

## Pedestal Spot Welders • 16-25 kVA

4640 • 4641 • 4642 • 4643 • 4644

The new stationary ergonomic frame designed by TECNA helps to facilitate the operator's work

The control unit has been positioned on the front of the machine to allow the operator to view the welding data even during the working cycle



### Key Features

- Arms adjustable in length allowing a better working flexibility
- Chrome-copper electrode holders for long life and heavy duty service, designed for straight and angled fitting
- Adjustable electrode stroke
- Epoxy resin coated transformer
- Water cooled transformer, arms and electrodes
- Microprocessor control unit TECNA TE101
- Adjustable electrode force; a microswitch starts the welding cycle when the desired pre-set value is reached. The foot pedal is adjustable in length

| Order Code                              |                 | 4640    | 4641    | 4642     | 4643    | 4644     |
|---|-----------------|---------|---------|----------|---------|----------|
| Nominal power @ 50%                     | kVA             | 16      | 20      | 20       | 25      | 25       |
| Maximum welding power                   | kVA             | 35      | 48      | 39       | 68      | 55       |
| No load secondary voltage               | V               | 3.4     | 4       | 4        | 4.6     | 4.6      |
| Maximum short circuit current           | kA              | 12.5    | 14.5    | 12       | 18      | 14.5     |
| Maximum welding current on light alloys | kA              | -       | -       | -        | 16.3    | -        |
| Maximum welding current on steel        | kA              | 10      | 11.6    | 9.6      | 14.4    | 11.6     |
| Thermal current 100%                    | A               | 3300    | 3500    | 3500     | 3800    | 3800     |
| Supply voltage 50Hz *                   | V               | 400     | 400     | 400      | 400     | 400      |
| Cables section L=10m                    | mm <sup>2</sup> | 6       | 10      | 10       | 16      | 16       |
| Cables section L=30m                    | mm <sup>2</sup> | 10      | 10      | 10       | 16      | 16       |
| Delayed fuses                           | A               | 32      | 40      | 40       | 50      | 50       |
| Min. throat depth                       | mm              | 230     | 230     | 380      | 230     | 380      |
| Max. electrode force (@ 6 bar)          | daN             | 240     | 240     | 150      | 240     | 150      |
| Electrode stroke                        | mm              | 8 - 44  | 8 - 44  | 10 - 60  | 8 - 44  | 10 - 60  |
| Max. electrodes throat depth            | mm              | 550     | 550     | 700      | 550     | 700      |
| Max. electrode force (@ 6 bar)          | daN             | 95      | 95      | 80       | 95      | 80       |
| Electrode stroke                        | mm              | 15 - 85 | 15 - 85 | 15 - 105 | 15 - 85 | 15 - 105 |
| Short circuit current with L max.       | kA              | 8.4     | 10      | 8.8      | 13      | 10.5     |
| Arms diameter                           | mm              | 36      | 40      | 40       | 40      | 40       |
| Electrode holders diameter              | mm              | 19      | 22      | 22       | 22      | 22       |
| Standard electrodes cone diameter       | mm              | 12.7    | 14.8    | 14.8     | 14.8    | 14.8     |
| Water cooling                           | l/min           | 2.5     | 3       | 3        | 3.7     | 3.7      |
| Aerial noise produced                   | dB(A)           | <70     | <70     | <70      | <70     | <70      |
| <b>Measure conditions</b>               |                 |         |         |          |         |          |
| Working stroke                          | mm              | 20      | 20      | 20       | 20      | 20       |
| Welding time                            | cycles          | 21      | 17      | 26       | 14      | 20       |
| Welding current                         | kA              | 9.4     | 11      | 9        | 13.5    | 11       |
| Working rating in welds/min             |                 | 10      | 10      | 10       | 10      | 10       |
| Net weight (approximately)              | Kg              | 135     | 143     | 146      | 145     | 148      |

\* Different voltages & frequencies on request