



## KÖCO-Compact Stud Welding Equipment

INVERTER

The KÖCO compact stud welding equipment INVERTER TECHNOLOGY 905i and 1805i 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

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).



INVERTER

# INVERTER

Technical data	905i	1805i
Stud welding with ceramic ferrule Weldable stud range $\varnothing$ (mm)	2 - 12	2 - 19
Short cycle stud welding Weldable stud range $\varnothing$ (mm)	2 - 8	2 - 10
Stud welding with shielding gas Weldable stud range $\varnothing$ (mm)	2 - 10	2 - 12
Max. current (A)	800	1600
Current setting range (A)	100 - 800	200 - 1600
Time setting range (ms)	1 - 800	1 - 1000
Storage of parameters	20	20
Max. stud/minute at ... $\varnothing$ (mm)	4/12 9/10	2/19 6/16
Self-diagnosis: overheating short circuit control mains phase failure internal failure	● ● ● ●	● ● ● ●
Microprocessor control	●	●
Constant current regulation	●	●
Repeat cycle lock	●	●
Mains connection 50/60 Hz 3-phase (V)	400	400
Mains plug at 400 V (A)	32	63
4-wire mains cable (m/mm <sup>2</sup> )	5/4	5/10
Mains fusing time-lag (A)	20	50
Mains power consumption at ...%ED/(kVA)	3/45 75/28 100/75	3/90 6/65 100/15,5
Tolerance range mains voltage (%)	-15/+6	-15/+6
Class of protection	IP 23	IP23
Cooling	F	F
Steel housing, powder-coated	●	●
Housing dimensions (L x W x H) mm	410 x 220 x 250	600 x 270 x 410
Swivel castors/fixed castors	-	2/2
Handle	1	2
Weight (kg)	17	36
Shielding gas equipment	●	●
LC-Display with backlight	●	●
German/English/French/Italian language selectable	●	●
Interface for automatic components	○	○
Stud counter	●	●
Gas pre-flow time (ms)	10 - 2000	10 - 2000
Stud welding guns: SK 14 K 22 K 22-D	● ○ ○	○ ○ ●

● = Standard, ○ = Option

⚠ Welding under increased electrically hazardous conditions permissible, CE-Labeling according to EN 60974-1 etc.

Update 11/2008. Subject to technical modifications.



Köster & Co GmbH  
Spreeler Weg 32  
D-58256 Ennepetal  
Germany



Tel. + 49 (0)23 33 8306-0  
Fax + 49 (0)23 33 8306-38  
E-mail koeco@bolzenschweisstechnik.de  
Internet www.koeco.info

