



**IT 1002**  
**Stud Welding Unit**  
 for ARC stud welding  
 according to current standards

#### Technical Data

|                                    |   |
|------------------------------------|---|
| Gas/Automation/Process control     | Series/Option/Option  |
| Welding range                      | M3 to MR16, dia. 2 to 14 mm   |
| Welding material                   | Mild steel, stainless steel, aluminum   |
| Welding rate                       | M12 = 25 studs/min  |
| Welding current                    | 1,000 A (max.)  |
| Current adjustment range           | Stud welding 100 to 1,000 A, electrode 50 to 400 A (stepless)   |
| Welding time                       | 5 to 1,000 msec (stepless)  |
| Primary power                      | 400 V, 3 phases, 50/60 Hz, 35 AT (alternative input voltages available)   |
| Primary plug                       | 32 A (with 400 V mains)   |
| Connected load                     | 50 KVA (with 400 V mains)   |
| Cooling type                       | F (temperature controlled cooling fan)  |
| Protection class                   | IP 23   |
| Operational and storage conditions | According to current standards  |
| Dimension L x W x H                | 660 x 280 x 340 mm (without handle)   |
| Weight                             | 29 kg   |
| Order No.                          | <b>93-60-1202 (Gas)</b><br><b>93-60-1204 (Gas/Automation)</b><br><b>93-60-1206 (Gas/Automation/Process control)</b> |

#### General Information

##### Application

- Especially suitable for thicker sheets of about 2 mm or higher

##### Process variants

- **Short cycle drawn arc welding**
- **Drawn arc welding**

##### Equipment

- **Welding with ceramic ferrule** (series)
- **Welding with shielding gas** (series)
- **Automation** (optional)
- **Process sequence control** (optional)



## Advantages

### 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
- **Display of error codes** – on digital display
- **Lift test** – for gap welding guns and 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
- **Process monitoring** – recording and analysis of factors affecting the welding process; after each weld, the reference and actual values are compared; display of the welding energy input; switchable automatic welding stop if limits are exceeded
- **RS232 interface** – for data output; data and time of day are stored; welding parameters of each weld are logged (only for version gas/automation/process control)

### 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**
- **Retriggering 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, automation and process monitoring possible; digital display of current, welding and gas-preflow time (optional: pneumatic feed time for automation); 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
- **2 in 1** – switchable from drawn-arc ignition to electrode welding

### Suitable stud welding guns/ -heads

- **A 12, A 16, AI 06**
- **CA 08**
- **PAH-1 (only suitable for automatic version)**
- **KAH 412, KAH 412 LA (only suitable for automatic version)**

Issue 11/08  
(Technical data may change)