximately)	kg	490	500	550	540	550	600
Ø arms	mm	60	60	60	60	60	60
Ø electrode-holders	mm	32	32	32	32	32	32
electrode taper Ø	mm	19.05	19.05	19.05	19.05	19.05	19.05

* Different voltages available on request

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