

## Stud welding guns - drawn arc stud welding



### PHM-10

Stud welding gun for short cycle stud welding (welding range: Ø 2-10 mm)  
Suitable welding units.  
LBH-710, LBH-910



### PHM-12

Stud welding gun for drawn arc stud welding (welding range: Ø 3-12 mm)  
Suitable welding units.  
LBH-410, LBH-710, LBH-910



### PHM-160

Stud welding gun for drawn arc stud welding (welding range: Ø 3-16 mm)  
Suitable welding unit.  
PRO-D 1600



### PHM-161

Stud welding gun for drawn arc stud welding (welding range: Ø 3-16 mm)  
Suitable welding unit.  
PRO-D 1600



### GD-22

Stud welding gun for drawn arc stud welding (welding range: Ø 3-22 mm)  
Suitable welding unit  
PRO-D 2200



### GD-25

Stud welding gun for drawn arc stud welding (welding range: Ø 3-25 mm)  
Suitable welding unit  
PRO-D 2800



## **PHM-10**

The compact stud welding gun PHM-10 is designed for short cycle stud welding. It guarantees optimum welding results and repeatability and is very easy to use. The PHM-10 stands out through its robust construction and high reliability. Its ergonomic design and low weight assure tireless working.



## **PHM-12**

The compact stud welding gun PHM-12 is designed for drawn arc stud welding. It guarantees optimum welding results and repeatability and is very easy to use. For flexible adjustment to different welding tasks a comprehensive range of accessories is available. The PHM-12 stands out through its robust construction and high reliability. Its ergonomic design and low weight assure tireless working.



## **PHM-160**

The compact stud welding gun PHM-160 is designed for drawn arc stud welding. It guarantees optimum welding results and repeatability and is very easy to use. For flexible adjustment to different welding tasks a comprehensive range of accessories is available. The PHM-160 stands out through its robust construction and high reliability. Its ergonomic design and low weight assure tireless working.



## **PHM-161**

The compact stud welding gun PHM-161 is designed for drawn arc stud welding. It guarantees optimum welding results and repeatability and is very easy to use. For flexible adjustment to different welding tasks a comprehensive range of accessories is available. The PHM-161 stands out through its robust construction and high reliability. Its ergonomic design and low weight assure tireless working. It is equipped as standard with an adjustable hydraulic damper to regulate the immersion speed of the stud into the welding pool.



## **GD-22**

The drawn arc stud welding gun GD 22 is designed for welding larger stud diameters  $\geq 16$  mm (max. welding diameter 22 mm). A newly developed hydraulic piston damper ensures in combination with the ample-dimensioned adjustable lift (adjustment range: 0-6 mm) optimum welding results in this diameter field. The outside welding cable (cable cross-section 95 mm<sup>2</sup>) accommodates the high welding currents that are necessary for large stud diameters. Optionally, an integrated travel monitoring system for measuring the stud travel (lift, piston runtime, immersion depth) for each weld is available.

The GD 22 convinces by easy handling, high reliability and an ergonomic design. The robust construction ensures a smooth running even under stringent conditions.



## **GD-25**

The drawn arc stud welding gun GD 25 is designed for welding larger stud diameters  $\geq 16$  mm (max. welding diameter 25 mm). A newly developed hydraulic piston damper ensures in combination with the ample-dimensioned adjustable lift (adjustment range: 0-6 mm) optimum welding results in this diameter field. The outside welding cable (cable cross-section 120 mm<sup>2</sup>) accommodates the high welding currents that are necessary for large stud diameters. Optionally, an integrated travel monitoring system for measuring the stud travel (lift, piston runtime, immersion depth) for each weld is available.

The GD 25 convinces by easy handling, high reliability and an ergonomic design. The robust construction ensures a smooth running even under stringent conditions.

# Stud welding guns for drawn arc stud welding

## - Technical data and characteristics –

	PHM-10	PHM-12	PHM-160	PHM-161	GD 22	GD 25
<b>Welding method</b>						
Drawn arc		x	x	x	x	x
Short cycle	x					
<b>Welding range (∅ mm)</b>						
Drawn arc		3-12	3-16	3-16	3-22	3-25
Short cycle	2-10					
<b>Welding material</b>						
Mild Steel	x	x	x	x	x	x
Stainless steel	x	x	x	x	x	x
<b>Lift (mm)</b>						
constant	1,5	2	2	2		
adjustable					0-6	0-6
<b>Piston damper (adjustable hydraulic)</b>				x	x	x
<b>Travel monitoring system</b>					o	o
<b>Piston guide</b>						
Slide-bearing	x	x	x	x	x	x
Linear ball track	o	o				
<b>Automatic length compensation</b>	x	x	x	x	x	x
<b>Welding cable</b>						
-cross-section (mm <sup>2</sup> )	35	35	50	50	95	120
-length (m)	5	5	5	5	2,5	2,5
<b>Control cable plug</b>	7-pin	7-pin	7-pin	7-pin	12-pin	12-pin
<b>Housing from impact resistant plastics</b>	x	x	x	x	x	x
<b>Protection of piston guidance from welding spatters</b>	x	x	x	x	x	x
<b>Dimensions</b>						
Width (mm)	40	55	67	67	67	67
Height (mm)	130	130	172	172	172	172
Length (mm)	183	173	255	255	277	277
Weight without cable (kg)	0,8	0,95	1,7	1,7	1,8	1,8

X – Standard

O – Option

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