



UNIVERSAL SEAM WELDING MACHINES

Pneumatic / Servo

AC • AC Inverter • MFDC • 3 Phase DC



MFDC machines are suitable for Spot, Projection and Seam Welding applications. **MFDC** models are most ideal for mass production of toughest industrial applications. MFDC machines are also ideal for resistance spot welding of aluminium and other coated and high tensile materials not easily weldable by conventional resistance welding.

Technical Advantages - MFDC

- Balanced power on three main phases.
- Low Primary power
- High power factor & output
- High quality welded joints
- Large power for Projection welding.
- Presence of magnetic materials in secondary circuit does not affect welding.
- Large power for welding with increased arm length
- Long electrode life
- Reduced welding time.
- Lower electricity bills.

- Manual Loading & Unloading
- Auto Coating removal from weld wheels.
- Auto wheel dressing
- Thin Wheel construction
- Welding Heads with Silver Shoes.
- Inverter MFDC Seam Welding Machines up to 600 KVA can be supplied

NASH Universal Seam Welding Machines are the most electrically efficient Machines.

Design Features

- LM Guides Mounted Ram (Optional) – LM guides are used for precision and frictionless movement of ram.
- Welding Head – All machines are provided with specially designed spindle assemblies mounted on taper roller bearings with silver contact shoes to deliver welding currents at highest possible efficiency and to provide trouble free extraordinary long life.
- Auto Zinc coating removal (Optional) – Programmable auto cleaning arrangement to remove Zinc coating from seam welding wheels.

LAP SEAM WELDERS



Application: Twin Lap Seam Welding for Front and Rear Roof Joining of HCV Cab



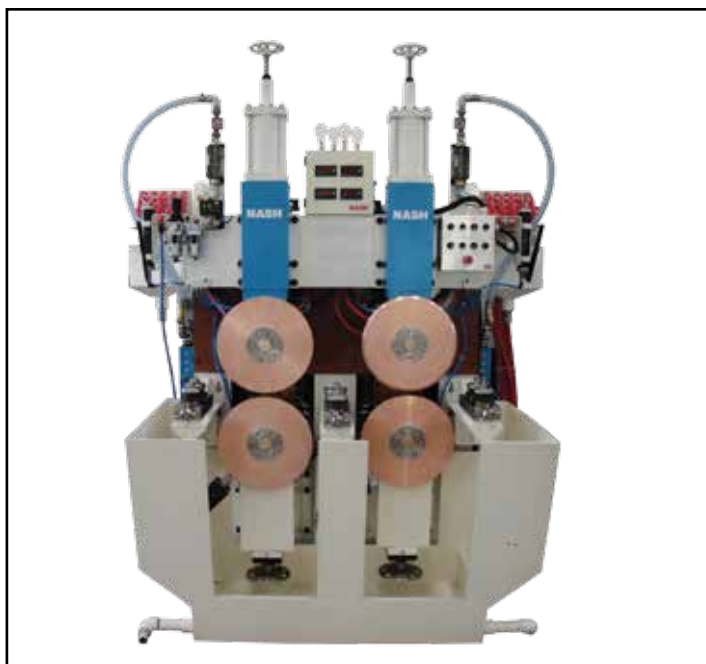
Application: Lap Seam Welder for coil joining for steel industry



Seam Welding Machine for Shock-absorber and Struts



200 KVA Longitudinal Seam Welder for Fuel Tank



Dual Head Seam Welding Machine for Wheel Rim Line



Inverter (MFDC) 600 KVA Aircraft Seam Welding Machine

FUEL TANK SEAM WELDER



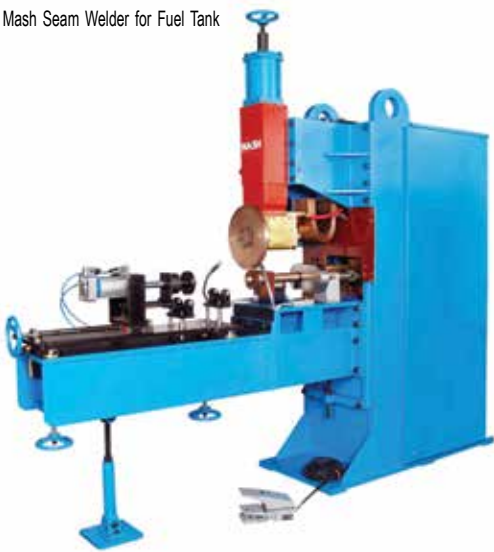
Mash Seam Welder for Fuel Tank



MFDC 150 KVA
Longitudinal Seam Welder



Bench Seam Welder
for Aircraft Industry



MFDC 100 KVA Circular Seam Welder
for Submersible Pumps



200 KVA Circular Seam Welding Machine
with Manipulator for Tractor Fuel Tank



Portable Seam Welder



3 phase DC transformer



Rocker Arm Type Seam Welding Machine for Fuel Tank



Circumferential Seam Welding Machine for Sports Bike Fuel Tank



Weld Controllers



Continues updating & monitoring of seam welding pulse current, Pulse failure rate monitor with indication, ½ cycle correction for constant current, Constant current with secondary feedback accuracy.

SEAM Welding Wheels, Shafts and Spares



Specifications - AC Seam Welders

Technical Data			NSW - 80	NSW - 100	NSW - 125	NSW - 150	NSW - 200
Nominal Power at 50% DC	Sn	kVA	80	100	125	150	200
Max. Short Circuit Power	Sc	kVA	148	260	325	385	500
Max. Welding Power	Smax	kVA	118	208	260	308	400
Nominal Supply Voltage	U _{1n}	V	415	415	415	415	415
Nominal Primary Current at 50% DC	I _{1n}	A	190	240	300	360	480
Supply Frequency	-	Hz	50	50	50	50	50
Supply Phases	-	kVA	2	2	2	2	2
Supply Capacity	-	kVA	120	155	195	230	300
Fuse Size (HRC)	-	Amps	160	200	250	315	400
Feed Cable - 30m Long	-	mm ²	70	95	120	185	240
Max. Primary Short Circuit Current	I _{1cc}	Amps	350	625	780	920	1200
Nominal Secondary Current at 50% DC	I _{2n}	Amps	11000	12000	14200	16300	20000
Max. Short Circuit Current	I _{2cc}	Amps	20000	31000	37000	42000	50000
Max. Welding Current	I _{2max}	Amps	16000	24800	29600	33600	40000
Duty Cycles for Maximum Welding	Xmax	%	23	11.55	11.55	11.55	12.5
Number of Taps	-	-	2	2	2	2	2
Secondary Open Circuit Voltage	U ₂₀	V	4.3/7.4	5.3/8.3	7.3/8.8	7.6/9.2	8.4/10
Welding Speed min./max.	-	mm/min	250/3000	250/3000	250/3000	250/3000	250/3000
Weld Cylinder Diameter	Ø	mm	125	150	150	160	160
Electrode force at 5.5 Bar	-	Kgs.	675	970	970	1100	1100
Throat Depth	-	mm	650	650	650	650	650
Working Stroke	-	mm	76	100	100	100	100
Cooling Water Consumption	-	lit/min.	40	60	60	80	80
Machine Size (D x W x H)	-	mm	1550x830x1720	1550x830x1768	1550x830x1768	1550x830x1768	1550x980x1768
Weight	-	Kgs.	900	1050	1100	1250	1400

NASH reserves the right to change specifications and appearance without prior notice.

NASH Robotics and Automation Pvt. Ltd.

93/9, MIDC, Satpur, Nashik 422 007, India
 Phones: +91 - 253 - 2353382, 2352180, 2350680
 Fax : +91 - 253 - 2351780
 Email : co@nashrobotics.com
 Web : www.nashrobotics.com

ISO 9001 Company

