

SL

RESISTANCE WELDING MACHINE

SL 202 / SL 204 / SL 206



rocker arm **SPOT**-welding machine
pneumatically operated



TECHNICAL DATA

Type	SL 202	SL 204	SL 206
Power rating at 50 % d.c.	20 kVA	30 kVA	50 kVA
Secondary short-circuit current	15 kA	20 kA	25 kA
Throat depth	130 - 500 mm	130 - 500 mm	130 - 500 mm
Throat gap	250 mm	250 mm	250 mm
Electrode force max	420 daN	420 daN	420 daN

TECHNICAL DATA

- 5-times synchronised welding control with 2 welding programs for operation with thyristor power stage
- digital current and time setting
- upslope and impulse function
- mains voltage compensation
- automatic mains recognition of 50/60 Hz
- parameter entry via keys in operator console
- status display via LED's
- international operating symbols
- stepping and locking contact
- throat depth infinitely adjustable
- compressed air servicing unit
- main switch acc. to VDE 0113
- 3 m connecting lead excl. plug
- correspondent to the standards VDE 0545-1, EN 60204-1, EN 50 240 EN 292 parts 1+2, EN 1050
- CE - symbol

SPOT WELDING MACHINE Type **SL 202 / SL 204 / SL 206**

Technical Data* acc. to DIN 44753 / ISO 669				SL 202	SL 204	SL 206
Throat depth			mm	130 - 500	130 - 500	130 - 500
Electrical Part	Machine power	Power rating (50% d.c.)	kVA	20	30	50
		Continuous output	kVA	14,1	21,2	35
		Maximum short-circuit power	kVA	56,8	108	150
		Maximum welding power	kVA	45,4	86,4	120
	Machine voltage	Secondary idling voltage	V	3,7	5,2	5,9
	Mains connection	Rated primary voltage	V	400	400	400
		Rated frequency	Hz	50	50	50
		Continuous output	kVA	30	55,2	80
		Main switch acc. to VDE	A	63	63	63
		Safety classification GL	A	35	63	63
		Wire range (cable length shorter = 15 m)	mm²	6	10	16
	Secondary current	Rated operating current	kA	5,4	5,8	8,2
		Continuous current	kA	3,8	4,1	5,8
		Short-circuit current	kA	15	20	25
		Highest welding current	kA	12	16	20
		Permitted duty cycle at highest welding current	%	10	6,5	8,4
Mechanical Part	Cylinder EH	Throat gap	mm	50	50	50
		Electrode arm Ø	daN	75 - 420	75 - 420	75 - 420
		Electrode holder Ø	daN	30 - 180	30 - 180	30 - 180
		Electrode holder, adjustability	stroke/ min	60	60	60
		Spot electrode seat no. / outer Ø	m³	0,1	0,1	0,1
	Spot mounting	Electrode stroke max.	mm	250	250	250
		Electrode force short throat depth	mm	45	45	45
		Electrode force long throat depth	mm	25	25	25
		Max. movements	mm	135	135	135
		Air consumption / 1000 strokes	mm	1/12,5 or 2/18	1/12,5 or 2/18	1/12,5 or 2/18
	Compressed air	Pipe connection		NG 16 - G ½	NG 16 - G ½	NG 16 - G ½
		Operating pressure max.	bar	6	6	6
	Cooling water	Pipe connection in / out		NG 8 - G ¼	NG 8 - G ¼	NG 8 - G ¼
		Operating pressure max.	bar	5	5	5
		Consumption at max. loading	l/min ⁻¹	4	4	4
	Machine measure- ments	Width x depth 2) x height	mm	430 x 1190 x 1260	430 x 1190 x 1260	430 x 1190 x 1260
Weight ca.		kg	180	196	200	
Operational Part	Welding values	Sheet steel C-content smaller = 0,2 % 1)	mm	4 + 4, max. 5 + 5	5 + 5, max. 6 + 6	6+ 6, max. 7 + 7
		CrNi sheet 1)	mm	1 + 1	1 + 1	1 + 1
		Brass sheet 1)	mm	1,5 + 1,5, max. 2 + 2	2 + 2, max. 3 + 3	3 + 3, max. 4 + 4
		Aluminium sheet 1)	mm	0,8 + 0,8, max. 1 + 1	1 + 1, max. 1,2 + 1,2	1,2 + 1,2, max. 1,5 + 1,5
		Round steel Ø C-content smaller = 0,2 % 1)	mm	8 + 8, max. 12 + 12	12 +12, max. 16 + 16	16 + 16, max. 17 + 17
	Leistungsstufen	Thyristor power stage		RS_17_LS	RS_17_LS	RS_17_LS

Notes:

- 1) subject to size influences
2) details incl. electrode arms

Technical alterations reserved
*details for shortest throath depth