AR8100

artech

Drawn Arc Stud Welder

Advantages

- Excellent reliability
- Uniform high welding quality
- No additional material such as flux or filler necessary
- High duty cycle
- Elimination of operations such as drilling and riveting

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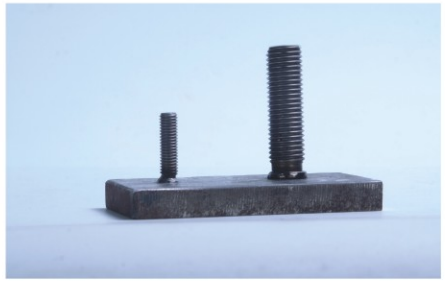
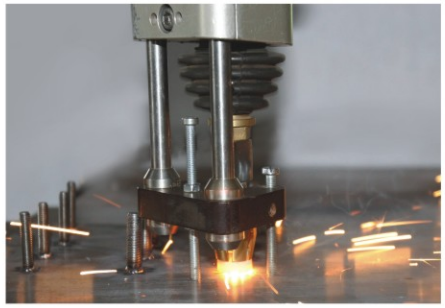
Drawn arc stud welding is an extremely efficient method of attaching fasteners primarily to mild steel and stainless steel by utilizing a constant current DC power supply. In this welding process, a welding rectifier serves as an energy source and provides a continuous welding current. The welding time can be adjusted from 10 to 950 milliseconds. When a weld is initiated, current begins to flow through the stud while the weld gun simultaneously lifts the stud to draw an arc, which melts the base of the stud and adjoining surface on the workpiece. Upon completion of the weld time, the gun plunges the stud back to the workpiece, resulting in a permanent bond as the molten material solidifies. The whole process takes less than one second.

During the welding process, a welding fillet is formed around the base of the stud, the dimension of which is predetermined by the ceramic ferrule. The ceramic ferrule concentrates the welding arc and forms a weld fillet around the stud base. Weld gun with shielding gas option can also be used.

This method has a higher depth of penetration compared to other stud welding processes. These machines are most commonly used in transformer manufacturing, ship building industry, boiler industry, power plants, automobile industry etc.





TECHNICAL DATA — AR 8100

Stud welding range [thread size]	M 8 to M 16
Welding current	1500 Amps. Max.
Welding Time	10 to 600 ms
Power	415 V 3 phase 50 Hz
Power source	Transformer / Rectifier
Welding Cable	3 Meter
Welding material	Mild Steel, Stainless steel
Welding Gun	Gap Gun

Specifications subject to change without notice

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