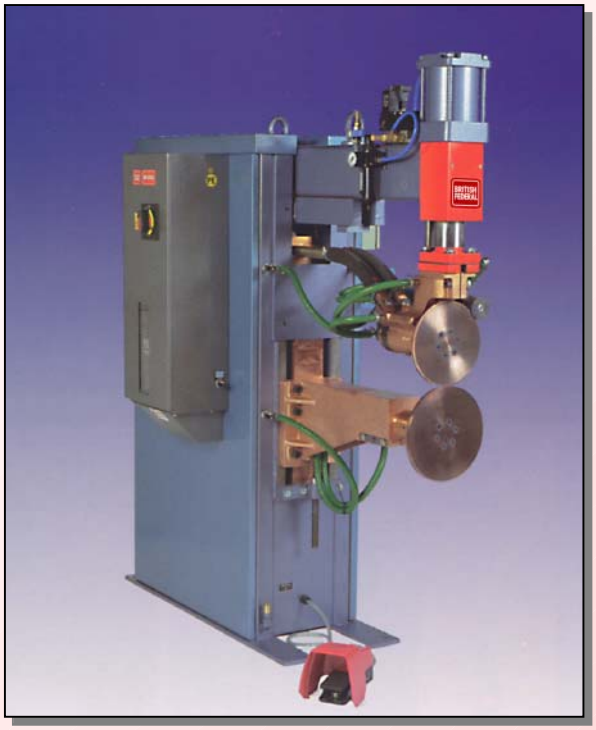
# UNIVERSAL SEAM WELDERS

## STRONGHOLD 80KVA



The ‘Stronghold’ range of resistance welding machines enhances its adaptability with the seam- welding version.

The transformer is specially designed for the high duty seam welding. A machine rating of 80KVA provides the economic solution for many overlap joint welding applications.

The British Federal welding control system with software and adaptation for seam welder operation guarantees consistent weld results and reliability for which the ‘Stronghold’ name is renowned.

- **Circumferential or Longitudinal Modes.**
- **Alternative Drive Systems.**
- **50% Duty Cycle Encapsulated Transformer.**
- **Welding Speeds Up To 3 metres per minute.**
- **C.E. Conformity.**

With over 25 years of continuous development and refinement, the Stronghold concept continues to set the standard for multi-purpose resistance welding machines.

**Federal Resistance Welding Limited**

Castle Mill Works,
Birmingham New Road, Dudley,
DY1 4DA, England.

www.britishfederal.co.uk

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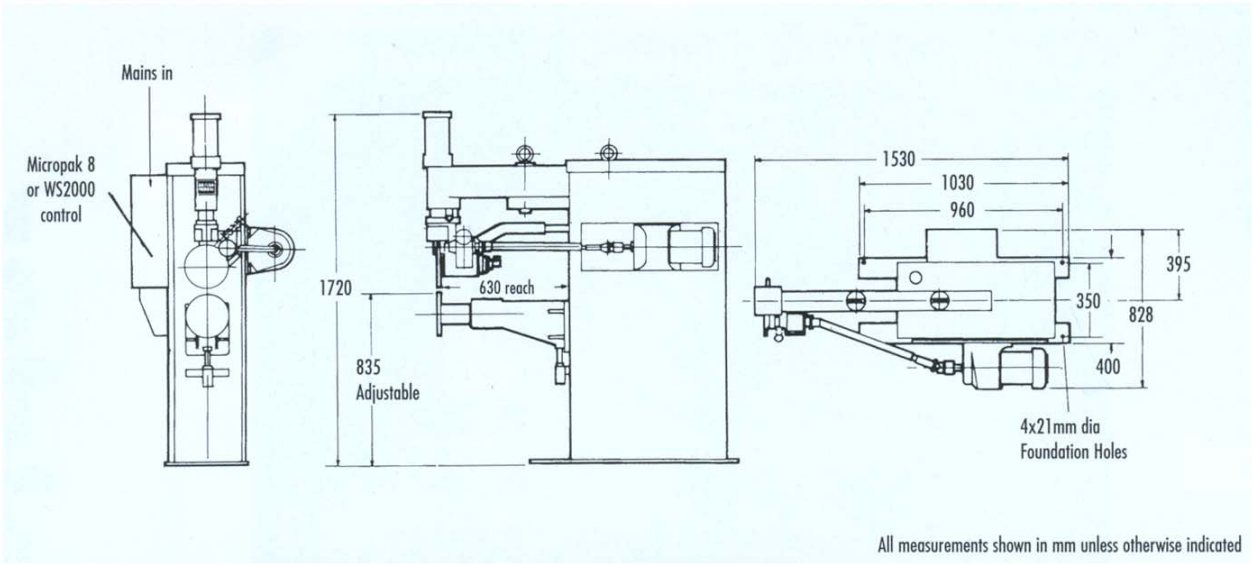
## *Stronghold 80kVA Universal Seamwelder*

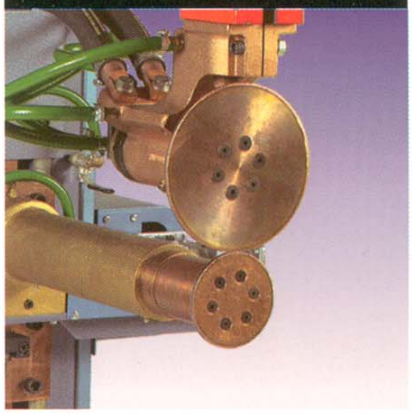



All measurements shown in mm unless otherwise indicated

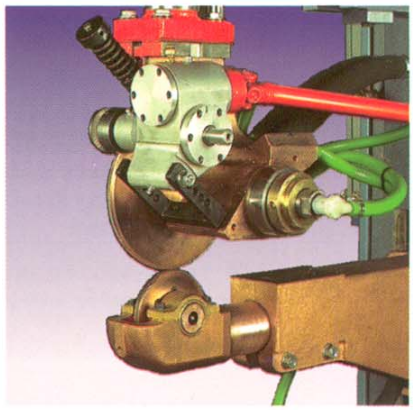
### Technical Specifications

| | | | |
|---|---|---|---|
| Nominal power @ 50% DC | Sn | kVA | 80 |
| Max short circuit power | Scc | kVA | 145 |
| Max welding power | Smax | kVA | 113 |
| Nominal supply voltage (+5% –10%) | U1n | Volts | 415 |
| Nominal primary current @ 50% | I1n | Amps | 190 |
| Supply frequency | | Hz | 50 |
| Supply phases | | | 2 |
| Supply capacity | | kVA | 90 |
| Fuse size (HRC) to BS88 | | Amps | 200 |
| Feed cable c.s.a <30m. run | | $mm^2$ | 70 |
| Max short circuit Pu current | I1cc | Amps | 350 |
| Nominal secondary current @ 50% DC | I2n | Amps | 11,000 |
| Max short circuit current | I2cc | Amps | 20,000 |
| Max welding current | I2max | Amps | 16,000 |
| Duty cycle for ma. welding | Xmax | % | 25 |
| Number of taps | | | 2 |
| Secondary open circuit Volts | U2o | Volts | 4.3/7.2 |
| Welding speed min./max. | | mm/min | 250/3,000 |
| Circumferential electrode | Upper/lower diameter | mm | 200/200 |
| Longitudinal electrode | Upper/lower diameter | mm | 200/125 |
| Weld cylinder diameter | | mm | 125 |
| Electrode force min/max @ 5.5 bar supply | | kN | 1.9/7.1 |
| Electrode force min/max @ 80 p.s.i supply | | lbs | 400/1,500 |
| Electrode stroke max | | mm | 76 |
| Free air consumption per 10mm stroke | | $m^3$ | 0.5 |
| Air pressure normal | | bar | 5.5 |
| Air pressure max operating | | bar | 7.0 |
| Air hose connection | | mm | 12 |
| Cooling water min operating temp. | | bar | 3 |
| Cooling water consumption | | lit./min | 20 |
| Cooling water max inlet temp. | | °C/°F | 36/97 |
| Cooling water hose connection diameter | | mm | 18 |
| Shipping specifications | Nett weight | kg | 900 |
| | Gross weight | kg | 1,100 |
| | Machine size | mm | 828W x 1,530D x 1,720H |

### Optional Head/Drive Configuration



Circumferential



Longitudinal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