



Inverter

- Maximum welding quality
- Maximum welding rates
- Minimum energy consumption
- Minimum weight
- Maximum efficiency

Visar 1200

Stud Welding Unit

for ARC stud welding
for Short Cycle welding according to current standards

Technical Data

Welding range	Studs dia. #4 to 5/8" (dia. 2 to 16 mm)
Welding material	Studs: Mild steel, stainless steel, aluminum
Welding rate	1/2" (M12) = 25 studs/min 5/8" (M16) = 12 studs/min
Welding current	1200 A (max.)
Current adjustment range	25 to 1200 A
Welding time	5 to 1500 ms (stepless)
Primary power	200-600 V, 3 phases, 50/60 Hz (auto detection)
Fusing	30 Amp Time Delay Fusing
Cooling type	F (temperature controlled cooling fan)
IP Code	IP 43
Dimension L x W x H	18.6" x 13.98" x 14.09" (472.5 x 355 x 358 mm) with handle
Weight	45 lbs
Order No.	93-66-0120 (Welder) 93-40-020 (Ground Cable) 88-24-466 (Toolbag)

General Information

Application

- Especially suitable for thicker sheets of about 2 mm or higher
- For welding on perforated and non-perforated sheets

Process variants

- Short cycle drawn arc welding
- Drawn arc welding

Equipment

- Welding with ceramic ferrule
- Welding with shielding gas

Advantages

Features

- **Microcontroller** – for precise process times, optimal functional reliability and maximum operating convenience
- **Function monitoring** – automatic function test following power-up; monitoring of all internal system functions



- **Display of error codes** – on digital display
- **Library function** – automatic specification of welding current and welding time through selection of stud diameter according to welding range (with and without shielded gas); fine adjustment via knobs/dials
- **Process monitoring** – recording and analysis of factors affecting the welding process; after each weld, the reference and actual values are compared; display of the welding energy input; switchable automatic welding stop if limits are exceeded
- **USB interface** – for data output

Structure

- **Extremely easy to operate**
- **Compact**
- **Mobile** – highly mobile thanks to compact dimensions and low weight (50 % weight savings versus conventional stud welding units)
- **Robust** – rugged housing with no air vents to withstand rough treatment in shop and on site

Safety

- With integrated **mains filter** (protection against voltage peaks)
- **Optimal for construction sites with large mains voltage fluctuations** – use even with critical voltage supply (- 10 % + 10 %)
- **EMC test**
- **High-voltage test with log**
- **Retriggering lock-out** – prevents welding on a welding element that has already been set
- **Thermal monitoring of transformer** – automatic shutdown in case of overheating
- **Temperature-regulated ventilator** – reduces noise and dust in the stud welding unit (greater system reliability)
- **Control unit galvanically separated from welding lines** – high degree of functional safety
- **Optimal protection against external interferences**
- **IP Code: IP 43**
- Also permits operation outdoors

Welding

- **Display** – infinitely adjustable power setting; easy monitoring of all functions via LED displays; easy operation via knobs/dials and digital display; setting of welding parameters, programs, shielding gas, automation and process monitoring possible; digital display of current, welding and gas-preflow time, separate settings for welding current and welding time
- **Powerful** – built-in power reserves
- **Trouble-free changing** of welding voltage polarity possible by reconnecting welding current and ground cables
- **Outstanding welding quality** – very high arc stability even at weak welding currents
- **High process flexibility** – high clock frequency (30 kHz) of stud welding unit allows highly dynamic regulation of welding process

Issue 2/20
(Technical data may change)