

ROOF SEAM WELDER 400HZ IBE10MW, Main Welder



Weld settings

Squeeze time	0 – 2000 ms
Weld time	0 – 2000 ms
Weld power	1 – 100 %
Weld current	2.0 – 4.0 kA
Cooling time	0 – 2000 ms
Hold time *	0 – 2000 ms
Motor speed *	1 – 100 %
Calculated speed	0 – 300 ms
Current dev.	0 - 25 %
Wearing	0 – 1,000 hours

The machine must be connected to a fuse box with main switch, earth fault breaker and fuses.

Supply Voltage:	400V/16A 3-phase 50/60Hz
Supply Current (welding):	10A/phase **
Welding frequency:	400Hz
Waterflow, requirement:	2 litres/minute
Weight:	26kg

Specifikation

- User-friendly interface with LCD display and master control switch, all settings is made by turning and pressing one button.
- Possibility to set weld power, either as percentage of transformer output or as current intensity in Ampere.
- Five weld schedules that can be individually changed and renamed with up to sixteen digits.
- 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. The weld is performed at a frequency of 400Hz.
- Weld log that stores the last 100 error messages, even if the machine is powered off, can be very useful in troubleshooting.
- Two separately weld seam counters, one that keeps track of the total number of performed seams, and one that is possible to reset.
- Two separately time counters, one that keeps track of the total number of welded minutes, and one that is possible to reset.

* Only applicable if the machine has a DC motor. For now, only on Detail Welder (DW) model.

** Less then 10A per phase at good welding quality, stainless steel 0.5+0.5. Supply current at welding depend on set point value of current and steel sheet thickness.