

Butt Welders

aircooling, manually operated



N 3



N 9



N 12



N 22

Butt welders for wire drawing mills

This manual operated machines are for butt welding of wire products at single production best suitable.

These butt welders are especially designed for wire drawing mills for joining steel, brass, aluminium and copper rods, are recommended for non heavy duty applications.

Technical Details:

- easy to use
- manually operated
- thyristor welding controller
- movable jaw by bearings for very precise sliding with low Friction to achieve quality welding
- graduated scala to easily set the opening of the jaws. (N3, TR9 and N12)
- start manually
 - at N 9 with footlever
 - at N 3, N 12, N 22 and N20 with handlever
- all models are standard supplied with the annealing function wheel trolley standard at N3, N9, N12 and N20, at N 22 this is optionally possible.



N 20
for concrete wire

Butt Welders N 3, N 9, N 12, N 20 and N 22

technical Data acc. to DIN 44753

Type		N 3	N 9	N 12	N 20	N 22	
Article-no.		60-310-605	60-310-610	60-310-615	60-310-618	60-310-620	
Machine power	Power rating (50%)	kVA	0,8	3	4	20	
	Maximum welding power	kVA	2	9,6	18	88	93
Machine voltage	Secondary idling voltage	V	2	2,6	2,4	4,4	4,2
	Number of regulation Steps		0				
Mains connection	Rated primary voltage	V	400				
	Rated frequency	Hz	50/60				
	Supply power	kVA	1	3	4	15	
	Fusing (carrier)	A	10			63	40
	Wire range (cable length < 15m)	mm ²	2,5			16	
Sec. current	Short-circuit-current	kA	1,2	4,4	10	25	28
Electrode force	Clamping force	daN	10	80	200	400	1000
	Upsetting force	daN	1,3	20	80	250	300
Machine measurements	Width x depth x height	mm	515x518x1145	565x565x1100	660x770x1120	880x800x1650	600x800x1550
	Weight	kg	52	80	80	320	280
Welding values	Steel (C-content ≤ 0,2%)	Ø mm	0,5-2,5	0,8-8,0	2,0-14,0	8,0-22,0	3,0-18,0
		mm ²	4,9	50	150	-	250
	Stainless steel	Ø mm	0,5-1,2	0,8-6,0	2,0-9,0	-	3,0-16,0
		mm ²	1,1	28	65	-	200
	Aluminium	Ø mm	0,8-2,0	2,0-5,0	2,0-8,0	4,0	4,0-12,0
		mm ²	3,1	20	50	-	110
	Copper	Ø mm	0,5-1,8	1,5-3,5	2,0-6,0	-	4,0-8,0
		mm ²	2,5	10	28	-	50
	Brass	Ø mm	0,5-1,8	1,5-3,5	2,0-6,0	-	4,0-10,0
		mm ²	2,5	10	28	-	75

Technical changes reserved. The table contents refer to standard models.

Extra Equipment:

- grinding wheel
- lighted magnifying glass (only at N 3)
- version with annealing facility „R“ (only at N 22)
- four wheel trolley (only at N 22)

Spezial Versions:

- rated primary voltage 230V
- vertical up wire welding (only at N 22)

Option Welding Control:

digital thyristor weld controler WS 708
(only at N 22)



N 22 with grinding wheel and four wheel trolley

