



## MARC 1 W

**Manual Pad Welding System** (Water cooled)  
for pad welding with rotating arc

### Technical Data

Welding range	M6 to M12 (pad)*
Welding material	Stainless steel, steel (on request)
Welding rate	10 pieces/min**
Wall thickness	Up to 2.5 mm***
Welding current	1,000 A (max.)
Welding time	5 to 1,000 msec (stepless)
Primary power	400 V (alternative input voltages available), 32 A, 3 phases, 50/60 Hz, 35 AT (IT 1002); 230/115 V, 50/60 Hz, 10 AT (CU)
Power source	Inverter
Field former unit	Not controlled
Protection class	IP 23
Dimension L x W x H	660 x 280 x 340 mm (IT 1002), 660 x 220 x 340 mm (CU); without handle
Weight	29 kg (IT 1002), 24 kg (CU)
	* due to a possible replacement of the manual welding gun, the unit is also suitable for manual stud welding
	** depending on pad diameter and material
	*** higher wall thickness on request

### Order No.

**MARC1.W**

Consists of:  
Stud welding unit IT 1002  
Ground cable  
Welding gun AM 30 W  
Field former FW1 (equipped for one standard dimension)  
Shielding gas tripod MARC1.A/MARC1.W  
Cooling unit CU

### General Information

#### Application

- Welding of threaded pads and welding nuts
- Welding on punched and unpunched sheets
- Especially suited for shop and installation applications

#### Options

- Gas control module 2-channel



## Advantages

### Description

- Low energy consumption
- Even and minimal heat input (low distortion)
- Very short welding time ( $\leq 1$  second) and consequently short cycle time in production
- No welding additives required
- Minimum upset force
- Small and even welding seam
- Only one-sided accessibility to the work piece required
- Low investment costs for machine technique
- Extremely clean process (minimum development of airborne particles)
- No reworking of work piece or welding element (thread)

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(Technical data may change)