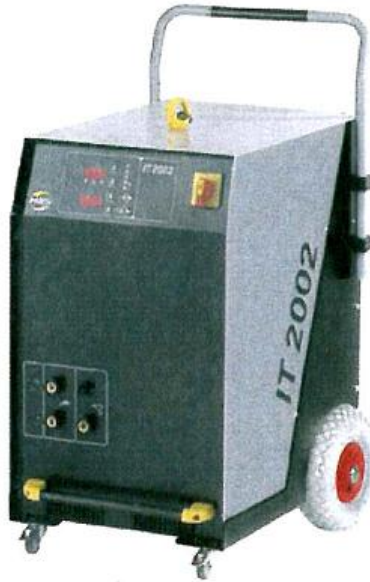




# ARC WELDERS: IT 2002



| Technical Data  |   |
|---|---|
| Gas   | Option  |
| Welding range   | #4 to 1ö, dia. 14ga to 1ö (M3 to M24, dia. 2 to 25mm)                       |
| Welding material  | Mild steel, stainless steel, aluminum                                       |
| Welding rate  | 7/8ö = 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  | 23.6ö x 19.7ö x 32.7ö (600 x 500 x 830 mm) without handle                   |
| Weight  | 209.4 lbs (95 kg)   |
| Order No.   | 93-66-2201  |
|   | 93-66-2202 (Gas)  |
| Features  |   |
| <ul style="list-style-type: none"> <li>• <b>Microcontroller</b> – for precise process times, optimal functional reliability and maximum operating convenience</li> <li>• <b>Function monitoring</b> – automatic function test following power-up; monitoring of all internal system functions</li> <li>• <b>Lift test</b> – for gap welding guns and stud welding heads</li> <li>• <b>Library function</b> – 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</li> </ul> |   |
| Suitable stud welding guns  |   |
| <ul style="list-style-type: none"> <li>• A 12</li> <li>• A 16</li> <li>• A 22</li> <li>• A 25</li> <li>• AI 06</li> </ul>   |   |

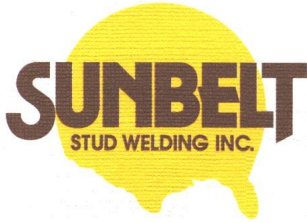
[www.sunbeltstudwelding.com](http://www.sunbeltstudwelding.com)

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14-16

**1-800-462-9353**  
**713-939-8903**  
**fax 713-939-9013**



# TECHNICAL DATA SHEET ARC WELDERS: IT 2002

## 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 drawn arc welding
- Drawn arc welding

### Equipment

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

## Advantages

### Structure

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

### Safety

- With integrated **mains filter** (protection against voltage peaks)
- **Optimal for construction sites with large mains voltage fluctuations**óuse 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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