

serie **MS**

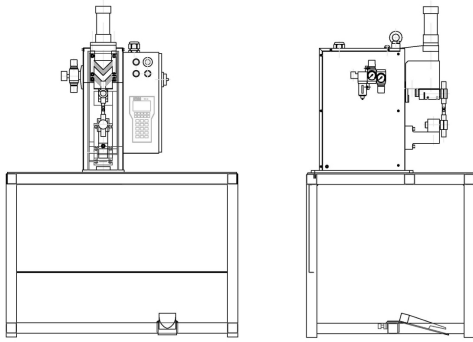
# MICROWELDING

High accuracy in welding of small parts

- AC / Medium Frequency 1000Hz
- Powers from 7 to 50 kVA
- High electronic technology



**SERRA**



### Equipment :

- Pneumatic circuit with double pressure system
- I/O water valves 1/4"
- Air Inlet valve 1/4" (3/8" in MS-50)
- Electric pedal
- AC : Weld controller Serratron 1B and Isolator
- MF: Inverter MFC-3007W, programming unit TP-10, Circuit breaker

### Optionals:

- Delivery without table
- Other voltages (not 400V/50Hz)
- Two hands start
- Pressure switch
- Circuit breaker

### ORDER CODE

#### Welding type

- A- Spot (Series Alfa)
- B- Projection (Series Beta)
- C- Microwelding**
- D- Seam (Series Gamma)

#### Structure dimensions

- 1- Up to 120 daN (MS16 / MS25)
- 2- Up to 450 daN (MS-50)

#### Throat

- 1- 160 mm
- 2- 300 mm

#### Force unit

- 1- 12 daN double pressure
- 2- 30 daN double pressure
- 3- 120 daN single pressure
- 4- 450 daN single pressure

#### Transformer

- 1- 07 kVA (50/60Hz)
- 2- 16 kVA (50/60Hz)
- 3- 25 kVA (50/60Hz)
- 4- 50 kVA (50/60Hz)
- 5- 20 kVA (1000Hz)
- 6- 40 kVA (1000Hz)



MICROWELDING	Series MS	AC 50 Hz						MF 1000 Hz	
		MS-07/AC	MS-16/AC			MS-25/AC	MS-50/AC	MS-25/MF	MS-50/MF
		C1111	C1112	C1122	C1123	C1133	C2244	C1135	C2256
Welding Frequency	Hz	50	50	50	50	50	50	1000	1000
Power at 50 % D.C.	kVA	7	16	16	16	25	50	20	40
Throat depth to electrodes	mm	160	160	160	160	160	300	160	300
Force at 6 bar	daN	12	12	30	120	120	450	120	450
Max. short circuit current (5 periods)	kA	7	9	9	9	18	20	16	16
Max. welding current (5 periods)	kA	5,6	7,2	7,2	7,2	14,4	16,0	16,0	16,0
Air consumption 50mm / 6 bar	NI	0,13	0,13	0,30	1,26	1,26	5,3	1,26	5,3
Cooling water consumption	l/h	280	280	280	280	280	400	400	600
Admissible power	kVA	15	30	30	30	50	100	25	50
Delayed fuses	A	63	63	63	63	63	100	63	63
Main supply section by phase	mm <sup>2</sup>	6	6	6	6	16	25	16	16
Secondary voltage	V	2,5	3,7	3,7	3,7	5,0	6,3	4,0	5,0
Electrode diameter (conical 10°)	mm	5,0	5,0	5,0	5,0	12,5	16	12,5	16
Electrode holder diameter	mm	-	-	-	-	-	25	-	25
Arms diameter	mm	-	-	-	-	-	60	-	60
Maximun distance between arms	mm	80	80	80	80	134	207	134	207
Welding stroke	mm	45	45	45	45	45	100	45	100
Cycles per minute (10 mm gap)	min <sup>-1</sup>	90	90	90	90	90	90	90	90
Width	mm	730	730	730	730	730	806	730	806
Width	mm	1000	1000	1000	1000	1000	1000	1300	1300
Heigh	mm	1262	1262	1262	1262	1426	1807	1426	1807
Weight	Kg	180	180	180	180	185	250	178	240

