

31

SPOT WELDING GUNS

A 3111 / A 3112 / A 3119

PRODUCT PROFILE

- small repair jobs or only outer-surface damage repairs **A 3111 / A 3112**
- recurring repair jobs, including light chassis damage, welding of open-tops, car transporters **A 3119**
- manufacturing and often recurring repair jobs of all damage incl. roof skins **A 3119**



APPLICATION AREAS

DALEX Spot welding guns of the series 31 are applied almost exclusively in the motor vehicle trade and in car body repair workshops

Upon request:
Hanging strap with hanger clamps
or cardan spring balancer

TECHNICAL DATA

Type	A 3111	A 3112	A 3119
Power rating at 50 % d.c.	2,4 kVA	2,4 kVA	8,0 kVA
Sec. short-circuit current	7,5 kA	8,5 kA	9,5 kA
Throat gap	120 mm	120 mm	120 mm
Electrode force	180 daN	180 daN	180 daN
Welding power	Steel sheet 3 + 3 mm	Steel sheet 3 + 3 mm	Steel sheet 3 + 3 mm
Compatible control unit	RS 15 Z 16 / Variospot 3.3	RS 15 Z 16 / Variospot 3.3	RS 15 Z 16 / Variospot 3.3
Compatible water re cooler	air cooled	air cooled	COOL 1

TECHNICAL DETAILS

- double stroke mechanism
- short stroke notch/increments
- hand-operated
- secondary transformer for current control
- distortion-free square electrode arms
- low-deflection square electrode arms for optimum performance of high electrode force
- universal usage via an all round mounting system
- rotation-resistant square mounting in gun body
- easy positioning of the spot welding gun via cardan spring balancer (A 3119 K)
- welding transformer cast resin sandwich construction
- welding quality remains constant via the same sandwich construction
- pressure-dependent current activation
- toggle-joint system for raising electrode force
- connecting cable in standard 10m length* and low connection load
- fusing A 16

*for spot welding gun A 3112 - 5m connecting cable

SPOT WELDING GUN Type **A 3111 / 3112 / 3119**

Technical Data* acc. to DIN 44753 / ISO 669			A 3111	A 3112	A 3119
Electrical part	Throat depth	mm	120	120	120
	Machine power	Power rating, 50 % d.c.	kVA	2,4	8
		Continuous rating	kVA	1,7	5,6
		Max. short-circuit power	kVA	17,5	28
		Max. welding power	kVA	14,0	22,4
	Machine voltage	Secondary idling voltage	V	2,3	2,9
	Mains connection	Rated primary voltage	V	400	400
		Rated frequency	Hz	50/50	50
		Supply power	kVA	10/10	16,8
		Main switch / Fusing	A	16/20	16
		Wire range for cable length shorter = 15 m	mm ²	2,5/4	2,5/4
	Secondary current	Rated operating current	kA	1,05	2,7
		Continuous current	kA	0,74	1,9
		Short-circuit current	kA	7,5	9,5
		Max. welding current	kA	6,0	7,6
		Perm. duty cycle at highest welding current	%	1,5	6,25
Mechanical part	Spot mounting	Throat gap	mm	120	120
		Electrode arm diameter height x width	mm	20 x 20	20 x 20
		Spot electrode / outer Ø	mm	12	12,5
	Hand-operation	Short stroke / long stroke	mm	25/57	25/57
		Electrode force min. / max.	daN	50/180	50/180
	Gun dimensions	3) Width x depth x height	mm	90 x 350 x 270	90 x 420 x 270
		Weight	kg	9,2	12,2
	Welding values	1) Steel sheet 2)	mm	3 + 3	3 + 3
		2) Round steel 15 % penetration	mm	8 + 8	8 + 8

Notes:

- 1) subject to influences, at a max. permitted voltage drop of 4 %
- 2) weldable quality with metallic clean surface, C-content 0,2 %
- 3) excl. electrode arms and spring balancer

Technical alterations reserved.

*Details for shortest throat depth.