



N 3



N 9



N 12



BUTT WELDERS FOR WIRE DRAWING MILLS

N 3, N 9, N 12 and N 22 butt welders have been particularly designed for wire drawing mills for joining steel, brass, aluminium and copper rods and are suitable for all low-cadence applications.

All models are available with annealing facility.

Jaws opening and closing is by means of foot pedals only in N 9, whilst it is operated by manual levers in N 3, N 12 and N 22.

N 3, N 9 and N 12 are standard supplied with a 4 wheel trolley for easy manoeuvrability, whilst N 22, on request, may be supplied with optional transport wheels.

Upon request all models of the N series can be supplied with a burr-removing grinding wheel. Lighted magnifying glass is additionally available for N 3 only.

- ▶ Manually operated
- ▶ Welding upset adjustment
- ▶ Welding power adjustment
- ▶ Movable jaw by bearing guides
- ▶ Graduated scale to easily adjust jaws opening (N 3, N 9 and N 12)
- ▶ Electronic control for welding parameter adjustment (N 22)

OPTIONAL

- Grinding wheel with magneto-thermal switch and blackout safety protection device (see A on next page and B)
- Four wheel trolley for N 22 (see B)
- Lighted magnifying glass for N 3 (see C)



N 22 (B)



N 3 (C)

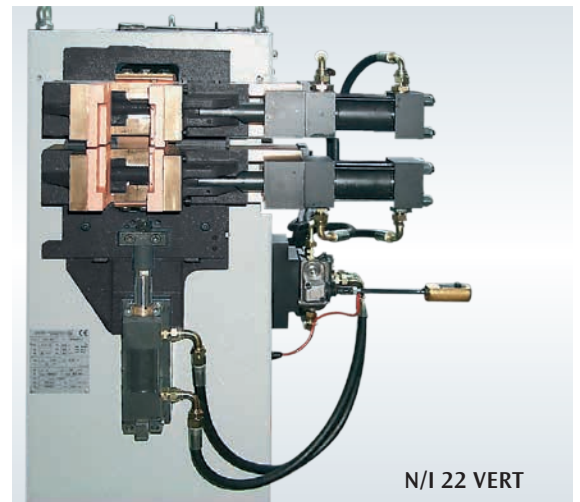


N 22

| | | | N 3 | | N 9 | | N 12 | | N 22 | |
|------|---|-----------------|-----|-----|-----|-----|------|-----|------|-----|
| | | | min | max | min | max | min | max | min | max |
| Fe | ● | ∅ mm | 0,5 | 2,5 | 0,8 | 8 | 2 | 14 | 3 | 18 |
| | ■ | mm ² | | 4,9 | | 50 | | 150 | | 250 |
| CrNi | ● | ∅ mm | 0,5 | 1,2 | 0,8 | 6 | 2 | 9 | 3 | 16 |
| | ■ | mm ² | | 1,1 | | 28 | | 65 | | 200 |
| Al | ● | ∅ mm | 0,8 | 2 | 2 | 5 | 2 | 8 | 4 | 12 |
| | ■ | mm ² | | 3,1 | | 20 | | 50 | | 110 |
| Cu | ● | ∅ mm | 0,5 | 1,8 | 1,5 | 3,5 | 2 | 6 | 4 | 8 |
| | ■ | mm ² | | 2,5 | | 10 | | 28 | | 50 |
| CuZn | ● | ∅ mm | 0,5 | 1,8 | 1,5 | 3,5 | 2 | 6 | 4 | 14 |
| | ■ | mm ² | | 2,5 | | 10 | | 28 | | 150 |

SPECIAL VERSIONS

- ▶ Vertical up wire welding (N/I 22 VERT)



N/I 22 VERT

| TECHNICAL DATA | | | N 3 | N 9 | N 12 | N 22 |
|-------------------------------------|-----------------|------|------|------|------|------|
| Single phase input 50/60 Hz | V | | 400 | 400 | 400 | 400 |
| Rated power at 50% | kVA | | 0,8 | 3 | 4 | 20 |
| Max. welding power | kVA | | 2 | 9,6 | 18 | 93 |
| Installed power | kVA | | 1 | 3 | 4 | 15 |
| Cross section connecting cables | mm ² | | 2,5 | 2,5 | 2,5 | 16 |
| Delayed fuse | A | | 10 | 10 | 10 | 40 |
| Open Circuit Voltage | V | | 2 | 2,6 | 2,4 | 4,2 |
| Short circuit current | kA | | 1,2 | 4,4 | 10 | 28 |
| Clamping force | daN | | 10 | 80 | 200 | 1000 |
| Upsetting force | daN | | 1,3 | 20 | 80 | 300 |
| Max. welding capacity on mild steel | mm ² | | 4,9 | 50 | 150 | 250 |
| Wire diameter | MIN. | mm | 0,5 | 0,8 | 2 | 3 |
| | MAX. | mm | 2,5 | 8 | 14 | 18 |
| Dimensions | | ↗ mm | 518 | 565 | 770 | 800 |
| | | → mm | 515 | 565 | 660 | 600 |
| | | ↑ mm | 1145 | 1100 | 1120 | 1550 |
| Weight | kg | | 52 | 80 | 80 | 280 |



Grinding wheel

Other voltages on request - Technical features might change without notice