

Spot Welding Machine SF

rocker arm, foot-operated

Technical Data:

type:	SF 100	SF 200
power rating at 50%:	8/12kVA	20/30kVA
rated voltage:	400V/50Hz	
throat depth:	130-300mm	130-500mm
throat gap:	160mm	205mm
electrode force max.:	220daN	360daN
electrode holder-Ø:	16mm	25mm
electrode seat:	Mk1	Mk1/Mk2
start:	foot lever	



Technical Details:

- solid machine frame
- high powered transformer
- throat depth infinitely adjustable
- electrode force can be infinitely regulated
- main switch acc. to VDE 0113
- 3m connecting lead

Welding control:

RS 15 (standard)

- 1-time-synchronised-welding control
- digital current and time setting
- automatic mains recognition of 50/60Hz
- mains voltage compensation
- status display via LED's
- international operating symbols

Extra Equipment:

- throat depth 380-700mm (only at SF 200)

- **Tube arm**
for spot welding of cylindrical parts



- **Angle shaped electrode holder**
for welding of steel profiles



- **Vice electrode**
for welding of one sheet disc on one rod. The rod carry the current and is clamped in a vice electrode



- **Pendular and arbor electrode holder**
for welding of wire tences



Spot Welding Machine SF 102/104 + SF 202/204

technical data acc. to DIN 44753 / ISO 669

Type		SF 102	SF 104	SF 202	SF 204	
Article-no.		11-101-102	11-101-104	11-101-130	11-101-150	
Throat depth	mm	130-300		130-500		
Machine power	Power rating (50%)	kVA	8	12	20	30
	Continuous output	kVA	5,65	8,48	14,1	21,2
	Maximum short-circuit power	kVA	22,7	36		
	Maximum welding power	kVA	18,2	28,8		
Machine voltage	Secondary idling voltage	V	2,6	3,2	3,7	5,2
	Number of regulation Steps		0			
Mains connection	Rated primary voltage	V	400			
	Rated frequency	Hz	50/60			
	Supply power	kVA	13,65	21,6	30	55,2
	Fusing (carrier)	A	63/25	63/25	63/25	63/63
	Wire range (cable length < 15m)	mm ²	2,5	2,5	6	10
Secondary current	Rated operating current	kA	1,75	3,79	5,4	5,8
	Permanent current	kA	1,24	2,68	3,8	4,1
	Short-circuit-current	kA	9,1	11,2	15	20
	Highest welding current	kA	7,3	8,9	12	16
	Permit. Duty cycle at highest weld cur.	%	2,88	9,07	10	6,5
Spot mounting	Electrode stroke max.	mm	50		50	
	Electrode force max.	daN	220		360	
	Throat gap	mm	160		205	
	Electrode arm-Ø	mm	32		45	
	Electrode holder-Ø	mm	16		25	
	Spot electrode seat		Mk1		Mk1/Mk2	
Cooling water	Pipe connection in / out		NG 8 / G ¼"		NG 8 / G ¼"	
	Operating pressure max.	bar	5		5	
	Entry temperature	°C	18		18	
	Consumption at max. loading	l/min	4		4	
Machine measurements	Width x depth x height	mm	360 x 785 1150		430 x 1190 x 1260	
	Weight	kg	115	122	180	196
Power stage	Thyristor power stage		RS 15 LS		RS 15 LS	
Welding values	Steel sheet (C-content ≤ 0,2%)	mm	1,5+1,5	3+3	4+4	5+5
	CrNi sheet	mm	0,75+0,75	0,75+0,75	1+1	1+1
	Round steel-Ø (C-content ≤ 0,2%)	mm	max. 6+6	max. 8+8	max. 12+12	max. 17+17

Technical alterations reserved. The table contents refer to standard models.

Water recooling units:



Air-Water Recooler

cooling to no more than 5-8°C above the ambient temperatures

Type	LWK 17
Article-no.	40-186-017
Cooling power	2kW
Rated voltage	230V/50Hz
Pump power	0,25kW
Water tank capacity	10l



Cooling-Water Recooler

with a fully-hermetic motor compressor and electronic thermostat with LCD display

Type	IK-V 07/B
Article-no.	40-186-072
Cooling power	0,9kW
Rated voltage	230V/50Hz
Pump power	0,25kW
Water tank capacity	6l