

The butt-upset welders are designed for welding of circular, square, rectangular intersection rods made of low alloy and alloy steel, copper and aluminium of diameters from 2.0 up to 25mm.

Simple construction, reliable operation and high quality of welds are a common features of this group of welders. Welding annealing unit is attached to each welder in order to improve plastic properties of the weld.

These welders are built on the basis of:-

Welding transformers of 50% duty cycle, using ASM-911 welding control with eight programmes.

Welding Capability	units	ZDZ-4P	ZDZ-7P	ZDZ-16P	ZDZ-40P
Low Carbon Steel	mm	2.0-10.0	4.0-14.0	8.0-20.0	12.0-25.0
Alloy Steel	mm	2.0-8.0	4.0-12.0	8.0-16.0	12.0-20.0
Cu	mm	2.0-6.0	5.0-10.0	6.0-12.0	10.0-18.0
Al	mm	3.0-7.0	6.0-12.0	6.0-12.0	14.0-18.0
Work Parameters					
Rated Power P50%	Kva	4	7	16	40
Short Circuit Power	Kva	22.5	99	132	429
Secondary Short Circuit Current	KA	10	30	40	52
Max Welding Current	KA	8	24	32	41.6
Secondary Short Circuit Voltage	V	2.2	3.3	3.3	4.13-8.25
Time Delay Cut Outs	A	25	25	60	315
Welding Force Type		pneumatic	pneumatic	pneumatic	pneumatic
Welding Force Of Electrodes	daN	10.0-58.0	70-340	110-540	400-900
Supply Power					
Installed Power	V	400(50hZ)	400(50hZ)	400(50hZ)	400(50hZ)
Required Compressed Air Pressure	Mpa	0.6	0.6	0.6	0.6
Compressed Air Usage At 0.6mpa	L/weld	3	4.5	5.5	14.5
Required Cooling Water Pressure	MPa	0.2-0.4	0.2-0.4	0.2-0.4	0.2-0.4
Min Water Usage At Rated Power	L/h	180	240	600	600
Dimensions					
Overall Dimensions Lxdxh	mm	620X600X1100	790X580X1320	790X580X1320	1120X960X1625
Weight	kg	84	160	200	650

