



Inverter based Drawn Arc Stud welder

Model: NDC-1200



Technical Information



Welding method

Drawn arc (ceramic ferrule) [suitable for weld through deck]	Yes
Short cycle	Yes
Drawn arc (shielding gas)	Optional

Max. welding diameter (mm)

Drawn arc (ceramic ferrule)	8
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Welding current (A)

5-1200

Welding time (mS)

1-1000

Constant current regulation

Yes

Welding parameter monitoring

Welding parameter monitoring	Yes
Welding parameter memory	Yes

Gun connections

1 Gun connection	Yes
5 Gun connections	Optional
Stud Counter with PLC interlink	Yes

Operation

Microcontroller control	Yes
Welding program storage	Yes
Weld counter (resettable)	Yes
Lift test	Yes
Self-diagnosis system	Yes
Automatic function test	Yes
Current Display	Yes
Effortless maneuverability of the Gun With CEARS Gantry and Balancer	Yes

Shielding gas module

Optional

Automatic stud feeding

Yes

Error diagnosis systems

Excess temperature	Yes
Damage on welding/control cable	Yes

Interfaces

Device Net, Profibus, Profinet, Ethernet I/P	Optional
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Trolley design with two big, extremely robust castors

Lifting eyes

Yes

Robust, powder-coated metal housing

Yes

Electric connection

Mains supply (V) at 50/60 Hz	380-440
Mains fuse external	63 AT
Mains plug	100 A

Technical Data



Mains supply voltage	440VAC 3 ph, 50Hz, +10 to -25%
Control system	Microcontroller based
Current source	Inverter
Welding Current capacity	1200A
Welding range	M3 – M8 or 3 – 8 mm
Welding time	1 up to 1000 ms
Welding sequence	15 – 20 studs/min., depending on stud diameter
Material	Steel, stainless steel, aluminum and brass conditionally, depending on the respective requirements.
Welding method	Drawn Arc stud welding
Standard pistol	Stud welding pistol
E – constant current	1A / phase
E – constant power	250 VA
E – peak current	60A / phase with 3 x 400 Volt (short time operation)
Open – circuit power	140 Volt / DC
Fuse element at front panel	F1 = 5A, F2 = 5A
Interface	Feeder Interface
Shielding gas supply	Max. 4 ~ 5 l/min.
Welding cable	25 sqmm, 3 mtr flexible
Earth cable	25 sqmm, 3 mtr flexible
Weight	~150 Kg
Panel Color	RAL 5015



Features

- Most advanced dual core RISC processor controlled
- High frequency Inverter power source
- Precise control of welding parameters achieving good quality weld
- Constant current control
- For all known studs of the short cycle drawn-arc stud welding method(M3-M8 and stud length up to 30mm)
- Customer Specific Interfaces to robots/transfer lines (parallel interface, Device Net, Ethernet I/P, Profibus, Profinet etc.)
- Upto 5 welding tools and feeders can be connected to single unit (Optional feature at extra price)
- Automatic feeding of the welding studs
- Modular design robust and service friendly structure
- Effortless handling of Welding Gun, Horizontal or Vertical suspension
- Monitoring the angular position. Welding the studs perpendicularly to the base, with LED indicator.
- Easy program selection via switch for up to 32 welding programs.
- Optionally welding with inert gas is possible