

# Stud Welding Equipment - Automatic Components

## IT 90 STUD WELDING UNIT



### IT 90

Stud Welding Unit  
for Arc stud welding  
according to current standards

### Inverter

- Maximum welding quality
- Maximum welding rates
- Minimum energy consumption
- Minimum weight
- Maximum efficiency

Technical Data	
Gas/Automation/Process control	Series/Series/Series
Welding range	#4 to 1", dia. 14 ga to 7/8" (M3 to M24, dia. 2 to 22 mm)
Welding material	Mild steel, Stainless steel, Aluminum
Welding rate	Dia. 7/8" = 7 studs/min (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) 80 kW
Cooling type	F (temperature controlled cooling fan)
IP-Code	IP 21
Dimension L x W x H	25.6" x 22" x 50.8" (650 x 560 x 1,290 mm) without handle
Weight	93-66-12096: 315.26 lbs (143 kg) 93-66-42096: 363.76 lbs (165 kg)
Order No	93-66-12096 (Gas/Automation/Process control/1 Gun connection) 93-66-42096 (Gas/Automatic/Process control/4 Gun connections)
General Information	
Application	
• Especially suitable for thicker sheets of about 2 mm or higher	
Process variants	
• Short cycle drawn arc welding	
• Drawn arc welding	
Equipment	
• Welding with ceramic ferrule (series)	
• Welding with shielding gas (series)	
• Automation (series)	
• Process sequence control (series)	



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