

# Stud Welding Equipment - Arc

## VISAR 1200

- All-rounder for workshops and construction sites – whether with shielding gas or with ceramic ferrule
- Compact lightweight unit with power: 1 200 A but just 20.5 kg
- Extremely wide current setting range from 25 to 1 200 A
- USB port for saving and loading welding programs
- Comprehensive customer-specific setting options as well as detailed process optimisation and control



M3 to M16 - #4 to 5/8"

Welding process	Arc = Drawn arc stud welding, SC = Short cycle stud welding			
Welding material	Mild Steel - Stainless Steel - Aluminium <sup>1)</sup> Welding element is not standardized according to DIN EN ISO 13918, but manufactured by the manufacturer's discretion. The welding parameters should be determined by test weldings.			
Technology	Inverter			
Equipment				
Welding with ceramic ferrule	x			
Welding with shielding gas	x			
Process control	x			
Display	Digital			
Welding range	M3 to M16, dia. 2 to 16 mm / #4 to 5/8", dia. 14 ga to 9/16"			
Welding rate (Duty cycle <sup>2)</sup> )	25 °C	100 %	50 %	35 %
	F [studs/min]	11	16	21
	t [ms]	600	600	600
	I <sub>2</sub> [A]	1200	1200	1200
	U <sub>2</sub> [V]	30	30	30
<sup>2)</sup> The term "duty cycle" refers to the ratio of welding duration to work pause of a stud welding unit. It describes the uninterrupted operating time of a unit over a period of 10 minutes. The largest possible studs are used in the test. 100 % duty cycle = 10 min. of continuous welding, no shutdown due to overtemperature. 50 % duty cycle = 5 min. of welding followed by 5 min. pause. 35 % duty cycle = 3.5 min. of welding followed by 6.5 min. pause.				
Welding current	1 200 A (max.) at 50 V			
Current adjustment range	25 to 1 200 A (stepless)			
Welding time	5 to 1 500 ms (stepless)			
Primary power	200 to 600 V, 3 phases, 50/60 Hz			
Cooling type	F (temperature controlled cooling fan)			
IP Code	IP 43			
Dimension LxWxH (without handle)	472.5 x 355 x 358 mm / 18.60" x 13.98" x 14.09"			
Weight	20.5 kg / 45 lbs			
Suitable guns	A 12, A 12-FL, A 16			
Order No.	93-60-0120 (Europe + China) 93-66-0120 (USA, Canada + China) 93-40-020 (Ground cable, 5 m, 25 mm <sup>2</sup> , 2x 10" vice grip) 88-24-466 (Toolbag) (Accessories and welding gun are not included)			