

Inverter Drawn Arc Stud Welding Machines-i25

The compact i25 is digital portable Inverter drawn arc stud welder and is capable of welding from 12 mm to 25 mm studs



Features & Advantages

- Weld current & weld time can be set
- Reduction in Input KVA of machine
- Constant current power source ensures consistent weld quality
- Smart digital display provides easy viewing of parametres
- Faster arc response because of Inverter technology makes it more reliable and repeatable
- Excellent performance on coated sheets



Applications

Steel girders for ROB's — Anchor plates — Composite coloums — PEB's — Mezzanine floor decks
Expansion joints — Shipbuilding — Transformer tanks

Strong welds. No Secondary operations.

Inverter Drawn arc stud welding is a highly efficient method of attaching fasteners primarily to mild steel and stainless steel by utilizing a constant current DC power supply. The welding process uses a welding inverter which serves as an energy source and provides continuous welding current. The welding time can be adjusted from 10 to 400 milliseconds.

Inverter Drawn Arc Stud Welding quickly joins a base metal to a stud/fastener. The welding is performed via a controlled electric arc process, which melts the end of the fastener to join it to the base metal.

Materials for stud welds and base metals that can be joined with Inverter Drawn Arc Stud Welding include — Low carbon Steel — Stainless steel — Galvanized Steel



Technical Specifications



	i25
Voltage	415 V -10% + 10%, 50/60 HZ
Max current	2400 A
Capacity	12 mm to 25 mm
Welding current	300A - 2400A
Welding time	100mS - 3000 mS
No .of gun	1
Weight	250 KGS (Approx)
Display	LCD based
Case dimensions (LxWxH)	1060mm x 640mm x 670mm
Working capacity @50°c	4 stud / min @ 25 mm stud
Gun cable length	30 Meter
MCB	100 Amp
Input cable size	5 Meter (25 sq.mm x 3)
Earthing cable	10 Meter x 2
Earthing cable size	70 Sq mm
Connected load	125 KVA
Generator required	200 KVA (min)

Features

- Password Protection — Alpha-numeric text display — Fine adjustment of weld time
- Weld counter — Protection against overloading of machine

Drawn Arc Welding Advantages

The Drawn Arc welding provides superior welding quality under a wide range of requirements. The full cross-sectional weld, in drawn arc stud welding, provides stronger bond while creating several benefits in quality, productivity, and cost advantages.

Superior Quality

Better weld strength

Drawn arc stud welding produces welds that are vibration-proof and resistant to breaking, loosening, or weakening.

Versatile weld designs

One-sided fastening in Drawn Arc Welding allows for greater variety in design.

Better Productivity

Easy to weld, faster welding for fasteners

As compared to the fastening operations, stud welding is way more easier due to welding times of less than a second and access required from only one side.

No secondary operations

Stud welding eliminates the need for drilling, tapping and riveting.

Cost Effective operations

Savings in relatively complex fabrication

Odd-shaped fabrication is relatively easy to perform with simple welding of studs, as opposed to other methods, thereby saving costs and time.

Artech Welders Private Limited

📍 No. A-24/1, H-Block, MIDC, Pimpri, Pune, Maharashtra 411 018, India.

☎ +91 20 2747 6160 / 2746 2771 / 72

✉ sales@artechwelders.com 🌐 www.artechwelders.com

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