

COMPACT EQUIPMENT INVERTER

The KÖCO compact stud welding equipment INVERTER TECHNOLOGY combine excellent welding characteristics with low weight, minimum size and outstanding performance. Therefore they are the ideal equipment for mobile tasks or stud welding on thin work-pieces.

Welding current setting is infinitely variable, and the selected setting is maintained with high accuracy throughout the welding process. Welding time can be set in steps of 1 ms, thus enabling adjustment of the welding energy with an extremely high degree of accuracy. Fusion penetration is kept extremely low in spite of the high current (short cycle stud welding).

All parameters can be set by turning a sturdy rotary knob with a built-in push-button, the 2305i has a key panel, and can be followed on an illuminated LC display. Up to 20 sets of parameters can be stored (welding current, welding time and shielding gas pre-flow time), which facilitates correct parameter setting in case of recurrent welding tasks.

Deviations from the normal mode are shown on the appliance by a red pilot lamp, and simultaneously on the display in plain text (self-diagnosis).

ADVANTAGES OF THE INVERTER SERIES

- Light weight, minimum size
- Mobile in use for weldable studrange 2-25 mm diameter
- Process control integrated
- Suitable for all stud welding processes
- Memory connection with USB

COMPACT EQUIPMENT INVERTER

Excellent welding characteristics with low weight, minimum size and outstanding performance.

INVERTER
Series

THE INVERTER SERIES

Our mobile compact stud welding equipment



Unit: 905i

Unit: 1305i



Unit: 1805i

Unit: 2305i

Unit	905i	1305i
Stud welding with ceramic ferrule, Weldable stud range Ø (mm)	2-12	3-16
Short cycle stud welding, Weldable stud range Ø (mm)	2-8	3-8
Stud welding with shielding gas, Weldable stud range Ø (mm)	2-10	2-16
Max. current (A)	800	1300
Current setting range (A)	100-800	200-1300
Time setting range (ms)	1-800	1-1000
Gas pre-flow time (ms)	10-2000	100-2000
Max. stud/min. at ... Ø (mm)	4/12 9/10	2/16 5/12
Self-diagnosis: overheating	●	●
short circuit control	●	●
mains phase failure	●	●
malfunction of pilot arc	●	●
Microprocessor control	●	●
Storage of parameters for current, time und Gas pre-flow time	20	20
Constant current regulation	●	●
Repeat cycle lock	●	●
Mains connection 50/60 Hz (V)	3 x 400	3 x 400
Mains plug (A)	32	32
Mains cable	4 wires/5 ms/4 mm ²	4 wires/5 m/6 mm ²
Mains fusing time-lag (A)	min. 20	35
Mains power consumption at ...% ED (kVA)	3/45 7,5/28	2/69, 4,5/45, 100/9,5
Tolerance range mains voltage (%)	-15/+6	-15/+ 6
Menu: selection of various languages	●	●
Dust and moisture protection of control unit	●	●
Class of protection	IP 23	●
Cooling	F	●
Stud counter	●	●
Interface for automatic components	○	○
Housing dimensions (L x W x H) mm	410 x 220 x 250	550 x 175 x 395
Swivel castors/fixd castors	-	-
Weight (approx. kg)	17	24
Shielding gas equipment	●	●
Stud welding guns: SK 14	●	●
K 22	○	○
K 22-D	○	○
K 26	-	-

Unit	1805i	2305i
Stud welding with ceramic ferrule, Weldable stud range Ø (mm)	2-19	2-25
Short cycle stud welding, Weldable stud range Ø (mm)	2-10	2-10
Stud welding with shielding gas, Weldable stud range Ø (mm)	2-12	2-12 (16)
Max. current (A)	1600	2300
Current setting range (A)	200-1600	200-2300
Time setting range (ms)	1-1000	1-1500
Gas pre-flow time (ms)	10-2000	10-2000
Max. stud/min. at ... Ø (mm)	2/19 6/16	3/25 5/22
Self-diagnosis: overheating	●	●
short circuit control	●	●
mains phase failure	●	●
malfunction of pilot arc	●	●
Microprocessor control	●	●
Storage of parameters for current, time und Gas pre-flow time	20	20
Constant current regulation	●	●
Repeat cycle lock	●	●
Mains connection 50/60 Hz (V)	3 x 400	3 x 400
Mains plug (A)	63	63 / optional 125
Mains cable	5/10	5/16
Mains fusing time-lag (A)	min. 50	63/80
Mains power consumption at ...% ED (kVA)	3/90 6/65	8/117 11/90
Tolerance range mains voltage (%)	-15/+6	-15/+6
Menu: selection of various languages	●	●
Dust and moisture protection of control unit	●	●
Class of protection	IP 23	IP 23
Cooling	F	F
Stud counter	●	●
Interface for automatic components	○	○
Housing dimensions (L x W x H) mm	600 x 270 x 410	800 x 310 x 535
Swivel castors/fixd castors	2/2	2/2
Weight (approx. kg)	36	63
Shielding gas equipment	●	●
Stud welding guns: SK 14	○	○
K 22	○	○
K 22-D	●	○
K 26	-	●