

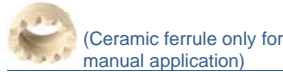


## IT 1002



- All-rounder for automation
- Precise welding results through advanced inverter technology

M3 to M16 (type RD)  
#4 to 5/8" (type RD)

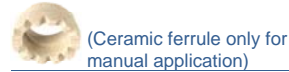








## IT 90



- 4 outputs (optional), process monitoring and shielding gas
- For critical surfaces (e.g. galvanised)

M3 to M24  
#4 to 1"



<b>Welding process</b>	ARC, SC	ARC, SC
<b>Welding material</b>	  	  
<b>Technology</b>	Inverter	Inverter
<b>Equipment</b>		
Welding with ceramic ferrule	X	X
Welding with shielding gas	X	X
Process control	X	X
Automation	X	X
4 gun/head connections	--	(optional)
<b>Display</b>	Digital	Digital
<b>Welding range</b>	M3 to M16 (type RD), dia. 2 to 14 mm #4 to 5/8" (type RD), dia. 14 ga to 9/16"	M3 to M24, dia. 2 to 22 mm / #4 to 1", dia. 14 ga to 7/8"
<b>Welding rate</b>	M12 / 1/2" = 25 studs/min	Dia. 22 / 7/8" = 6 studs/min
<b>Welding current</b>	1 000 A (max.)	2 000 A (max.)
<b>Current adjustment range</b>	100 to 1 000 A, electrode 50 to 400 A (stepless)	300 to 2 000 A (stepless)
<b>Welding time</b>	5 to 1 000 ms (stepless)	5 to 1 500 ms (stepless)
<b>Primary power</b>	400 V*, 3 phases, 50/60 Hz, 35 AT (slow blow) *alternative primary power see „Order No.“	400 V, 3 phases, 50/60 Hz, 63 AT (slow blow)
<b>Primary plug</b>	32 A (with 400 V mains)	63 A (with 400 V mains)
<b>Connected load</b>	50 kVA (with 400 V mains)	100 kVA (with 400 V mains)
<b>Cooling type</b>	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)
<b>IP Code</b>	IP 23	IP 21
<b>Dimension LxWxH (without handle)</b>	660 x 280 x 340 mm / 26" x 11" x 13.4"	650 x 560 x 1 290 mm / 25.6" x 22" x 50.8"
<b>Weight</b>	31 kg / 68.343 lbs	145 kg / 319.67 lbs (1 gun conn.) 165 kg / 363.76 lbs (4 gun conn.)
<b>Suitable guns/heads</b>	PAH-1, KAH 412, KAH 412 LA	PAH-1, KAH 412, KAH 412 LA

### Order No.

**93-60-1206** (400 V – process control)  
**93-66-1206** (480/460 V – process control)

### Order No.

**93-60-12096** (400 V – 1 gun connection)  
**93-60-42096** (400 V – 4 gun connection)

### Legend

Welding process: ARC = Drawn arc stud welding, SC = Short cycle stud welding

