



# KÖCO-Compact Stud Welding Equipment

## ELOTOP

All models of the ELOTOP compact stud welding equipment series are laid out for top performance as well as highly cost-effective drawn-arc stud welding. Through their special features they are designed for rough wear on building sites and continuous operation.

High performance, current regulation and microprocessor control ensure optimum welding results even during mains fluctuation, variation in temperature and long cables.

Digital setting of all parameters guarantees precisely repeatable weldings.

20 storage spaces allow to file individual settings.

The intelligent self-diagnosis system increases productivity through minimizing machine downtime.



ELOTOP COMPACT STUD WELDING EQUIPMENT

# SERIES ELO TOP

| Technical data  | 502         | 810                    | 1010                  | 1710                    | 2010                   | 3010                   |
|---|-------------|------------------------|-----------------------|-------------------------|------------------------|------------------------|
| Stud welding with ceramic ferrule<br>Weldable stud range $\varnothing$ (mm) | 3 - 8       | 3 - 12                 | 3 - 14                | 3 - 20                  | 3 - 22                 | 6 - 25                 |
| Short cycle stud welding<br>Weldable stud range $\varnothing$ (mm)          | 3 - 6       | 3 - 8                  | 3 - 10                | 3 - 12                  | 3 - 12                 | 6 - 12                 |
| Stud welding with shielding gas<br>Weldable stud range $\varnothing$ (mm)   | 3 - 8       | 3 - 10                 | 3 - 12                | 3 - 16                  | 3 - 16                 | 3 - 16                 |
| Max. current (A)  | 450         | 800                    | 1100                  | 1800                    | 2300                   | 3500                   |
| Current setting range (A)   |             | 50 - 750               | 150 - 1000            | 150 - 1600              | 300 - 2000             | 300 - 2600             |
| Time setting range (ms)   | 20 - 450    | 20 - 600               | 20 - 1000             | 20 - 1500               | 20 - 1500              | 20 - 2000              |
| Gas pre-flow time (ms)  | 1000        | 100 - 2000             | 100 - 2000            | 100 - 2000              | 100 - 2000             | 100 - 2000             |
| Storage of parameters   | -           | 20                     | 20                    | 20                      | 20                     | 20                     |
| Max. stud/min. at ... $\varnothing$ (mm)                                    | 15/3<br>4/8 | 32/3<br>3/12           | 49/3<br>4/14          | 50/3<br>2/20            | 52/3<br>4/22           | 50/6<br>6/25           |
| Self-diagnosis:   |             |                        |                       |                         |                        |                        |
| overheating   | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| short circuit control   | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| mains phase failure   | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| malfunction of pilot arc  | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Menu: selection of various languages  | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Fully controlled thyristor bridge   | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Microprocessor control  | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Constant current regulation   | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Repeat cycle lock   | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Mains connection 50/60 Hz 3-phase (V)                                       | 400         | 230/400                | 230/400               | 230/400                 | 230/400                | 230/400                |
| Mains connection special voltages (V)                                       | ○           | ○                      | ○                     | ○                       | ○                      | ○                      |
| Mains plug at 400 V (A)   | 16          | 32                     | 32                    | 63                      | 63/125                 | 125                    |
| 4-wire mains cable at 400 V (m/mm <sup>2</sup> )                            | 5/2.5       | 5/4                    | 5/4                   | 5/10                    | 5/16                   | 5/16                   |
| Mains fusing time-lag at 230/400 V (A)                                      | 16          | 25                     | 35                    | 63                      | 63/80                  | 125                    |
| Mains power consumption at ...% ED (kVA)                                    | 1<br>29     | 1.4/3.2/100<br>55/38/7 | 2.5/7/100<br>73/43/12 | 2.25/9/100<br>121/59/17 | 2.5/7/100<br>156/93/25 | 8/13/100<br>187/145/52 |
| Tolerance range mains voltage (%)   | -15/+6      | -15/+6                 | -15/+6                | -15/+6                  | -15/+6                 | -15/+6                 |
| Dust and moisture protection of control unit                                | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Class of protection   | IP 23       | IP 23                  | IP 23                 | IP 23                   | IP 23                  | IP 23                  |
| Cooling   | F           | F                      | F                     | F                       | F                      | F                      |
| Steel housing, powder-coated  | ●           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Housing dimensions (L x W x H) mm<br>with castors and handle                | 375x220x360 | 555x308x535            | 555x308x535           | 700x415x660             | 805x430x730            | 950x605x860            |
| Swivel castors/fix castors  | -           | 2/2                    | 2/2                   | 2/2                     | 2/2                    | 2/2                    |
| Handle  | 1           | 2                      | 2                     | 1                       | 1                      | 1                      |
| Lifting eye   | -           | 2                      | 2                     | 2                       | 2                      | 2                      |
| Weight (abt. kg)  | 25          | 65                     | 85                    | 160                     | 190                    | 350                    |
| Shielding gas equipment   | ●           | ●                      | ●                     | ○                       | ○                      | ○                      |
| Stud counter resettable   | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Stud counter totally  | -           | ●                      | ●                     | ●                       | ●                      | ●                      |
| Interface for automatic components  | -           | ○                      | ○                     | ○                       | ○                      | ○                      |
| Stud welding guns:  |             |                        |                       |                         |                        |                        |
| SK 14   | ●           | ●                      | ○                     | ○                       | ○                      | ○                      |
| K 22  | ○           | ○                      | ●                     | ○                       | ○                      | ○                      |
| K 22-D  | -           | -                      | ○                     | ●                       | ○                      | ○                      |
| K 24  | -           | -                      | -                     | -                       | ●                      | ○                      |
| K 26  | -           | -                      | -                     | -                       | -                      | ●                      |

● = standard, ○ = optional, - = not available

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

Update 8/2015. Subject to technical modifications.