



Panel montage



Free-standing weld controller, mounted in a box

### Specifikation

- User-friendly interface with LCD display and master control switch, all settings is made by turning and pressing one control switch.
- Possibility to set weld powers, either as percentages of transformer output or as current intensity in Ampere.
- Thirty pre-programmed weld schedules for different materials that can be individually changed and renamed with up to sixteen digits.
- Phase shift compensation; automatic compensation for  $\cos \varphi$ , phase shift between voltage and current.
- Weld current monitor; with possibility to set accepted deviation in percentage, monitors secondary current and displays error message if deviates from preset set point value
- Weld current regulation that automatically compensates for current deviations during the weld cycle.
- Tip wear compensation; automatically increases weld power.
- Weld log that stores the last 100 carried out welds. The RS-232 interface makes it possible to continuously transfer weld log data to a PC, can be very useful in troubleshooting.
- Two separately weld counters, one that keeps track of the total number of performed welds, and one that is possible to reset.
- Freehand emergency stop device, by pressing once more on the weld control switch the welding cycle can be aborted. Useful if one, for instance, wants to interrupt the welding process during squeeze time.

### Weld settings

Squeeze time	0 - 100 cycles
Pre-heating time	0 - 100 cycles
Pre-heating power	0 - 100 %
Pre-heating current	2.0 – 30.0 kA
Weld time	0 - 100 cycles
Weld power	0 - 100 %
Weld current	2.0 – 30.0 kA
Cooling time	0 - 100 cycles
Post-heating time	0 - 100 cycles
Post-heating power	0 - 100 %
Post-heating current	2.0 – 30.0 kA
Hold time	0 - 100 cycles
Pulsation	0 - 10 pulses
Pulsation break time	0 - 100 cycles
Repeat time	0 - 300 cycles
Current deviation	0 - 25 %
Wearing	500 – 10,000 welds

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