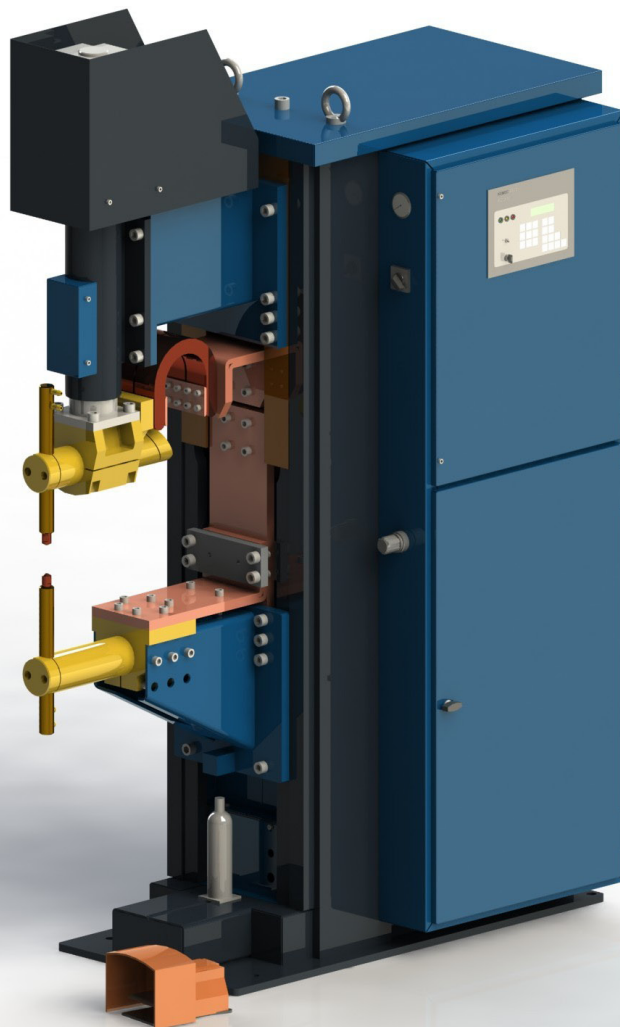


KEMEC

KRW B81-121 – SPOT WELDING

With the Kemecweld KRW 81 and KRW 121 spot welding machines it is possible to make strong welds quickly and cleanly without filler materials. In addition to unalloyed steel, the machine can be used for spot welding zinc-coated steels, aluminium and stainless materials.

The KRW spot welding machines have a rugged construction and are reliable in operation. The frame is compact and accepts a wide range of additional equipment. The welding characteristics are excellent.



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THICK SHEET METALS AND DEMANDING WELDS WITH KRW B SPOT WELDERS

TECHNICAL DATA KRW B81 B121

Electrical data

Mains voltage	V/Hz	400/50	400/50
Rated power 50 % ED	kVA	80	120
Secondary current	kA	24	32
Secondary voltage	V	5 - 7	5 - 7
Mains cable, Cu	mm ²	70	150
Fuses, delayed	A	160	250

Mechanical data

Working depth	mm	500/750	500/750
Gab height	mm	150 - 285	150 - 285
Elektrode pressure	kN	7,3	12
Stroke length	mm	100	100
Working height	mm	600 - 900	600 - 900
Main dimensions			
height	mm	2000	2000
width	mm	670	670
depth	mm	1250	1250
Weight	kg	850	900

Compressed air

Pressure	bar	2 - 6	2 - 6
Consumption (6 bar)	l/stroke	2,3	4,0

Cooling water

Pressure	bar	2 - 4	2 - 4
Consumption	l/min	4	4



The functions of the **Kemecweld RCU 101** control unit are particularly suitable for spot welding different materials. A total of 15 complete welding programs can be stored in the unit's memory.

In addition to the basic functions, the RCU 101 features:

- adjustable current up-slope time
- pulsation of current time
- operation modes: single spot, serial spot or seam welding
- illuminated LCD display
- key-lockable setting of welding parameters
- membrane keypad