

STRECKER

Buttwelding machines with STRECKER dual upset method

For flashfree welds on solid wires or stranded conductors

The integrated automatic deburring cycle allows to achieve welded joints
having the same diameter as the original material

All units available with Full Parameter Control (FPC)



MS 20-FPC



MS 220-FPC



MK 300-FPC

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Welding of wires or solid conductors up to abt. 100 per cent strength of the weld

Welding of stranded conductors without tubes

Type	MS 20	MS 40	MS 80	MS 220	MS 300	MK 220	MK 300	MK 300-3P
kVA nominal	20	40	80	220	300	220	300	800
Welding range Ø [mm]								
Cu	3 - 9	5 - 13	5 - 18	8 - 25	8 - 32	10 - 30	10 - 40	15 - 48
Al	4.5 - 10	5 - 16	5 - 20	9 - 30	10 - 34	10 - 32	10 - 42	15 - 50
Brass	3 - 9	5 - 13	5 - 23	8 - 26	8 - 28	10 - 28	10 - 35	-
Welding range [mm ²]								
Cu stranded	16 - 95	16 - 120	16 - 300	50 - 500	50 - 630	50 - 800	95 - 1,200	185 - 2,000
Al stranded	16 - 95	25 - 120	25 - 300	70 - 500	95 - 630	95 - 1,000	120 - 1,200	185 - 2,000
Weight [kg]	550	1,200	1,300	1,900	2,100	2,800	3,200	4,500

Machines starting at 100 kVA nominal capacity are available with a medium frequency transformer, or with a 3phase AC transformer (3P) alternatively. This allows symmetrical load dispatching to the phases with abt. 40 per cent less supply system loading.

FPC (Full Parameter Control)

central control and administration of all welding parameters



automatic deburring

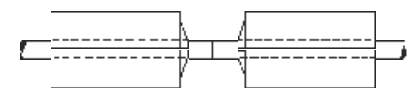
burr free welds on wires and solid conductors



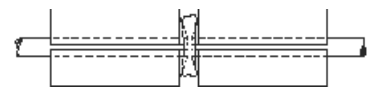
Even different cross sections and materials may be welded together.



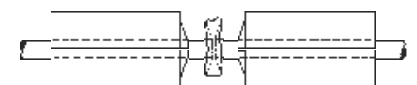
Operating diagram of a MS / MK weld



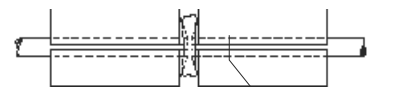
clamped wire ends before welding



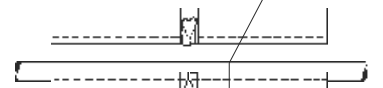
after welding and second upset cycle



position before flash removal . . .
. . . and after deburring



welded joint



flash ring is torn apart

Grain structure



a) conventional welding technique



b) dual upset method

STRECKER

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Data in this leaflet basing on experience. Only quotation is decisive.

MS - 1201e