



Inverter

ARC Stud Welding

Clever stud welding using advanced inverter power sources

HEAVY DUTY - POWERFUL

Outstanding welding quality - very high arc stability

Less consumption

- Reduced by 50% (compared to units with transformer technology)
- Save on costs

Mobile

- Minimized weight (1/2 of conventional power sources)
- Compact dimensions



Guns

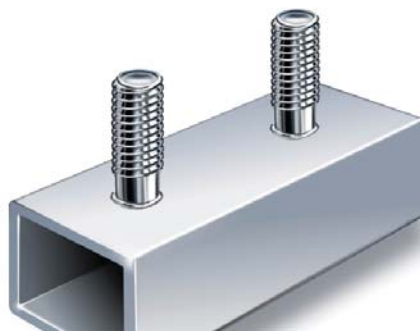
- Low weight
- Double hydraulic system (A 22/A 25)
- Automatic length compensation

Welding Quality

- Arc stability
- Process monitoring
- Unaffected by external power fluctuations (- 10 % + 10 %)

- Library function/preset welding parameters
- Pre-programmed current curve for shear connectors/throughdeck (IT 2002, IT 3002)

Simple Operation





HBS inverter technology means:

- Maximum** welding quality
- Maximum** welding rates
- Minimum** energy consumption
- Minimum** weight
- Maximum** efficiency

Welding unit	IT 1002	IT 2002	IT 3002	
	Welding range	M3 to RD16, dia. 2 to 14 mm	Dia. 2 to 22 mm, M3 to M24	Dia. 2 to 25 mm, M3 to M24
	Welding rate	M12 = 25 studs/min	Dia. 22 = 6 studs/min	Dia. 25 = 6 studs/min
	Welding current	1 000 A (max.)	2 000 A (max.)	2 600 A (max.)
	Welding time	5 to 1 000 ms (stepless)	300 to 2 000 A (stepless)	300 to 2 600 A (stepless)
	Connected load	50 kVA (with 400 V mains)	100 kVA (with 400 V mains)	150 kVA (with 400 V mains)
	Cooling	F (temperature controlled cooling fan)		
	Class protection	IP 23		
	Dimension L x W x H	660 x 280 x 340 mm (without handle)	600 x 500 x 830 (without handle)	650 x 560 x 1 290 mm (without handle)
	Weight	29 kg	95 kg	160 kg (1 Gun connection) 179 kg (2 Gun connections)

- High mobility
- Powerful
- Easy to use
- Robust
- Microcontroller
- Easily readable display
- Integrated mains filter
- Function monitoring
- Lift test
- Library function
- Simple polarity change
- Optimal protection against external interference

Welding gun	A 12	A 16	A 22	A 25	
	Welding range	M3 to M12, dia. 2 to 12 mm	Dia. 3 to 16 mm	Dia. 14 to 22 mm (dia. 25 mm)	Dia. 14 to 25 mm
	Stud length	10 to 400 mm*	10 to 240 mm*	10 to 390 mm*	
	Length compensation	3 mm automatic	6 mm automatic	9 mm automatic	
	Stroke	Adjustment range 3 mm	Adjustment range 4 mm	Adjustment range 6 mm	
	Damping	--	Adjustable oil damper		
	Welding cable	5 m	4,85 m, 50 mm ²	4,85 m, 95 mm ²	1,5 m, 120 mm ²
	Dimension L x W x H	200 x 65 x 140 mm**	260 x 74 x 220 mm**		
	Weight	0,8 kg (without cable)	2 kg (without cable)		

- Durable ergonomic design for repeated use
- Compact dimensions
- Sealed piston guidance (dust ingress protection)
- Advanced slide bearing for piston guidance
- Automatic length compensation
- Oil damper for damped plunging in the weld pool
- Lift adjustment
- Lift damper for optimum welding quality
- Stud length freely adjustable

* depending on tripod; ** without cable, with foot piece

Units for automatic operation: IT 1002, IT 50, IT 90 (up to 4 gun connections)

