

STUD WELDING PRODUCTS, INC.



STUD WELDING UNIT

Model: IT-2002



APPLICATION

- Especially suitable for thicker sheets of about 2 mm or higher
- Especially suitable for welding of concrete anchors/shear connectors for job site applications
- Suitable for through deck welding

PROCESS VARIANTS

- Short cycle drawn arc welding
- Drawn arc welding

EQUIPMENT

- Welding with ceramic ferrule (series)
- Welding with shielding gas (optional)

FEATURES

- Microcontroller – for precise process times, optimal functional reliability and maximum operating convenience
- Function monitoring – automatic function test following power-up; monitoring of all internal system functions
- Lift test – for gap welding guns and stud welding heads
- Library function – automatic specification of welding current and welding time through selection of stud diameter according to welding range (with and without shielded gas); fine adjustment via arrow keys

FEATURES	WELDING UNIT IT-2002
SIZE	23.6" length, 19.7" width, 32.7" height (600 x 500 x 830 mm) without handle
WEIGHT	209.4 lbs. (95 kg)
WELD RANGE	#4 to 1", dia. 14 ga to 1" (M3 to M24, dia. 2 to 25 mm)
WELD MATERIALS	Mild steel, stainless steel, aluminum
WELDING RATE	Dia. 7/8" = 7 studs/min (dia. 22 mm = 7 studs/min)
WELDING CURRENT	2,000 A (max.)
CURRENT ADJUSTMENT RANGE	300 TO 2,000 A (stepless)
WELDING TIME	5 to 1,500 msec (stepless)
PRIMARY POWER	480/460 V, 3 phases, 50/60 Hz, 63 AT (alternative input voltages available)
CONNECTED LOAD	100 KVA (with 400 V mains), 80 kw
COOLING TYPE	F (temperature controlled cooling fan)
PROTECTION CLASS	IP 23
OPERATIONAL & STORAGE CONDITIONS	According to current standards
GAS	Option
ORDER NUMBER	93-66-2201 93-66-2202 (Gas)

STRUCTURE

- Extremely easy to operate
- Compact
- Mobile – highly mobile thanks to compact dimensions and low weight (50% weight savings vis-à-vis conventional stud welding units)
- Robust – metal housing withstands rough treatment in shop and on site

SAFETY

- With integrated mains filter (protection against voltage peaks)
- Optimal for construction sites with large mains voltage fluctuations – use even with critical voltage supply (- 10% + 10%)
- EMC test
- High-voltage test with log
- Retriggerring lock-out – prevents welding on a welding element that has already been set
- Thermal monitoring of transformer – automatic shutdown in case of overheating
- Temperature-regulated ventilator – reduces noise and dust in the stud welding unit (greater system reliability)
- Control unit galvanically separated from welding lines – high degree of functional safety
- Optimal protection against external interferences
- Protection class IP 23
- Also permits operation outdoors

WELDING

- Display – infinitely adjustable power setting; easy monitoring of all functions via LED displays; easy operation via membrane keyboard and digital display; setting of welding parameters, programs, shielding gas (optional); digital display of current, welding and gas-preflow time; separate settings for welding current and welding time
- Powerful – built-in power reserves
- Trouble-free changing of welding voltage polarity possible by reconnecting welding current and ground cables
- Outstanding welding quality – very high arc stability even at weak welding currents
- High process flexibility – high clock frequency (30 kHz) of stud welding unit allows highly dynamic regulation of welding process

Suitable stud welding guns

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| • A 12 | • A 22 | • AI 06 |
| • A 16 | • A 25 | |

Check us out on the internet www.studweldprod.com or email info@studweldprod.com

Downey, CA

9459 Washburn Rd.
Downey, CA 90242
Phone- 800.252.1919
Fax- 562.862.3022

Hayward, CA

2391 American Ave.
Hayward, CA 94545
Phone- 510.782.7883
Fax- 510.782.7918

Kent, WA

19038 72nd Ave. South
Kent, WA 98032
Phone- 425.656.9787
Fax- 425.656.9786

Phoenix, AZ

3535 East Wier Ave., Ste. #4
Phoenix, AZ 85040
Phone- 602.305.9350
Fax- 602.305.4890