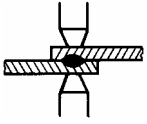


DALEX

WELDING TECHNOLOGY



rocker-arm –
SPOT-welding machine



fig. Series SF 200

TECHNICAL DETAILS

- 1-time synchronised welding control with thyristor power stage
- welding power finely adjustable
- digital current and time setting
- overload protection via thermal contact
- electrode holder axially adjustable
- throat depth infinitely adjustable
- main switch acc. to VDE 0113
- 3 m connecting lead excl. plug
- conforms to the standards VDE 0545-1, EN 60204-1, EN 50 240, EN 292 parts 1+2, EN 1050
- CE - displayed

TECHNICAL DATA

SF 202 / 204 / 206

Power rating at 50 %:	20 kVA / 30 kVA / 50 kVA
Secondary short-circuit current:	15 kA / 20 kA / 25 kA
Standard throat depth	130 – 500 mm
Throat gap:	250 mm
Electrode force max:	360 daN

Resistance welding machines

Series SF 200

DALEX Spot welding machines SF 202 / 204 / 206

Technical Data* acc. to DIN 44753 / ISO 669			SF 202	SF 204	SF 206	
Throat depth		mm	130 – 500	130 – 500	130 – 500	
Electrical Part	Machine power	Power rating (50% d.c.)	kVA	20	30	50
		Continuous output	kVA	14,1	21,2	35
		Maximum short-circuit power	kVA	56,8	108	150
		Maximum welding power	kVA	45,4	86,4	120
	Machine voltage	Secondary idling voltage	V	3,7	5,2	5,9
	Mains connection	Rated primary voltage	V	400	400	400
		Rated frequency	Hz	50	50	50
		Continuous output	kVA	30	55,2	80
		Main switch acc. to VDE	A	63	63	63
		Safety classification GL	A	35	63	63
		Wire range (cable length smaller = 15 m)	mm ²	6	10	16
	Secondary current	Rated operating current	kA	5,4	5,8	8,2
		Continuous current	kA	3,8	4,1	5,8
		Short-circuit current	kA	15	20	25
		Highest welding current	kA	12	16	20
Permitted duty cycle at highest welding current		%	10	6,5	8,4	
Mechanical Part	Spot mounting	Throat gap	mm	250	250	250
		Electrode arm Ø	mm	45	45	45
		Electrode holder Ø	mm	25	25	25
		Electrode holder, adjustability	mm	135	135	135
		Spot electrode seat no./outer Ø	mm	1/12,5 oder 2/18	1/12,5 oder 2/18	1/12,5 oder 2/18
		Electrode stroke max.	mm	20	20	20
		Electrode force short throat depth	daN	65 – 360	65 – 360	65 – 360
	Electrode force long throat depth	daN	25 – 140	25 – 140	25 – 140	
	Cooling water	Pipe connection in / out		NG 8 – G ¼	NG 8 – G ¼	NG 8 – G ¼
		Operating pressure max.	bar	5	5	5
Consumption at max. loading		l/min	4	4	4	
Machine measurements	Width x depth ²⁾ x height	mm	430 x 1190 x 1260	430 x 1190 x 1260	430 x 1190 x 1260	
	Weight ca.	kg	180	196	200	
Operational Part	Welding values	1) Sheet steel	mm	4 + 4 max. 5 + 5	5 + 5 max. 6 + 6	6 + 6 max. 7 + 7
		C-content smaller = 0,2 %				
		CrNi sheet	mm	0,75 + 0,75	0,75 + 0,75	0,75 + 0,75
		Brass sheet	mm	1,5 + 1,5 max. 2 + 2	2 + 2 max. 3 + 3	3 + 3 max. 4 + 4
		Aluminium sheet	mm	0,8 + 0,8 max. 1 + 1	1 + 1 max. 1,2 + 1,2	1,2 + 1,2 max. 1,5 + 1,5
		Round steel Ø	mm	8 + 8	12 + 12	16 + 16
		C-content smaller = 0,2 %		max. 12 + 12	max. 16 + 16	max. 17 + 17

Notes:

- 1) dependant on size influences
- 2) details incl. electrode arms

Technical alterations reserved.

*details for shortest throat depth.