



INVERTER ARC STUD WELDER - IT 2002



TECHNICAL DATA

Gas	Option
Welding range	#4 to 1", dia. 14ga to 1" (M3 to M24, dia. 2 to 25mm)
Welding material	Mild steel, stainless steel, aluminum
Welding rate	7/8" = 7 studs per minute (dia. 22 mm = 7 studs/min)
Welding current	2,000 A (max.)
Current adjustment range	300 to 2,000 A (stepless)
Welding time	5 to 1,500 msec (stepless)
Primary power	480/460 V, 3 phases, 50/60 Hz, 63 AT (alternative input voltages available)
Connected load	100 KVA (with 400 V mains), 80kw
Cooling type	F (temperature controlled cooling fan)
Protection class	IP 23
Operation and storage conditions	According to current standards
Dimensions L x W x H	23.6" x 19.7" x 32.7" (600 x 500 x 830 mm) without handle
Weight	209.4 lbs (95 kg)
Order No.	93-66-2201
	93-66-2202 (Gas)

www.sunbeltstudwelding.com

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14-19

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FEATURES

Features

- **Microcontroller** – for precise process times, optimal functional reliability and maximum operating convenience
- **Function monitoring** – automatic function test following power-up; monitoring of all internal system functions
- **Lift test** – for gap welding guns and welding heads
- **Library function** – automatic specification of welding current and welding time through selection of stud diameter according to welding range (with and without shielded gas); fine adjustment via arrow keys

SUITABLE STUD WELDING GUNS

A 12 with ceramic leg assembly PSC-1	A 12 with gas shroud PSS-1/SC
A 12 with shielding gas leg assembly PSS-2	A 12-FL
A 16	A 22

GENERAL INFORMATION

Application

- Especially suitable for thicker sheets of about .093 inches (2 mm) or higher
- Especially suitable for welding of concrete anchors/shear connectors for job site applications
- Suitable for through deck welding

Process Variants

- Short cycle (SC)
- Drawn arc with ceramic ferrule (ARC)
- Drawn arc with shielding gas (ARC)

Equipment

- Welding with ceramic ferrule (series)
- Welding with shielding gas (optional)

ADVANTAGES

Structure

- **Extremely easy to operate**
- **Compact/Mobile** – highly mobile thanks to compact dimensions and low weight (50% less weight compared to conventional stud welding units)
- **Robust** – metal housing withstands rough treatment in shop and on site

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ADVANTAGES (continued)

Safety

- With integrated **mains filter** (protection against voltage peaks)
- Optimal for construction sites with large mains voltage fluctuations—use even with critical voltage supply $\pm 10\%$
- **EMC test**
- **High-voltage test with log**
- **Retriggering lock-out** – prevents welding on a welding element that has already been set
- **Thermal monitoring of transformer** – automatic shutdown in case of overheating
- **Temperature-regulated ventilator** – reduces noise and dust in the stud welding unit (greater reliability)
- **Control unit galvanically separated from welding lines** – high degree of functional safety
- **Optimal protection against external interferences**
- **Protection class IP 23**
- Also permits **operation outdoors**

Welding

- **Display** – infinitely adjustable power setting; easy monitoring of all functions via LED displays; easy operation via membrane keyboard and digital display; setting of welding parameters, programs, shielding gas (optional); digital display of current, welding and gas-preflow time; separate settings for welding current and welding time
- **Powerful** – built-in power reserves
- **Trouble-free changing** of welding voltage polarity possible for reconnecting welding current and ground cables
- **Outstanding welding quality** – very high arc stability even at weak welding currents
- **High process flexibility** – high clock frequency (30 kHz) of stud welding unit allows highly dynamic regulation for welding process

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