



# 15 KVA SPOT WELDER TO WELD COILS TO TERMINAL PINS

## Inverter control



Spot-welding machine to weld coils to terminal pins. It is provided with an accurate electronic welding control for the correct adjustment of the welding, as the type and the diameter of wire to be welded change.

### MACHINE COMPOSITION

- Frame in aluminum fusion for the housing of the whole welding group
- Pneumatic cylinder for the movement of the welding electrode
- 2 water-cooled electrode holder arms
- CCS copper electrodes
- Electronic control with the possibility to set up to 300 welding programs with:
  - Approach of the electrodes
  - Setting of the welding current ramp
  - Setting of the current and of the welding duration
  - Setting of the holding current
  - Setting of the higher and lower limits of the welding current
  - Holding in pressure by cooling after the welding
- Controlled diodes power group (S.C.R.)
- Transformer made of silicon sheets, with nominal power 15 KVA, single-phase, completely water-cooled and impregnate in epoxy resins



## AVAILABLE VERSIONS

<b>Mod. 400/MIP-25000</b>	Spot welder with inverter control (Work bench excluded)
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## TECHNICAL CHARACTERISTICS

The main technical features of the pin-coil welding manual machine are:

- Inverter command with medium frequency IGBT, with possibility of choosing the operating frequency of the inverter between 1000 Hz and 4000 Hz.
- Storage of up to 300 welding programs.
- Overheating protection for the welding transformers.
- Up to 32 programmable parameters for each program.
- Slope up, Slope down, pulses, pre-weld, post-weld functions and adjustment of the welding times with units of 1 ms.
- Display of the RMS of the welding current, energy, power, RMS of voltage at the electrodes, of the initial and final resistance, of the machine's thermal use percentage, of the machine's use percentage
- 6 working modes: constant current (IK), constant power (PWK), constant voltage (VEK), FIX, constant energy (ENE), DYNAMIC mode (DYN). Limit indicators for: current, voltage at the electrodes, energy, power, inverter use percentage, initial and final resistance of the material to be welded.
- Double stroke function.

## INVERTER FEATURES

Supply voltage	400 VAC 3-phase / 50-60 hz
Max output current	150 A
Primary frequency	1000 – 2000 – 3000 – 4000 Hz
Current range	300 – 5400 A
Cooling	Fan
Dimensions (L x W x H)	550 x 300 x 320 mm
Weight	40 kg

## WELDING TRANSFORMER FEATURES

<b>Box Type</b>	<b>1586</b>	<b>1587</b>
Power 50%	20 kVA	25 kVA
Max output current	5400 A	5000
No load secondary voltage	13 V	14.5 V
Thermal current 100%	1500 A	1800 A
Cooling	Water	
Dimensions (L x W x H)	378 x 150 x 106 mm	
Weight	22 kg	20 kg