

Spot welders

Technical specifications



Product image

400 V, 50/60 Hz pneumatic, microprocessor-controlled, water-cooled fixed-arm spot welding. Available in 20, 30 and 60 kVA AC versions.

Product features

- Can be manufactured with different power ratings and designs to suit the application.
- The specially guided, high-force cylinders used in our machines are manufactured in-house.
- Welding capacity · steel sheet: 0.4+0.4 / 3+3 mm.
- Welding capacity · steel wire: Ø2+Ø2 / Ø8+Ø8 mm.
- Welding capacity · M4-M8 nuts and bolts.
- Welding capacity · stainless steel sheet: 0.4+0.4 / 3+3 mm.
- Welding capacity · aluminium sheet: 0.5+0.5 mm.
- Standard equipment: microprocessor control unit, air preparation unit, standard electrode, foot pedal, emergency stop button, specially designed guided cylinder and water distribution manifold.

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Optional equipment

- Blade electrode
- Two-hand control system
- S-type electrode
- Proportional pressure regulator
- PLC control system and touchscreen panel
- Custom arm length
- Movable operator safety screen
- Custom fixtures and dies
- Poka-yoke system
- Constant-current welding control system

APF20SA ac / APF20LA ac / APF30SA ac / APF30LA ac / APF60SA ac / APF60LA ac

Values vary by model and application.

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Rated power (%50 DT)	20 kVA	20 kVA	30 kVA	30 kVA	60 kVA	60 kVA
Secondary voltage	5 V	5 V	5,9 V	5,9 V	7,1 V	7,1 V
Short-circuit welding current (max)	20 kA	17 kA	23 kA	21 kA	25,5 kA	23,5 kA
Arm length	260-450 mm	260-450 mm	260-450 mm	260-450 mm	260-450 mm	260-450 mm
Stroke width	100 mm	100 mm	100 mm	100 mm	100 mm	100 mm
Piston diameter	Ø 63 mm	Ø 63 mm	Ø 80 mm	Ø 80 mm	Ø 80 mm	Ø 80 mm
Air pressure	2 / 8 bar	2 / 8 bar	2 / 8 bar	2 / 8 bar	2 / 8 bar	2 / 8 bar
Electrode pressure force (6 bar)	180 daN	180 daN	300 daN	300 daN	300 daN	300 daN
Cooling water inlet pressure (min-max)	2 / 5 bar	2 / 5 bar	2 / 5 bar	2 / 5 bar	2 / 5 bar	2 / 5 bar
Cooling water inlet temp. (min-max)	16 / 21 °C	16 / 21 °C	16 / 21 °C	16 / 21 °C	16 / 21 °C	16 / 21 °C
Cooling water inlet flow rate (min)	7 lt/min	7 lt/min	8 lt/min	8 lt/min	10 lt/min	10 lt/min
Transformer cooling type	Air / Water	Air / Water	Air / Water	Air / Water	Air / Water	Air / Water
Weight	240±30 kg	270±30 kg	280±30 kg	310±30 kg	380±30 kg	410±30 kg
Dimensions (W×L×H)	520×940×1450 mm	520×1145×1450 mm	520×950×1450 mm	520×1155×1450 mm	520×950×1450 mm	520×1155×1450 mm
Power supply voltage	400 V · 50/60 Hz · 2-phase	400 V · 50/60 Hz · 2-phase	400 V · 50/60 Hz · 2-phase	400 V · 50/60 Hz · 2-phase	400 V · 50/60 Hz · 2-phase	400 V · 50/60 Hz · 2-phase
Delayed circuit breakers	50 A	50 A	63 A	63 A	125 A	125 A
Mains cable (≤10 m)	2×10+4 mm ²	2×10+4 mm ²	2×16+6 mm ²	2×16+6 mm ²	2×35+10 mm ²	2×35+10 mm ²