

### IT 1002



### IT 2002



### IT 90



- All-rounder for construction sites and workshops (IP 23)
- Precise results through advanced inverter technology

- Energy Package for larger studs, used on construction sites and workshops










- Inverter (2000 A) with options for 4 outputs, process monitoring and shielding gas

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

M3 to M24  
#4 to 1"

M3 to M24  
#4 to 1"



<b>Welding process</b>	ARC, SC	ARC, SC	ARC, SC
<b>Welding material</b>	  	  	  
<b>Technology</b>	Inverter	Inverter	Inverter
<b>Equipment</b>			
Welding with ceramic ferrule	X	X	X
Welding with shielding gas	X	X	X
Process control	(optional)	--	X
Automation	(optional)	--	X
4 gun/head connections	--	--	(optional)
<b>Display</b>	Digital	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 1"	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	Dia. 22 / 7/8" = 6 studs/min
<b>Welding current</b>	1000 A (max.)	2000 A (max.)	2000 A (max.)
<b>Current adjustment range</b>	100 to 1000 A, electrode 50 to 400 A (stepless)	300 to 2000 A (stepless)	300 to 2000 A (stepless)
<b>Welding time</b>	5 to 1000 ms (stepless)	5 to 1500 ms (stepless)	5 to 1500 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) *alternative primary power see „Order No.“	400 V*, 3 phases, 50/60 Hz, 63 AT (slow blow) *alternative primary power see „Order No.“
<b>Primary plug</b>	32 A (with 400 V mains)	63 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)	100 kVA (with 400 V mains)
<b>Cooling type</b>	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)
<b>IP Code</b>	IP 23	IP 23	IP 21
<b>Dimension LxWxH (without handle)</b>	660 x 280 x 340 mm / 26" x 11" x 13.4"	600 x 500 x 830 mm / 23.6" x 19.7" x 32.7"	650 x 560 x 1290 mm / 25.6" x 22" x 50.8"
<b>Weight</b>	31 kg / 68.343 lbs	95 kg / 209.4 lbs	145 kg / 319.67 lbs (1 gun conn.) 165 kg / 363.76 lbs (4 gun conn.)
<b>Suitable guns</b>	A 12, A 12-FL, A 16, CA 08	A 12, A 12-FL, A 16, A 22	A 12, A 12-FL, A 16, A 22

#### Order No.

93-60-1202 (400 V)  
93-66-1202 (480/460 V)

#### Order No.

93-60-2202 (Gas, 400 V)  
93-66-2202 (Gas, 480/460 V)

#### Order No.

93-60-12096 (400 V - 1 gun connection)  
93-60-42096 (400 V - 4 gun connection)  
93-66-12096 (480/460 V - 1 gun connection)  
93-66-42096 (480/460 V - 4 gun connection)



93-40-020 (Ground cable, 5 m,  
25 mm<sup>2</sup>, 2 vice grips 10")

93-40-019 (Ground cable, 2 pcs.,  
5 m, 70 mm<sup>2</sup>, 1 vice grip 10")

93-40-019 (Ground cable, 2 pcs.,  
5 m, 70 mm<sup>2</sup>, 1 vice grip 10")

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

 Mild steel  Stainless steel  Aluminium