

3 Technical Specifications

3.1 General Specifications

	Specification	Value	Unit
	Weight	approx. 90	kg
	Width	approx. 570	mm
	Height	approx. 1000	mm
	Depth	approx. 685	mm
	System of protection: Protected against solid objects until 12 mm.	IP 23 according IEC529	Protected against water drops
	Operating temperature	15 - 40	°C
	Stocking temperature	-25 - 55	°C
	Relative humidity of air, not condensing	5 - 95	%
	Operation Mode	Automatic	
	Working Position	vertical	
	Display	40x16	Matrix-module
	Dot size	0,4x0,4	mm
	Character height	2,65x3,55	mm
Electromagnetic compatibility	The control and power unit DCE 1500 has been tested following the DIN EN 60 974-10.		

3.2 Connected Loads

Electrical	Specification	Value	Unit
	Power supply $\pm 10\%$	400/440/500	V AC
	Supply frequency $\pm 5\%$	50/60	Hz
	Max. effective idle voltage	110,0 137,5	V at 400V V at 500V
	Max. duration of power supply Interruptions	at I=1500A	5 ms
	DC voltage	55	V at 400V
	Effective current-out	130	A

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Electrical	Specification	Value	Unit
	Weld current range	ΔI : 20-1500	A
	Weld time range	Δt : 36-160	ms
	Output peak capacity	PA: 80	KVA at 400V AC
	Number of welds	60 min ⁻¹ at	I= 750A, t= 30 ms
		30 min ⁻¹ at	I=1500A, t= 30 ms
		at 30°C environmental temperature	
	Control system	PI-Controller	
	Control range	ΔI : 10	A

Weld parameter

Adjustment range	Specification	Value	Unit
	Pilot current	20	A
	Pilot current time	30	ms
	Weld current	100-1500	A
	Weld time	6-350	ms
Clearance	Weld current	ΔI_s : 10	A
	Weld time	Δt_s : 1	ms

Stud feeding times

Interval	Specification	Value	Unit
	Loading time	0-1000	ms
	Feeding time	300-2500	ms
Clearance	Loading time	Δt_L : 50	ms
	Feeding time	Δt_z : 50	ms