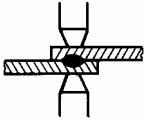


# DALEX

## WELDING TECHNOLOGY



rocker arm-  
**SPOT**- welding machine



fig. Series SL 200

### TECHNICAL DETAILS

- 5-times synchronised welding control with 8 welding programs for operation with thyristor power stage
- digital current and time setting
- upslope and impulse function
- mains voltage compensation
- automatic mains recognition of 50/60 Hz
- parameter entry via keys in operator console
- status display via LED's
- international operating symbols
- stepping and locking contact
- throat depth infinitely adjustable
- compressed air servicing unit
- main switch acc. to VDE 0113
- 3 m connecting lead excl. plug
- corresponds to the standards VDE 0545-1, EN 60204-1, EN 50 240, EN 292 parts 1+2, EN 1050
- CE - displayed

### TECHNICAL DATA SL 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.:	420 daN

Series SL 200

Resistance welding machines

# DALEX Spot welding machines SL 202 / 204 / 206

Technical Data* acc. to DIN 44753 / ISO 669			SL 202	SL 204	SL 206	
<b>Throat depth</b>		<b>mm</b>	<b>130 - 500</b>	<b>130 - 500</b>	<b>130 - 500</b>	
<b>Electrical Part</b>	<b>Machine power</b>	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
	<b>Machine voltage</b>	Secondary idling voltage	V	3,7	5,2	5,9
	<b>Mains connection</b>	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 <sup>2</sup>	6	10	16	
<b>Secondary current</b>	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	
<b>Mechanical Part</b>	<b>Spot mounting</b>	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
	<b>Cylinder – single stroke</b>	Electrode stroke max.	mm	50	50	50
		Electrode force short throat depth	daN	75 - 420	75 - 420	75 - 420
		Electrode force long throat depth	daN	30 - 180	30 - 180	30 - 180
		Max. movements	strokes/min	60	60	60
	<b>Compressed air</b>	Pipe connection		NG 16 – G ½	NG 16 – G ½	NG 16 – G ½
Operating pressure max.		bar	6	6	6	
<b>Cooling water</b>	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	
<b>Machine measurements</b>	width x depth <sup>2)</sup> x height	mm	430 x 1190 x 1260	430 x 1190 x 1260	430 x 1190 x 1260	
	Weight ca.	kg	180	196	200	
<b>Operational Part</b>	<b>Welding values</b>	1) Sheet steel	mm	4 + 4	5 + 5	6 + 6
		C-content smaller = 0,2 %		max. 5 + 5	max. 6 + 6	max. 7 + 7
		CrNi sheet	mm	0,75 + 0,75	0,75 + 0,75	0,75 + 0,75
		Brass sheet	mm	1,5 + 1,5	2 + 2	3 + 3
				max. 2 + 2	max. 3 + 3	max. 4 + 4
		Aluminium sheet	mm	0,8 + 0,8	1 + 1	1,2 + 1,2
				max. 1 + 1	max. 1,2 + 1,2	max. 1,5 + 1,5
Round steel Ø	mm	8 + 8	12 + 12	16 + 16		
		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.