IT 90

Stud Welding Unit

Ceramic/Gas/Automatic/Process Control
93-60-42099

HBS EFFICIENT TECHNOLOGY

Operating Manual

2025

After-sales service for Germany:

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Translation of the Original Operating Manual

Please keep the manual in a safe place for future reference.

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Dear Customer,

Many thanks for buying a stud welding machine from HBS Bolzenschweiss-Systeme.

We at HBS wish you success at all times when working with this stud welding machine.

The high level of quality of our products is guaranteed by ongoing further development in the design, equipment and accessories. This may result in differences between the present operating manual and your product. No claims can therefore be derived from the data, illustrations and descriptions.

We have compiled the data and information in this reference work with the greatest care, and have made every effort to ensure that the information contained in this manual was correct and up-to-date at the time of delivery. We can nevertheless give no guarantee for an absolutely error-free document.

Should you discover any errors or unclear points when reading this operating manual, please do not hesitate to contact us.

We would also be grateful for any feedback should you have any suggestions or complaints to make about our product.

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1 Important Safety Precautions

The target group for this manual are qualified personnel who in view of their technical training, know-how and experience and knowledge of applicable regulations are able to assess the work assigned to them and recognise potential hazards.

Danger from incorrect use

- Use the stud welding machine only for the purpose described in this manual.

Otherwise you may endanger yourself or damage the stud welding machine.

You endanger yourself and others if you operate the stud welding machine incorrectly or fail to observe the safety precautions and warnings. This can lead to serious injury or extensive material damage.

Danger for unauthorised operating personnel

- Work with the stud welding machine only when
  - You are appropriately trained, instructed and authorised to do so, and
  - You have read and completely understood this operating manual.
- Never work with the stud welding machine when you are under the influence of
  - Alcohol,
  - Drugs or
  - Medication.

Danger from unauthorised modifications

- Never modify the stud welding machine or parts thereof without obtaining a clearance certificate from the manufacturer.

You will otherwise endanger yourself. This can lead to serious injury or extensive material damage.

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Life-threatening danger for wearers of active implanted cardiac devices

Danger for workers at particular risk within the meaning of the EMF directive

Persons at particular risk within the meaning of the EMF directive are:

– Workers with active implanted medical devices
– Workers with passive implanted medical devices that contain metal
– Workers with medical devices worn on the body
– Pregnant workers.

◆ Never operate the stud welding machine if you are among the group of workers at particular risk within the meaning of the EMF directive.
◆ In this case, never remain in the vicinity of the stud welding machine during welding.
◆ Never operate the stud welding machine if persons are located nearby who are among the group of workers at particular risk within the meaning of the EMF directive.

Strong electromagnetic fields are produced in the vicinity of the stud welding machine during welding. These fields can adversely affect the function of medical devices as well as the course of a pregnancy.

Danger from fumes and airborne particulates

◆ Switch on the welding fume extractor at the place of work.
◆ Ensure that the room is well ventilated.
◆ Never weld in rooms with a ceiling height of less than 3 m.
◆ Observe furthermore your working instructions and the accident prevention regulations.

This will help to avoid health damage due to fumes and airborne particulates.

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Danger from glowing metal spatter (fire hazard)

Glowing hot weld spatter and liquid splashes, flashes of light and a loud bang > 90 dB (A) must be anticipated during stud welding.

- Inform colleagues working in the immediate vicinity accordingly before starting work.
- Ensure that an approved fire extinguisher is available at the workplace.
- Do not weld when wearing working clothes soiled with flammable substances such as oil, grease, petroleum, etc.
- Wear your proper protective equipment, such as:
  - Protective gloves in accordance with the relevant standard,
  - Non-flammable clothing,
  - A protective apron over your clothing,
  - Full-ear hearing protection in accordance with the relevant standard,
  - A safety helmet when welding above your head,
  - Safety shoes,
  - Safety goggles with sight glass of protection level 2 in compliance with the applicable standards and do not look directly into the electric arc.
- Remove all flammable materials and liquids from the vicinity of the work area before starting welding.
- Weld at a safe distance from flammable materials or liquids. Select a safety distance large enough to ensure that no danger can arise from weld spatter.

Protection of the stud welding unit

- Protect the stud welding machine against the ingress of foreign matter and liquids caused by cutting or grinding work in the vicinity of your work area.

This will help to prolong the service life of your stud welding machine.

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Safety notices in accordance with EMF directive 2013/35/EU

Currents flowing through electrical conductors during stud welding cause electric and magnetic fields that can occur, in particular, near the hand-held welding guns, the welding arrangement (e.g., welding cables) and the welding power sources.

Due to the high currents, high EMF exposures may occur.

Danger for workers at particular risk within the meaning of the EMF directive

Persons at particular risk within the meaning of the EMF directive are:

- Workers with active implanted medical devices
- Workers with passive implanted medical devices that contain metal
- Workers with medical devices worn on the body
- Pregnant workers.

Strong electromagnetic fields are produced in the vicinity of the stud welding machine during welding.

To reduce the danger posed by electromagnetic fields, we recommend, among other things, the following rules of conduct:

◆ Lay all cables as close together as possible.

For proper bundling and safeguarding of the cables, HBS offers protective tubes in various sizes.

◆ Do not position yourself between the welding cables.

◆ Only lay the cables to one side and position them as far as possible from the operating personnel.

◆ Do not loop the cables over your body, especially not at head level.

◆ Completely unwind the welding cables.

◆ Use the shortest possible welding cables.

◆ Place portable welding power sources as far away as possible while welding.

◆ If possible, do not operate welding power sources in the immediate vicinity of other persons, do not sit directly next to the welding power source while working and do not lean against it.

◆ In addition to these safety notices, also observe your work instructions and accident prevention regulations.

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2 Symbols and Terms Used

The symbols used in this operating manual have the following meanings:

Danger

Warns you of hazards that can lead to **injury of persons** or to **considerable material damage.**

Caution

Problems in operating **may occur** if this information **is not observed.**

No access for people with active implanted cardiac devices

No access for persons with implants made of metal

No access for pregnant women

Danger

Warns you of **electrical** hazards

Danger

Warns you of **electromagnetic fields** that can be generated during welding

These symbols prompt you to wear **personal protective equipment when working with the stud welding unit**.

This symbol prompts you to wear **ear protection**. **A loud bang > 90 dB (A) can occur during the welding process.**

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☞ **Tip**

Cross-reference to **useful information** on the use of the stud welding machine

Cross-references in this operating manual are marked with this symbol or ***are printed in italics***

Fire hazard

Have a suitable fire extinguisher for the working area ready before starting work.

◆ **Work instruction**

– **List**

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Glossary

Automatic welding head:	Device for welding of welding elements
Capacitor:	Component for storage of electrical energy.
Electric arc:	Autonomous gas discharge between two electrodes when the current is high enough. A whitish light is emitted in the process. The electric arc allows very high temperatures to be generated.
Rectifier:	Electrical component that converts alternating voltage into direct voltage
Stud feeder:	Device for automatic feeding of welding elements
Stud welding gun:	Device for welding of welding elements
Stud welding system:	Stud welding unit including stud welding gun or welding head
Stud welding unit:	Device for provision of the electrical energy for stud welding
Thyristor:	Electronic component for contact-free switching of high currents; switching takes place via the control input
Welding element:	Component such as stud or pin that is welded to the workpiece
Welding parameters:	Mechanical and electrical settings at the stud welding gun or welding head and at the stud welding unit (e.g. spring force, charging voltage)
Workpiece:	Components such as sheet metal or tubes to which the welding elements are to be fastened

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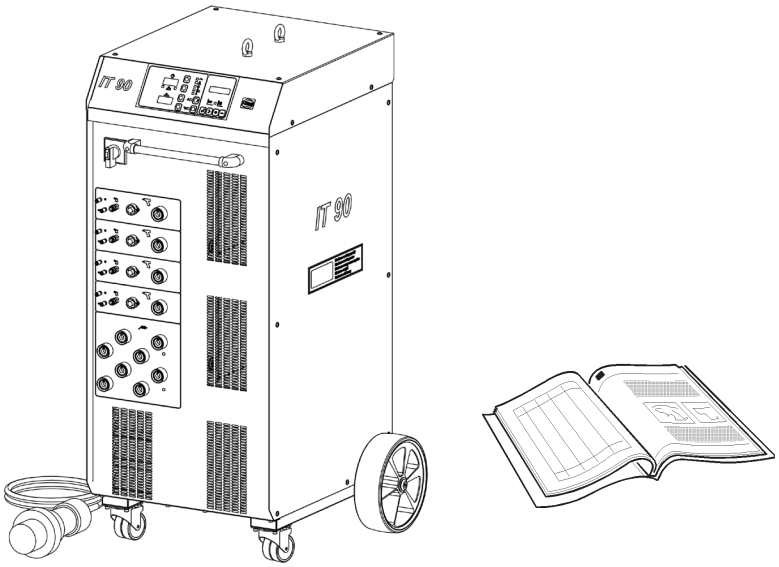
3 Scope of Supply

The **basic configuration** of your stud welding unit contains the following parts:

No. of pieces	Part	Type	Order No.
1	Stud welding unit	IT 90	93-60-42099
1	Operating manual	IT 90	E-BA 93-60-42099



During transport and set-up of the machine, safety against tilting is only guaranteed up to an angle of 30°.

A lift unit with two hooks must be used for lifting and transporting the stud welding unit.

In this way, you avoid turning out the ring screws by twisting the machine during lift and transport processes.

Lifting the stud welding unit using the handle or only one ring screw is not permitted.

- Inspect the shipment for visible damage and completeness immediately on receipt.
- Report any transport damage or missing components immediately to the delivering shipping agent or the dealer (address, see page 2).

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4 Accessories

The following ground cables are available as **accessories**:

No. of pieces	Part	Type	Order No.
1	Ground cable (2 pcs. necessary)	5 m, 95 mm²	93-40-072
1	Data cable		80-70-308

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5 Technical Data

Stud welding unit IT 90
for ARC stud welding according to current standards

Gas/Automation/Process control	Series/Series/Series
Welding range	Dia. 2 - 22 mm, M3 - M24
Welding material	Mild steel, stainless steel, aluminium
Welding rate	Dia. 22 = 6 studs/min
Welding current	2 000 A
Current adjustment range	300 - 2 000 A (stepless)
Welding time	5 - 1 500 ms (stepless)
Primary power	400 V, 3 phases, 50/60 Hz, 63 AT
Primary plug	63 A (400 V mains)
Connected load	100 kVA (400 V mains)
Cooling type	F (temperature controlled cooling fan)
IP Code	IP 21 (not allowed to use while raining)
Ambient temperature limits	0 °C to 40 °C
Dimension L x W x H	650 x 560 x 1 290 mm (without handle)
Weight	165 kg

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6 Intended Use

Our stud welding units are designed and built exclusively for industrial use. Nonindustrial use is expressly forbidden due to the lack of know-how about the welding technology employed and the applicable standards.

The stud welding unit is intended exclusively for stud welding of standardised welding elements. Any other use will result in the desired strength of the welded joint being reduced.

This stud welding unit can only be used with the HBS stud welding guns A 12, A 12-FL, A 16 and A 22, the automatic welding gun PAH-1, the welding heads KAH 412 and KAH 412 LA as well as the automatic stud feeder VBZ-3.

The intended use also implies observance of the operating manual of the component used and compliance with the intervals and conditions for inspection and maintenance of the stud welding unit and the components employed.

◆ Always check the operating manual of your stud welding gun whether it may be used with this stud welding unit.

The stud welding unit must be suitable for welding the welding elements in use.

Welding elements manufactured with the cold formed process have a flange and an ignition tip. During welding, the flange prevents the arc getting to the cylindric part of the welding element and increases simultaneously the welding area.

◆ **Please refer to the operating manual of your stud welding gun for detailed information on which welding elements may be used.**

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7 Warranty

Please refer to the latest "General Terms and Conditions" for the scope of the warranty.

The warranty does not cover faults caused by e.g.

- Normal wear,
- Improper handling,
- Failure to observe the operating manual,
- Failure to observe the safety precautions,
- Use for other than the intended purpose, or
- Transport damage.

Warranty entitlement shall no longer be valid if modifications, changes or service and repair work is carried out by unauthorised persons or without the knowledge of the manufacturer. Invalidation of warranty entitlement shall also render the declaration of conformity invalid. The CE marking shall be declared invalid by the manufacturer.

We expressly point out that only spare parts and accessories or components approved by us may be used. The same applies likewise to installed units from our sub-suppliers.

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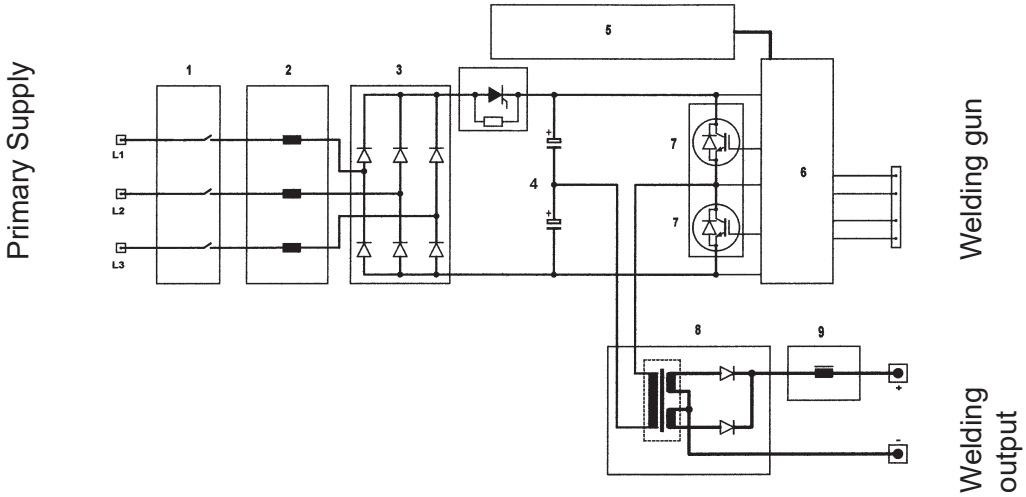
8 Components of the Stud Welding Unit

8.1 Main Assemblies



1 - Mains switch
2 - EMC-filter
3 - Bridge rectifier
4 - Electrolytic capacitors
5 - Control unit
6 - Control unit
7 - IGBT switch
8 - Middle-frequency transformer with diodes
9 - Welding current stabilizer

After passing the **mains switch (1)** and the **EMC-filter (2)**, the mains alternating current is converted in the **bridge rectifier (3)**.

The rectified voltage is smoothed by the **electrolytic capacitors (4)** and transferred to the **IGBT switches (7)**. These switches convert the direct current into a high-frequency alternating current of 30 kHz.

The energy is transferred via the middle-frequency transformer with **diodes (8)** and rectified.

The **stabilizer (9)** smoothes the current and passes it on to the welding sleeves.

Control of the **IGBT switches (7)** is carried out by the **control unit (6).**

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The **control unit (5)** synchronises the mechanical sequence (lifting the welding element) with the electronic control (ignition of pilot arc, ignition of main arc, sequence of welding time).

Welding with shielding gas/forming gas

During the welding processes, the stud welding unit automatically regulates the timing of the gas flow.

Welding time and welding current are steplessly adjustable.

Type plate

The type plate is located on the backside of the stud welding unit.

The type plate contains the following information:

- Manufacturer
- Type
- Order No./Serial No.
- Primary voltage
- Fuse
- Power consumption
- Cooling class
- IP code
- Date.

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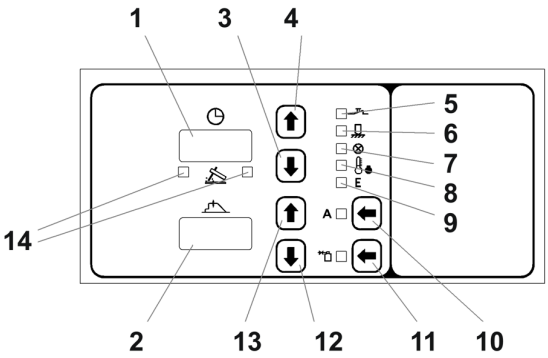
8.2 Control Panel and Display



1 - Welding time
2 - Welding current
3 - Shorter
4 - Longer
5 - Trigger
6 - Contact
7 - Locked
8 - Temperature
9 - Error (fault)
10 - Automation
11 - Shielding gas
12 - Lower
13 - Higher
14 - Active gun output

Display (LED) of **active gun output (14)**:

no LED display	=	gun output 1 is active
right LED display	=	gun output 2 is active
left LED display	=	gun output 3 is active
both LED display	=	gun output 4 is active

The condition of the welding unit is monitored after switching-on.

After self-test, the digital displays show the last set **welding time (1)** and **welding current (2)**.

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To the right of the displays (1) and (2) are light-emitting diodes (LED) with the following meanings:

	Yellow	Lights up when the welding gun button is triggered
	Yellow	Lights up when electrical contact exists between the welding element and the workpiece.
	Red	The stud welding unit is locked – After welding as long as there is electrical contact with the workpiece
	Green	The stud welding unit is ready for welding.
	Red	The stud welding unit is locked – if the stud welding unit is overheated. (8888 appears on the display and LED E lights up). After a short cooling period, the work can be continued.
E	Red	The stud welding unit is locked – if the stud welding unit is overheated – if there is a malfunction of the power element.
A	Green	Lights, automatic mode is switched on.
	Green	Lights, shielding gas is switched on.

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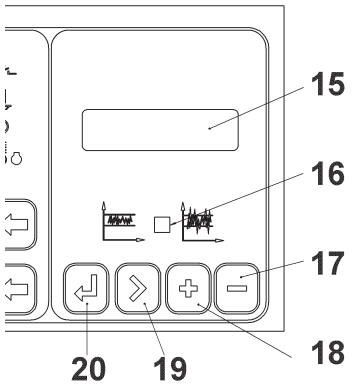
The **LCD display (15)** show the last set values::



15	- LCD Display			
16	- LED	green	=	value inside of adjusted tolerance range
		red	=	value out of adjusted tolerance range
17	- Minus key			
18	- Plus key			
19	- Arrow key			
20	- Enter key			

LCD Display

2 x 16 characters, height 5 mm

with background illumination

Tasten

↵	ENTER	Confirmation of selected function
>	ARROW	Marks the selected program item
+	PLUS	Increases the selected value
-	MINUS	Decreases the selected value

LED

If you are working with process sequence control (PAF [1]), then the LED's inform whether the output voltage value is inside the tolerance range of the reference or not.

Green	value inside of adjusted tolerance range
Red	value out of adjusted tolerance range

[1] PAF = Process Analysis Factor

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9 Welding Process

Stud welding with a drawn arc process is divided into drawn-arc stud welding with ceramic ferrule and drawn-arc stud welding with shielding gas. This stud welding unit must be used exclusively for stud welding with drawn arc.

The face of a stud-shaped welding element and the opposite surface of the workpiece are molten by an arc. Stud welding is suitable for the welding of joining elements across the entire cross-section, mainly using pin-shaped metallic welding elements with metallic workpieces.

The various processes of arc stud welding are distinguished by:

– The method of weld pool protection (shielding gas - SG, ceramic ferrule - CF or no protection - NP)
– The length of welding time (standard ARC or short-cycle drawn-arc stud welding - SC)
– The energy source (welding rectifier supplied by mains, inverter, capacitor battery).

Drawn-Arc Stud Welding

The HBS stud welding unit operates by process of ‘arc stud welding with drawn-arc ignition’ according to the current standards. The standards assign this method of joining pin-shaped elements with plane workpieces to the so called ‘Arc Pressure Welding’.

Joining is carried out in plastic or liquefied condition of the welding zone. The process can be carried out mechanically or automatically, depending on the used welding guns/welding heads.

Generally, the positive pole of the stud welding unit is connected to the workpiece. The welding element is manually or automatically inserted into the chuck of the welding gun or of the welding head. Then it is placed onto the workpiece - possibly equipped with a ceramic ferrule (see figure, **position 1**). When the button of the welding gun is triggered, the automated welding process starts, which works as follows:

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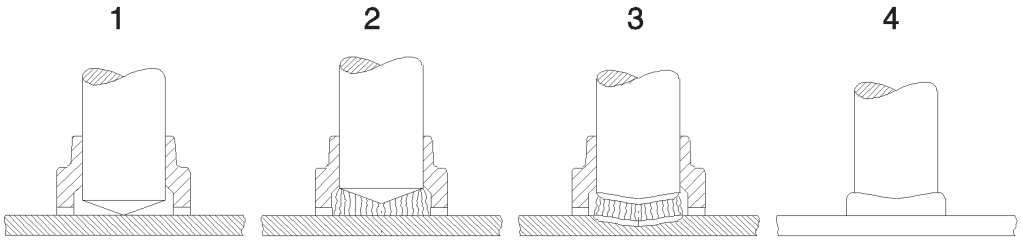

– At the beginning of the welding process, the welding element (stud) in the welding gun is lifted clear off the workpiece by a lifting device (solenoid). An initial switched current triggers a pilot arc of a low current power (see figure, **position 2**). Then the main arc ignites between the face area of the welding element and the workpiece.

– The main arc burns at the set current during the welding time preselected at the stud welding unit. The selected welding energy must match the requirements of the selected welding element. The energy of the arc melts the face of the welding element and the workpiece (see figure, **position 3**).

– At the end of the preset welding time, the stud is mechanically moved to the workpiece. On plunging into the weld pool, the two weld zones join and solidify. The contact of stud and workpiece extinguishes the arc in a short-circuit and the main current is switched off.

– The weld zone solidifies and cools down. The welding element is now welded to the workpiece over its entire cross-section of the welding element (see figure, **position 4**). As soon as the weld metal is cooled down, the welding gun can be carefully withdrawn from the welding element. When using shielding gas, the shielding gas flow is switched off with the withdrawal of the welding gun. If a ceramic ferrule is used, it can be removed by light hammer blows.

The welding range of drawn-arc stud welding is about 3 to 25 mm diameter when using mild steel/stainless steel. Welding elements with rectangular cross-section should not exceed a ratio length : width of about 5 : 1. All technical information and adjustment values are based on the use of welding elements which correspond with current standards.

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Variants of drawn-arc stud welding

Item	Drawn arc stud welding with ceramic ferrule	Drawn arc stud welding with shielding gas	Short-cycle drawn arc stud welding with shielding gas
Diameter welding element d metric in mm (imperial)	3 - 25 (#4 or 12 gage to 1“)	3 - 12 (16) (#4 or 12 gage to 1/2“ (5/8“)), by using aluminium up to 12 mm/ 1/2“)	3 - 12 (#4 or 12 gage to 1/2“), by using brass and aluminium with shielding gas
Max. current I in A	3 000	3 000	2 000
Welding time t in ms	100 - 2 000	100 - 2 000	10 - 100
Energy source	Welding rectifier, inverter	Welding rectifier, inverter	Welding rectifier, inverter
Weld pool protection	Ceramic ferrule CF	Shielding gas SG	Shielding gas SG or no protection NP
Material welding element (suitable for welding)	Mild steel, stainless steel	Mild steel, stainless steel, aluminium (up to 12 mm)	Mild steel, stainless steel, brass and aluminium with shielding gas
Workpiece surface	Metallic bright (rolling skin, rust film, welding primer)	Metallic bright (rolling skin, rust film, welding primer)	Metallic bright, galvanised (< 40 µm), slightly oiled
Min. thickness of workpiece	1/4 d min. 1 mm	1/8 d min. 1 mm	1/10 d approx. 0.7 mm
Adjustable parameters	Welding current I in A = 80 x d (up to 16 mm)	Welding current I in A = 80 x d (up to 16 mm)	Welding current I in A = 100 x d (up to 12 mm)
	Welding time t in ms = 20 x d (up to 12 mm)	Welding time t in ms = 20 x d (up to 12 mm)	Welding time
	Lift (arc length)	Lift (arc length)	Lift (arc length)
	Protrusion, immersion speed (plunge damper from 14 mm diameter)	Protrusion, immersion speed (plunge damper from 14 mm diameter)	Protrusion, immersion speed

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Drawn-Arc Stud Welding with Ceramic Ferrule

Drawn-arc stud welding with ceramic ferrule is used with welding elements of 3 to 25 mm diameter (preferably above 12 mm diameter) and with welding times of about 100 to 2 000 ms. It is generally suitable for all welding positions. When stud welding with ceramic ferrule, the welding position is PA (flat position). The major part of all applications applies to this procedure.

The ceramic ferrule (CF):

- prevents atmosphere from getting to the weld pool by a formation of metal vapor in the arc chamber
- stabilizes and concentrates the arc, thus decreasing the arc blow effect
- forms the melt under pressure to a weld collar and supports the weld pool on a vertical wall and overhead
- protects the welder from arc radiation and welding spatters

Normally, the ceramic ferrule is used for only one weld and is removed after solidification of the weld pool.

Standard welding elements and ceramic ferrules are described in EN ISO 13918. When using concrete anchors or shear connectors the front area can be plane constructed with a small pressed-in aluminium ball.

Studs with cone-shaped front area and aluminium ball are preferably used with ceramic ferrule.

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Drawn-Arc Stud Welding with Shielding Gas

Drawn-arc stud welding with shielding gas is used with welding elements for a diameter range of 3 to 12 (16) mm and with welding times from 100 to 2000 ms. Principally, it is suitable for all welding positions, however, it is preferably used in flat position PA. With stud welding with shielding gas, the weld area is protected by shielding gas. The shielding gas, which is fed from outside through a gas control and an additional device, displaces the ambient atmosphere from the welding area and reduces considerably pore formation.

	Recommendation according	Recommendation according HBS
Mild steel / stainless steel	DIN EN ISO 14175-M21: (82 % Ar / 18 % CO_2)	90 % Ar / 10 % CO_2 *) 92 % Ar / 8 % CO_2 *)
Aluminium and aluminium alloys	DIN EN ISO 14175-I1 DIN EN ISO 14175-I3	85 % Ar / 15 % He 70 % Ar / 30 % He **)

*) As a result of the higher amount of CO_2 the surface tension of the weld pool is reduced, which may lead to increased spatter formation.

**) For larger plate thicknesses the helium content may be increased.

The shielding gas influences

– the arc and the melting behavior of welding element and workpiece,

– the development of the weld collar and the penetration shape via the surface tension.

With stud welding with shielding gas, the shape of the weld collar is not reproducible, as the shielding gas has no forming effects on the melt – different from a ceramic ferrule. And so an additional ceramic ferrule may be used in special cases.

The standard welding elements for drawn-arc stud welding with shielding gas are described in EN ISO 13918. Welding elements with cone-shaped front area and without an aluminum ball are preferably used.

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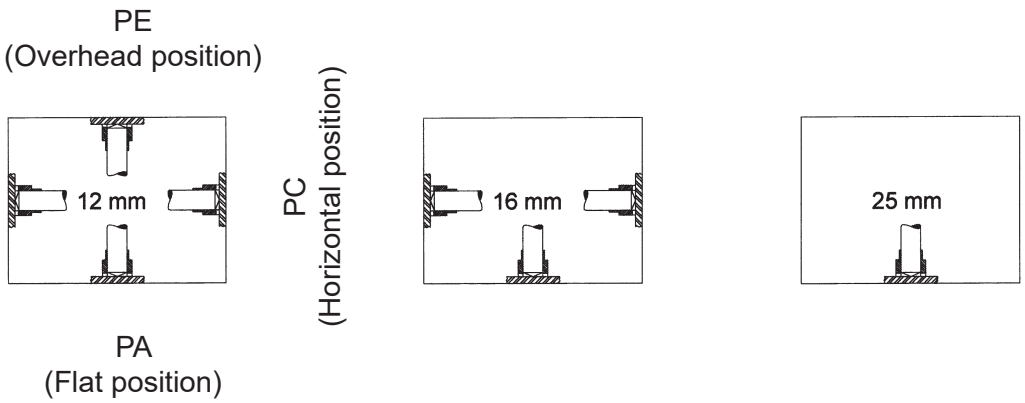
With shielding gas, you should only weld in position PA (flat position) because due to gravity, the shielding gas cannot prevent flow of the molten metal.



Short-Cycle Drawn-Arc Stud Welding with Shielding Gas

Short-cycle drawn-arc welding with shielding gas is used for welding elements within a diameter range of 3 to 12 mm (nominal diameter without flange) and welding times between 10 and 100 ms

Due to the short welding times, the energy input and the weld pool are so small that also welding elements up to 12 mm diameter can be welded on thin workpieces.

Normally, welding elements with flange (according to current standards) are used, which forms a larger welding area compared with the shaft diameter. In this way, higher tensional forces than in the stud shaft can be transmitted in spite of some pores in the weld zone. To minimize pore formation, the use of shielding gas for stud diameters upwards of 8 mm is recommended.

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10 Preparing Workplace and Welding Process

Danger from fumes and airborne particulates

- Switch on the welding fume extractor at the workplace.
- Ensure that the room is well ventilated.
- Never weld in rooms with a ceiling height of less than 3 m.
- Observe furthermore your working instructions and the accident prevention regulations.

This will help to avoid health damage due to fumes and airborne particulates.

Danger from fire and explosion

- Remove all inflammable materials and liquids from your working area.
- Ensure that there are no explosive materials in your working area.
- Ensure that an approved fire extinguisher is available at the workplace.

Danger from tripping and falling

- Lay cables and connecting leads in such a way that they are protected against damage and
- that you or third parties cannot trip over them or fall.

Warning of weld spatter

- Ensure that there is no equipment or apparatus in the working area that could be damaged by weld spatter.
- Remove if necessary.

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Warning of electromagnetic fields

- Ensure that there is no equipment or apparatus in the working area that could be damaged by magnetic fields.
- Remove if necessary.

Danger!

- Ensure that there is a free circulation of air through the housing of the stud welding unit.
- Always place the stud welding unit on a stable, level and clean surface.
- Check the condition of all cables and cable connections.
- Have defective cables or their connections immediately repaired or replaced by a qualified electrician.

10.1 Preparing Surfaces

- Remove
  - Paint, oil and other impurities,
  - Rust,
  - Non-conductive coatings (of surface-coated materials)

from the welding surface and the contact points of the ground clamps.

This ensures a high strength of the welded joints.

- **Weld the welding element only to a flat surface.**
- Ask your application consultant at HBS about welded joints on tubes and riffle plates (*see page 2*).

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10.2 Checking the Stud Welding Gun

- Always check the operating manual of your stud welding gun to see whether it may be used with this stud welding unit.

This stud welding unit can only be used with the HBS welding guns A 12, A 12-FL, A 16, A 22 and PAH-1.

- Check the chuck of your stud welding gun for proper fit and ensure it is tightened.
- Check the bellows of your stud welding gun for damage.
- Check if spring force and lift are set according to the welding parameter table in the operating manual of the stud welding gun.

- **Refer here to the operating manual of your stud welding gun.**

10.3 Checking the Stud Welding Head

- Always check the operating manual of your stud welding head to see whether it may be used with this stud welding unit.

This stud welding unit can only be used with the HBS welding heads KAH 412 und KAH 412 LA.

- Check the chuck of your stud welding head for proper fit and ensure it is tightened.
- Check the bellows of your stud welding head for damage.
- Check if spring force and lift are set according to the welding parameter table in the operating manual of the stud welding head.
- Check whether the stud welding head equipment has been selected correctly according to the welding task.

- **Refer here to the operating manual of your stud welding head.**

10.4 Checking the Automatic Stud Feeder

- Always check the operating manual of your automatic stud feeder to see whether it may be used with this stud welding unit.

This stud welding unit can only be used with the fully automatic stud feeder VBZ-3.

- **Refer here to the operating manual of your automatic stud feeder.**

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11 Connection

- **First prepare your workplace.**
- Read and observe here *point 10 "Preparing Workplace and Welding Process"*.

Electric shock hazard

- Leave the stud welding unit switched off during connection of the connecting leads.

In this way you can avoid any unintentional starting of the welding process.

- **Secure the cables.**

Strong magnetic fields are generated during the welding process that can lead to whipping of the cables. This can cause the cables to come out of the plug sockets.

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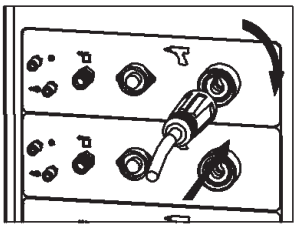
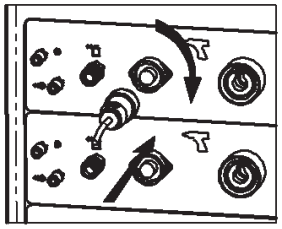
11.1 Connecting the Welding Gun to the Stud Welding Unit



Connect the welding current cable

- Only now plug the welding current cable into the corresponding socket of the stud welding unit.
- Press in the plug and turn it firmly clockwise (to the right)



Connect the control cable

- Plug the control cable in the connector of the stud welding unit.
- Twist the retaining nut of the control cable connector clockwise.

Only loosely made connections will result in damage to the plug connectors.

- Therefore always check that the plug connector is firmly inserted.

This prevents a poor contact and hence overheating of the plug connectors.

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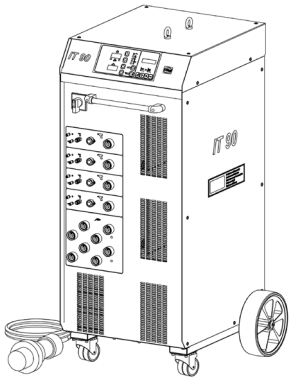
Switch-over Gun Output

Welding time and welding current of the selected gun output are displayed. The currently active gun output is displayed by the LED below the welding time display:

no LED display	=	gun output 1 is active
right LED display	=	gun output 2 is active
left LED display	=	gun output 3 is active
both LED display	=	gun output 4 is active

(see section 8.2 Keyboard and Display)



Gun output 1 is the first gun output watched from above.

The gun outputs are switched-over by triggering the welding gun button or by placing the welding gun onto the workpiece.

11.2 Connecting the Welding Head to the Stud Welding Unit

- ◆ Connect the welding current cable and the control cable.
- ◆ Proceed as described in section „*11.1 Connecting the Welding Gun to the Stud welding unit*“.

Only loosely made connections will result in damage to the plug connectors.

- ◆ Therefore always check that the plug connector is firmly inserted.

This prevents a poor contact and hence overheating of the plug connectors.

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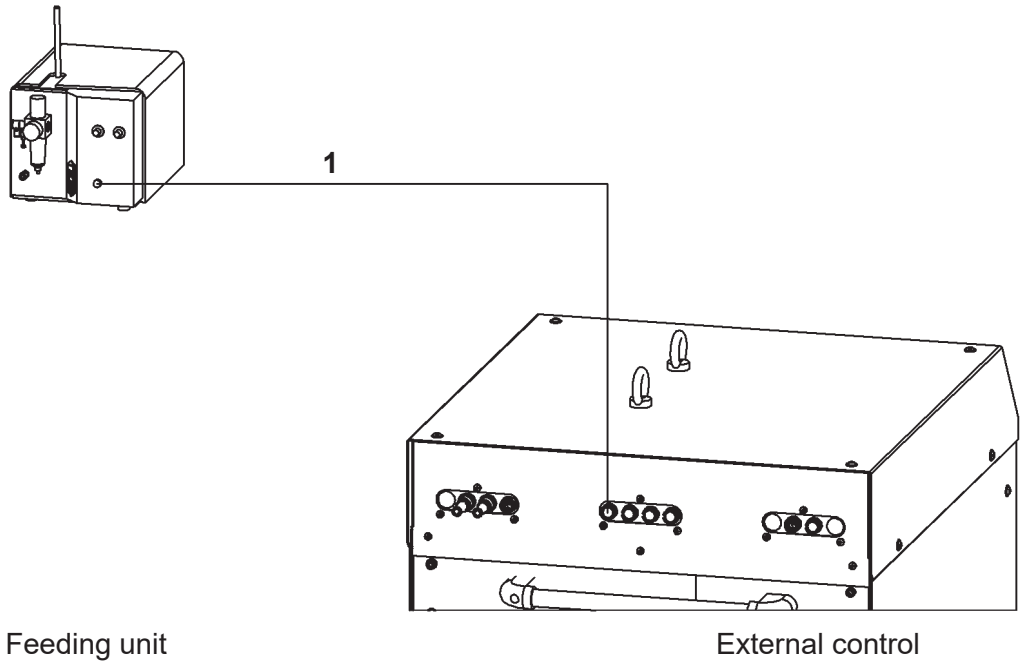
11.3 Connecting the Fully Automatic Stud Feeder to the Stud Welding Unit

◆ Connect the control socket of the feeding unit (front side) to the control socket of the stud welding unit (rear side):



1 - VBZ connection 5 poles

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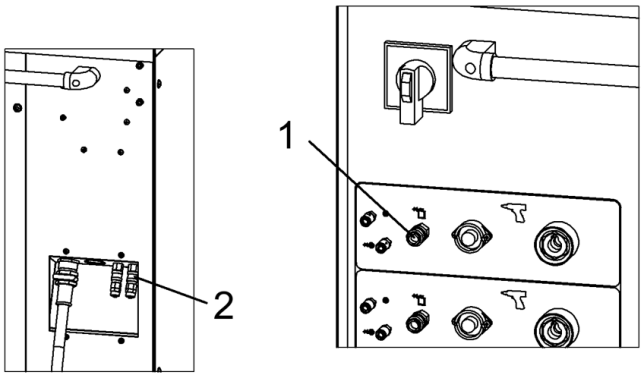
11.4 Shielding Gas Connection



1 - Gas outlet

2 - Gas inlet shielding gas bottle

- Connect the gas hose of the shielding gas bottle to the gas inlet of the stud welding unit.
- Connect the gas hose of the welding gun to the gas outlet.
- Set the flow meter of the shielding gas bottle to 8 - 16 liters/min.

Minimum flow rate for stud welding with shielded gas is 8 l/min.

For stud welding a shielding gas mixture according DIN EN ISO 14175 is used.

- Please refer to *chapter 9* for more detailed information.

- **You must not put the air hose into the gas valve of the stud welding unit!**

  The valve would be destroyed.

If the conduits are wrongly connected, feeding and welding malfunctions will occur.

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Danger from incorrect securing and handling of shielding gas cylinders

Incorrect handling and insufficient securing of shielding gas cylinders can result in severe injury!

- Follow the instructions from the gas manufacturer and given in the relevant compressed gas regulation.
- Place the shielding gas cylinder in the cylinder holder intended for this purpose.
- Secure the shielding gas cylinder properly!

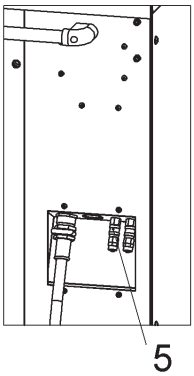
Do not secure the cylinder by its valve!

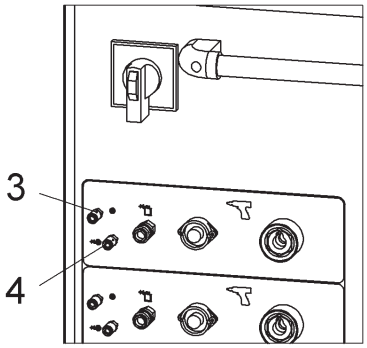
- Take measures to prevent the shielding gas cylinder from heating up.

11.5 Connecting the Compressed Air Connection for Automatic Stud Feeding

In automatic mode the welding gun PAH-1 or the welding heads KAH 412 and KAH 412 LA can be used to weld welding elements from dia 3 up to 8 mm.

You can insert the welding elements into the welding gun by hand (semiautomatic) or work with a fully automatic stud feeder.





3 - air outlet blue

4 - air outlet black

5 - connector compressed air inlet

- **You must not put the air hose into the gas valve of the stud welding unit!**

The valve would be destroyed.

If the conduits are wrongly connected, feeding and welding malfunctions will occur.

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Connecting the fully automatic stud feeder VBZ-3

- If you use the automatic stud feeder, plug the air hose into the compressed air supply (6 bar, 800 l/min) of the feeding unit VBZ-3.
- Connect the compressed air outlet of the feeding unit to the compressed air inlet of the stud welding unit.

You can set the operating pressure of max. 6 bars with the pressure reducing valve of the feeding unit. In the filter unit, the compressed air is cleaned and drained.

- **You must not put the air hose into the gas valve of the stud welding unit!**

The valve would be destroyed.

Connecting the automatic welding gun PAH-1

- Plug the air connectors of the welding gun into the air outlet bushes at the front of the stud welding unit.
- Observe the color markings:

black	=	**switched air** (during stud feeding time)
blue	=	**continuous air**, for pressing the stud into the chuck and as a stop

The stud welding unit controls the air between these two bushes.

If the conduits are wrongly connected, feeding and welding malfunctions will occur.

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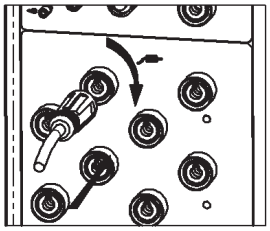
11.6 Connecting the Ground Cable



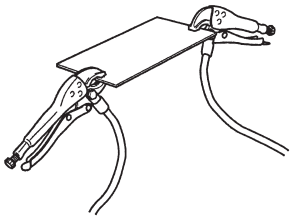
Connect the ground cable

- Plug the ground cable into the corresponding socket of the stud welding unit.
- Press in the plug and turn it firmly clockwise (to the right).

Only loosely made connections will result in damage to the plug connectors.

- Therefore always check that the plug connector is firmly inserted.

This prevents a poor contact and hence overheating of the plug connectors.



Connect the ground clamps

- Remove rust, paint and dirt from the points on the workpiece to which you wish to connect the ground clamps.
- Attach the ground clamps to the workpiece as tightly as possible.
- Pay attention to a good contact and symmetrical connection.

The welding point should be in the middle between the two ground clamps.

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11.7 Connecting the Stud Welding Unit to the Mains Supply

Electric shock hazard

- Have an electrician check whether the plug socket to which you intended to connect the stud welding unit is correctly earthed.
- Connect the stud welding unit only to a mains supply with the same mains voltage as that indicated on the type plate.
- Compare the current consumption indicated on the type plate with the fuse of your mains power supply.
- Check that the stud welding unit is switched off.
- Only now insert the plug into the plug socket.

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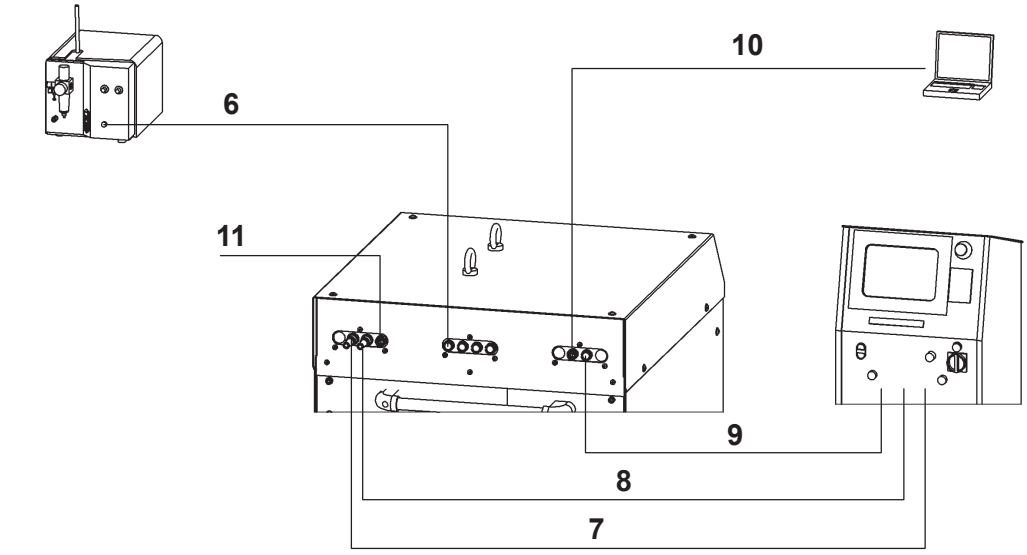
11.8 Integrate the Stud Welding Unit into a CNC System

- Connect the control socket of the feeding unit (front side) to the control socket of the stud welding unit (rear side).
- Proceed as described in section *11.3 Connecting the Fully Automatic Stud Feeder to the Stud Welding Unit*.
- Then connect the control cables 7, 8 and 9 as follows:



Feeding unit External control

6 - VBZ connection 5 poles
7 - External welding start 4 poles
8 - Contact socket 3 poles
9 - OK / Error 5 poles
10 - RS 232 interface CP 7 poles
11 - RS 232 interface PR 7 poles

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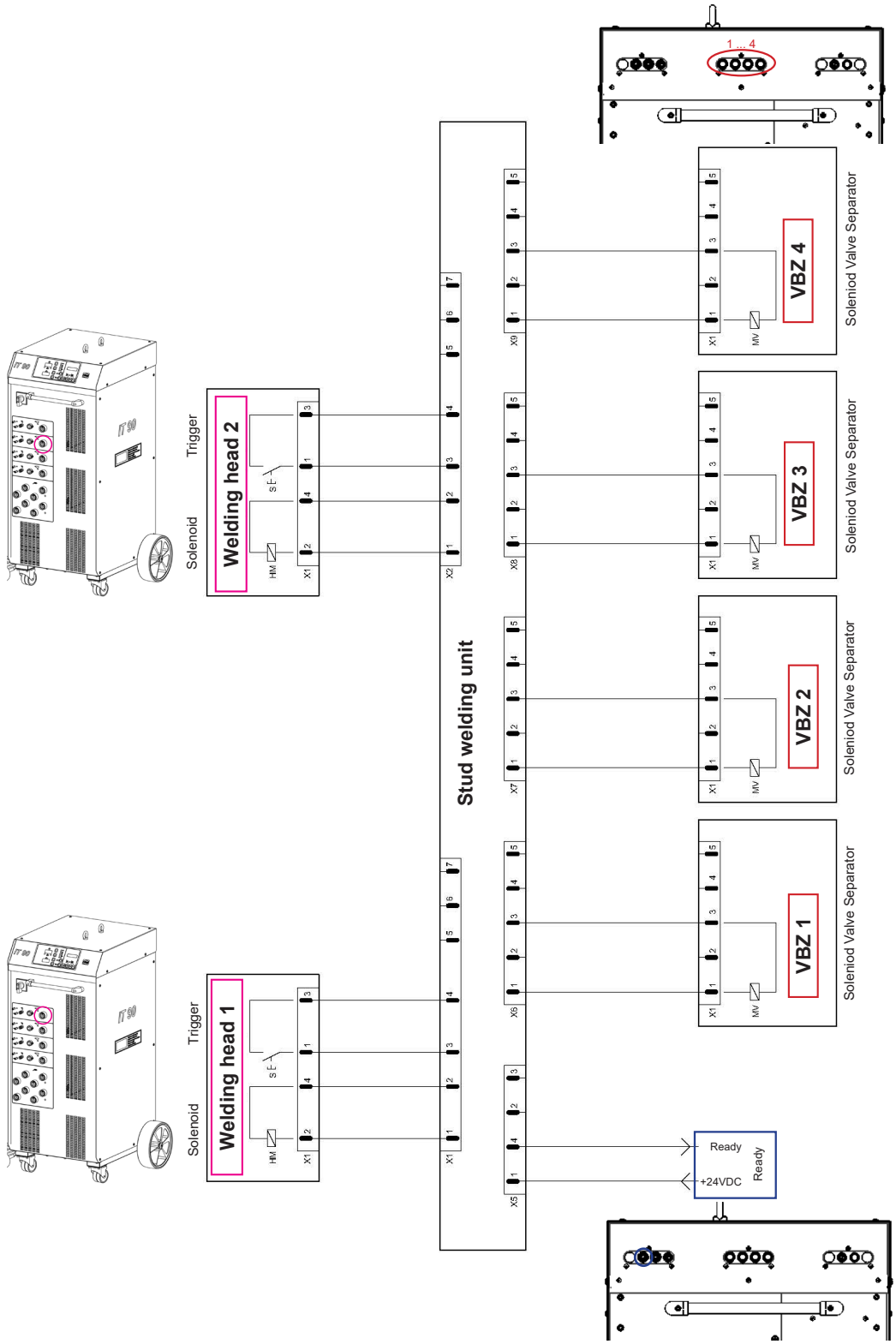
Automactic Interface IT 90



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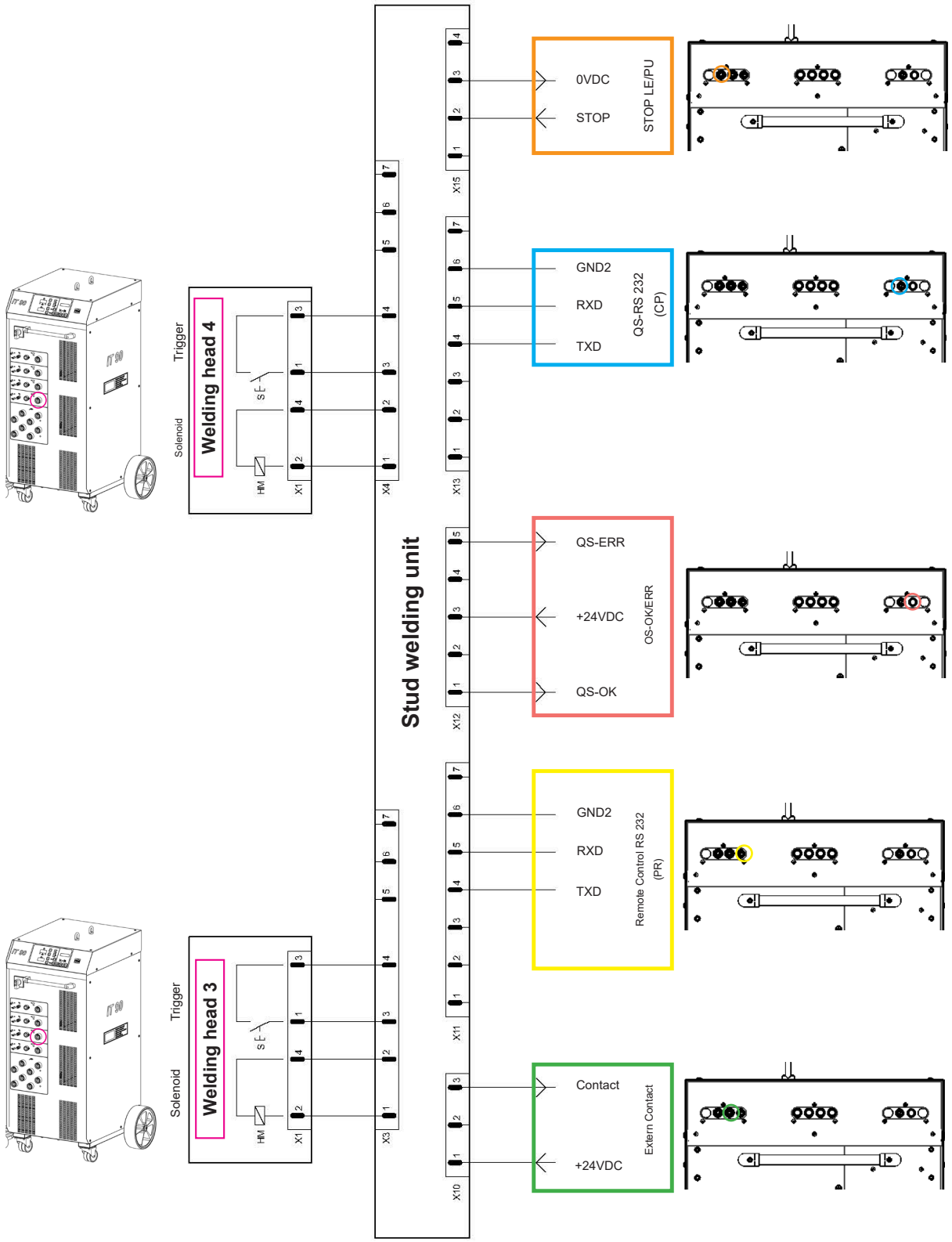

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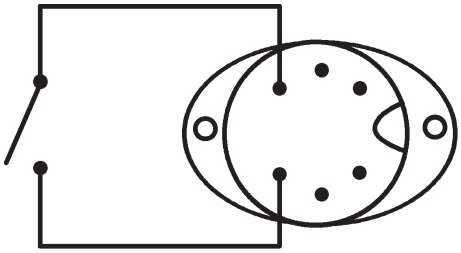
11.8.1 External Welding Start

A welding start can also be provided with the welding gun control plug at the front side of the stud welding unit (pins 3; 4).



To start welding, you must shortcircuiting pin 3 and 4 for at least 100 ms.

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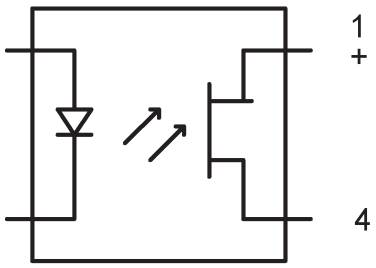
Charging Supervision (Ready)

For best control of time sequence of CNC machines, a charging supervision is provided. As soon as the stud welding unit is ready for welding, the transistor is switched on (control socket 4 poles, pins 1; 4)



1 - Input

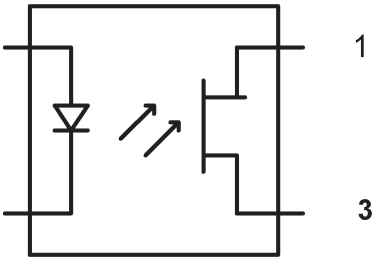
4 - Output

Operating voltage 24 V DC

Current capacity max. 50 mA

11.8.2 Contact

For best control of time sequence of CNC machines, an external contact inquiry between work piece and welding head is provided. As soon as a contact is recognized, the transistor is swiched on (control socket 3 poles, pins 1; 3).



1 - Input

3 - Output

Operating voltage 24 V DC

Current capacity max. 50 mA

◆ **Refer here to the operating manual of your welding head.**

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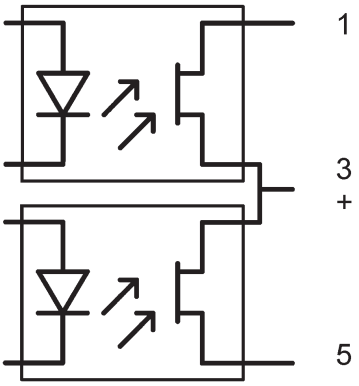
11.8.3 OK/ERR

This interface informs your control whether the welded value is inside or outside the tolerance range.



1 - Output OK

3 - Input +

5 - Output ERR

Operating voltage 24 V DC

Current capacity max. 50 mA

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12 Welding

- **First connect up the stud welding unit.**
- Read and observe here *point 11 „Connection“*.

Life-threatening danger for wearers of active implanted cardiac devices

Danger for workers at particular risk within the meaning of the EMF directive

Persons at particular risk within the meaning of the EMF directive are:

– Workers with active implanted medical devices
– Workers with passive implanted medical devices that contain metal
– Workers with medical devices worn on the body
– Pregnant workers.

- Never operate the stud welding machine if you are among the group of workers at particular risk within the meaning of the EMF directive.
- In this case, never remain in the vicinity of the stud welding machine during welding.
- Never operate the stud welding machine if persons are located nearby who are among the group of workers at particular risk within the meaning of the EMF directive.

Strong electromagnetic fields are produced in the vicinity of the stud welding machine during welding. These fields can adversely affect the function of medical devices as well as the course of a pregnancy.

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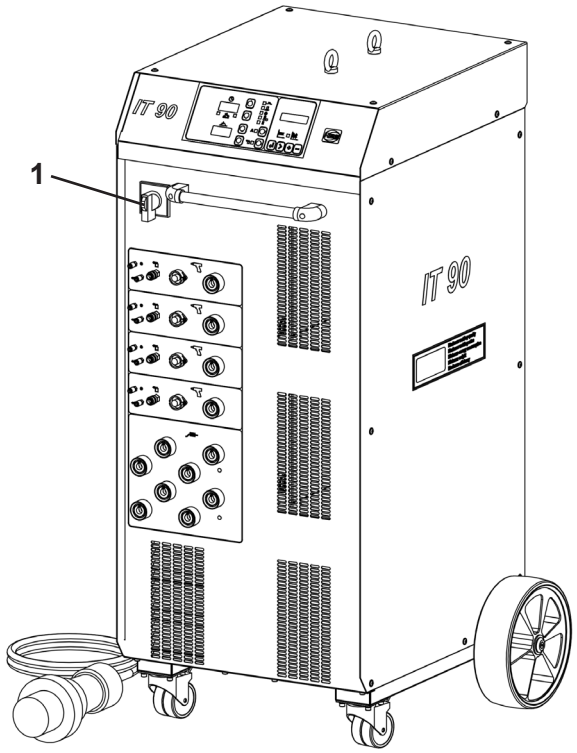
12.1 Switching on the Stud Welding Unit



1 - Mains switch

◆ Only now switch on the stud welding unit at the **mains switch (1)**.

12.2 Determining the Welding Time and the Welding Current

Determination of welding time and welding current at the stud welding unit using the arrow keys depends i.a. on

– the welding gun used,

– the material of the welding element,

– the diameter of the welding element,

– the material of the workpiece.

◆ Determine welding time and welding current to be set at the stud welding unit using the following tables.

☞ **The figures in these table are indicative values and must be checked by means of a test welding on the original material with the same properties as the original workpiece.**

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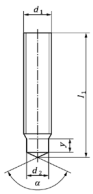
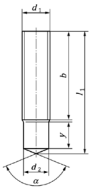
Determining the Welding Time and the Welding Current for Welding Guns A 12, A 12-FL, A 16 and A 22

for drawn-arc stud welding with ceramic ferrule

Welding elements Material: 4.8 (suitable for welding) [2]		Diameter of welding elements				Welding current [1) 2)] IT 90 I in A	Welding time [1) 2)] IT 90 t in ms
		metric		imperial (US)			
		Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]							
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	RD (MR) [3]	M6	4.7	1/4	0.185	300	150
	RD (MR) [3]	M8	6.2	5/16	0.244	450	170
	RD (MR) [3]	M10	7.9	3/8	0.311	500	250
	RD (MR) [3]	M12	9.5	1/2	0.374	550	330
	RD (MR) [3]	M16	13.2	5/8	0.520	800	550
	RD (MR) [3]	M20	16.5	3/4	0.650	1400	670
	RD (MR) [3]	M22	18	7/8	0.709	1500	840
	RD (MR) [3]	M24	20	1	0.787	1700	1000
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	FD/PD/MD (DD) [3]	M6	5.35	1/4	0.211	450	100
	FD/PD/MD (DD) [3]	M8	7.19	5/16	0.283	500	250
	FD/PD/MD (DD) [3]	M10	9.03	3/8	0.356	550	330
	FD/PD/MD (DD) [3]	M12	10.86	1/2	0.428	675	420
	FD/PD/MD (DD) [3]	M16	14.7	5/8	0.579	1200	550
	FD/PD/MD (DD) [3]	M20	18.38	3/4	0.724	1500	750
	FD/PD/MD (DD) [3]	M22	20.0	7/8	0.787	1500	840
	FD/PD/MD (DD) [3]	M24	21.8	1	0.858	1700	1000
		Ø d_1		Ø d_1			
	UD/ND [3]	3 (ISO)		#4 / 12 gage		--- [5]	--- [5]
	UD/ND [3]	4 (ISO)		#8		--- [5]	--- [5]
	UD/ND [3]	5 (ISO)		#10 / 3/16		--- [5]	--- [5]
	UD [3]	6		1/4		300	180
	UD [3]	8		5/16		500	250
	UD [3]	10		7/16		550	330
	UD [3]	12		1/2		675	420
	UD [3]	16		5/8		1200	670
	UD [3]	19		3/4		1500	840
	UD [3]	22		7/8		1700	1000
	UD [3]	25		1		1900	1400

1) to be checked by test weldings

2) When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

3) Information and recommendations on this can be found in **DIN EN ISO 14555**.

5) We recommend the “drawn arc stud welding with shielding gas” welding procedure.

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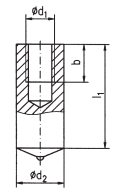
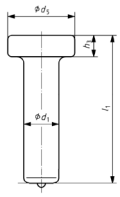
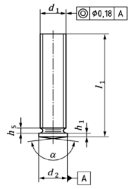
Welding elements Material: 4.8 (suitable for welding) [2]	Diameter of welding elements				Welding current [1] [2] IT 90 I in A	Welding time [1] [2] IT 90 t in ms
	metric		imperial (US)			
	Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]						
	Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	ID [3]	M6	10	1/4	0.394	550	330
	ID [3]	M8	12	5/16	0.472	675	420
	ID [3]	M10	16.2	3/8	0.638	1 200	670
	Ø d_1 - 0.4		Ø d_1 - 0.4			
	SD [3]	10		3/8		550	330
	SD [3]	13		1/2		675	420
	SD [3]	16		5/8		1 200	670
	SD [3]	19		3/4		1 500	840
	SD [3]	22		7/8		1 700	1 000
	SD [3]	25		1		1 900	1 400
	Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	PS (US, IS) [4]	M3	4	1/8	0.157	400	10
	PS (US, IS) [4]	M4	5	5/32	0.197	600	15
	PS (US, IS) [4]	M5	6	3/16	0.236	700	15
	PS (US, IS) [4]	M6	7	1/4	0.276	800	20
	PS (US, IS) [4]	M8	9	5/16	0.354	--- [5]	--- [5]
	PS (US, IS) [4]	M10	11	3/8	0.433	--- [5]	--- [5]

[1] to be checked by test weldings

[2] When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

[3] Information and recommendations on this can be found in **DIN EN ISO 14555**.

[4] Information and recommendations on this can be found in **DVS 0902**.

[5] We recommend the “drawn arc stud welding with shielding gas” welding procedure.

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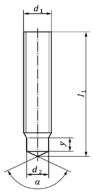
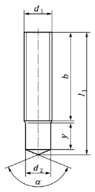
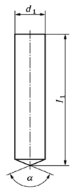
Determining the Welding Time and the Welding Current for Welding Guns A 12, A 12-FL, A 16, A 22 and PAH-1

for drawn-arc stud welding with shielding gas [5)]

Welding elements Material: 4.8 (suitable for welding) [2)]		Diameter of welding elements				Welding current [1) 2)] IT 90 I in A	Welding time [1) 2)] IT 90 t in ms
		metric		imperial (US)			
		Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2)]							
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	RD (MR) [3)]	M6	4.7	1/4	0.185	400	100
	RD (MR) [3)]	M8	6.2	5/16	0.244	525	160
	RD (MR) [3)]	M10	7.9	3/8	0.311	670	160
	RD (MR) [3)]	M12	9.5	1/2	0.374	800	210
	RD (MR) [3)]	M16	13.2	5/8	0.520	1 000	550
	RD (MR) [3)]	M20	16.5	3/4	0.650	--- [7)]	--- [7)]
	RD (MR) [3)]	M22	18	7/8	0.709	--- [7)]	--- [7)]
	RD (MR) [3)]	M24	20	1	0.787	--- [7)]	--- [7)]
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	FD/PD/MD (DD) [3)]	M6	5.35	1/4	0.211	490	120
	FD/PD/MD (DD) [3)]	M8	7.19	5/16	0.283	670	180
	FD/PD/MD (DD) [3)]	M10	9.03	3/8	0.356	840	220
	FD/PD/MD (DD) [3)]	M12	10.86	1/2	0.428	970	275
	FD/PD/MD (DD) [3)]	M16	14.7	5/8	0.579	1300	550
	FD/PD/MD (DD) [3)]	M20	18.38	3/4	0.724	--- [7)]	--- [7)]
	FD/PD/MD (DD) [3)]	M22	20.0	7/8	0.797	--- [7)]	--- [7)]
	FD/PD/MD (DD) [3)]	M24	21.8	1	0.858	--- [7)]	--- [7)]
		Ø d_1		Ø d_1			
	UD/ND [3)]	3 (ISO)		#4 / 12 gage		250	60
	UD/ND [3)]	4 (ISO)		#8		320	90
	UD/ND [3)]	5 (ISO)		#10 / 3/16		425	150
	UD[3)]	6		1/4		500	120
	UD[3)]	8		5/16		680	170
	UD[3)]	10		7/16		840	220
	UD [3)]	12		1/2		970	275
	UD [3)]	16		5/8		1 000	550
	UD [3)]	19		3/4		--- [7)]	--- [7)]
	UD [3)]	22		7/8		--- [7)]	--- [7)]
	UD [3)]	25		1		--- [7)]	--- [7)]

1) to be checked by test weldings

2) When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

3) Information and recommendations on this can be found in **DIN EN ISO 14555.**

6) Shielding gas according to DIN EN ISO 14175-M21, see *chapter 9 "Welding Process"*

7) We recommend the "drawn arc stud welding with ceramic ferrule" welding procedure.

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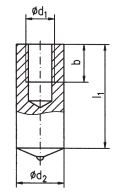
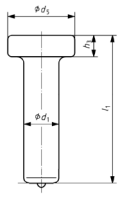
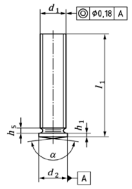
Welding elements Material: 4.8 (suitable for welding) [2]	Diameter of welding elements				Welding current [1] [2] IT 90 I in A	Welding time [1] [2] IT 90 t in ms
	metric		imperial (US)			
	Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]						
	Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	ID [3]	M6	10	1/4	0.394	840	220
	ID [3]	M8	12	5/16	0.472	970	275
	ID [3]	M10	16.2	3/8	0.638	1 000	550
	Ø d_1 - 0.4		Ø d_1 - 0.4			
	SD [3]	10		3/8		840	220
	SD [3]	13		1/2		970	275
	SD [3]	16		5/8		1 000	550
	SD [3]	19		3/4		--- [7]	--- [7]
	SD [3]	22		7/8		--- [7]	--- [7]
	SD [3]	25		1		--- [7]	--- [7]
	Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	PS (US, IS) [4]	M3	4	1/8	0.157	400	20
	PS (US, IS) [4]	M4	5	5/32	0.197	500	25
	PS (US, IS) [4]	M5	6	3/16	0.236	600	30
	PS (US, IS) [4]	M6	7	1/4	0.276	700	40
	PS (US, IS) [4]	M8	9	5/16	0.354	950	40
	PS (US, IS) [4]	M10	11	3/8	0.433	1 000	100

1) to be checked by test weldings

2) When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

3) Information and recommendations on this can be found in **DIN EN ISO 14555.**

4) Information and recommendations on this can be found in **DVS 0902**.

7) We recommend the “drawn arc stud welding with ceramic ferrule” welding procedure.

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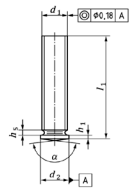
Determining the Welding Time and the Welding Current for Welding Guns A 12, A 12-FL, A 16, A 22 and PAH-1

for drawn-arc stud welding with shielding gas [8)]

Welding elements Material: AlMg3 [8)]		Diameter of welding elements				Welding current [1) 2)] IT 90 I in A	Welding time [1) 2)] IT 90 t in ms
		metric		imperial (US)			
		Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Aluminium [8)]							
		Ø d_1	Ø d_3	Ø d_1	Ø d_3		
	PS (US, IS) [4)]	M6	7	1/4	0.276	850	15
	PS (US, IS) [4)]	M8	9	5/16	0.354	900	40
	PS (US, IS) [4)]	M10	11	3/8	0.433	1 000	120

[1)] to be checked by test weldings

[4)] Information and recommendations on this can be found in **DVS 0902**.

[8)] Shielding gas according to DIN EN ISO 14175-I1/HBS recommendation, see *chapter 9 "Welding Process";* for better welding results, we recommend changing the polarity of the welding voltage by reversing the welding current and ground cables.

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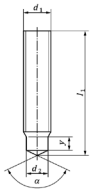
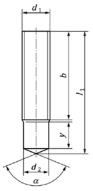
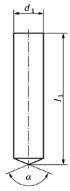
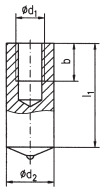
Determining the Welding Time and the Welding Current for Welding Heads KAH 412 and KAH 412 LA

for drawn-arc stud welding without weld pool protection

Welding elements Material: 4.8 (suitable for welding) [2]		Diameter of welding elements				Welding current [1] IT 90 I in A	Welding time [1] IT 90 t in ms
		metrisch		imperial (US)			
		Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]							
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	RD (MR) [3]	M6	4.7	1/4	0.185	300	150
	RD (MR) [3]	M8	6.2	5/16	0.244	450	170
	RD (MR) [3]	M10	7.9	3/8	0.311	500	250
	RD (MR) [3]	M12	9.5	1/2	0.374	550	330
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	FD/PD/MD (DD) [3]	M6	5.35	1/4	0.211	450	100
	FD/PD/MD (DD) [3]	M8	7.19	5/16	0.283	500	250
	FD/PD/MD (DD) [3]	M10	9.03	3/8	0.356	550	330
	FD/PD/MD (DD) [3]	M12	10.86	1/2	0.428	675	420
		Ø d_1		Ø d_1			
	UD/ND [3]	3 (ISO)		#4 / 12 gage		--- [5]	--- [5]
	UD/ND [3]	4 (ISO)		#8		--- [5]	--- [5]
	UD/ND [3]	5 (ISO)		#10 / 3/16		--- [5]	--- [5]
	UD [3]	6		1/4		300	180
	UD [3]	8		5/16		500	250
	UD [3]	10		7/16		550	330
	UD [3]	12		1/2		675	420
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	ID [3]	M6	10	1/4	0.394	550	330
	ID [3]	M8	12	5/16	0.472	675	420

[1] to be checked by test weldings

[2] When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

[3] Information and recommendations on this can be found in **DIN EN ISO 14555**.

[5] We recommend the “drawn arc stud welding with shielding gas” welding procedure.

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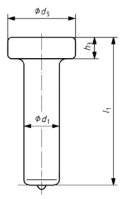
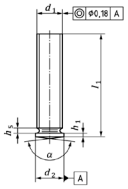
Welding elements Material: 4.8 (suitable for welding) [2]	Diameter of welding elements				Welding current [1] IT 90 I in A	Welding time [1] IT 90 t in ms
	metric		imperial (US)			
	Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]						
		Ø d_1 - 0.4		Ø d_1 - 0.4		
	SD [3]	10		3/8	550	330
		Ø d_1	Ø d_2	Ø d_1	Ø d_2	
	PS (US, IS) [4]	M3	4	1/8	0.157	400	10
	PS (US, IS) [4]	M4	5	5/32	0.197	600	15
	PS (US, IS) [4]	M5	6	3/16	0.236	700	15
	PS (US, IS) [4]	M6	7	1/4	0.276	800	20
	PS (US, IS) [4]	M8	9	5/16	0.354	--- [5]	--- [5]
	PS (US, IS) [4]	M10	11	3/8	0.433	--- [5]	--- [5]

[1] to be checked by test weldings

[2] When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

[3] Information and recommendations on this can be found in **DIN EN ISO 14555**.

[4] Information and recommendations on this can be found in **DVS 0902**.

[5] We recommend the “drawn arc stud welding with shielding gas” welding procedure.

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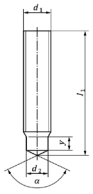
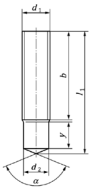
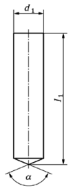
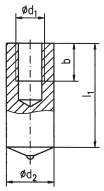
Determining the Welding Time and the Welding Current for Welding Heads KAH 412 and KAH 412 LA

for drawn-arc stud welding with shielding gas [6)]

Welding elements Material: 4.8 (suitable for welding) [2)]		Diameter of welding elements				Welding current [1)] IT 90 I in A	Welding time [1)] IT 90 t in ms
		metric		imperial (US)			
		Stud diameter in mm	eff. diameter in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2)]							
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	RD (MR) [3)]	M6	4.7	1/4	0.185	400	100
	RD (MR) [3)]	M8	6.2	5/16	0.244	525	160
	RD (MR) [3)]	M10	7.9	3/8	0.311	670	160
	RD (MR) [3)]	M12	9.5	1/2	0.374	800	210
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	FD/PD/MD (DD) [3)]	M6	5.35	1/4	0.211	490	120
	FD/PD/MD (DD) [3)]	M8	7.19	5/16	0.283	670	180
	FD/PD/MD (DD) [3)]	M10	9.03	3/8	0.356	840	220
	FD/PD/MD (DD) [3)]	M12	10.86	1/2	0.428	970	275
		Ø d_1		Ø d_1			
	UD/ND [3)]	3 (ISO)		#4 / 12 gage		250	60
	UD/ND [3)]	4 (ISO)		#8		320	90
	UD/ND [3)]	5 (ISO)		#10 / 3/16		425	150
	UD [3)]	6		1/4		500	120
	UD [3)]	8		5/16		680	170
	UD [3)]	10		7/16		840	220
	UD [3)]	12		1/2		970	275
		Ø d_1	Ø d_2	Ø d_1	Ø d_2		
	ID [3)]	M6	10	1/4	0.394	840	220
	ID [3)]	M8	12	5/16	0.472	970	275

1) to be checked by test weldings

2) When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

3) Information and recommendations on this can be found in **DIN EN ISO 14555**.

6) Shielding gas according to DIN EN ISO 14175-M21, see *chapter 9 "Welding Process"*

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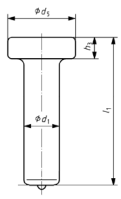
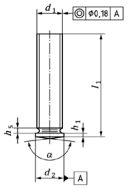
Welding elements Material: 4.8 (suitable for welding) [2]	Diameter of welding elements				Welding current [1] IT 90 I in A	Welding time [1] IT 90 t in ms
	metric		imperial (US)			
	Std diameter in mm	eff. diamete in mm	Stud diameter in inches	eff. diameter in inches		
Material of workpiece: Mild steel (suitable for welding) [2]						
		Ø d_1 - 0,4		Ø d_1 - 0,4		
	SD [3]	10		3/8	840	220
		Ø d_1	Ø d_2	Ø d_1	Ø d_2	
	PS (US, IS) [4]	M3	4	1/8	0.157	400	20
	PS (US, IS) [4]	M4	5	5/32	0.197	500	25
	PS (US, IS) [4]	M5	6	3/16	0.236	600	30
	PS (US, IS) [4]	M6	7	1/4	0.276	700	40
	PS (US, IS) [4]	M8	9	5/16	0.354	950	40
	PS (US, IS) [4]	M10	11	3/8	0.433	1 000	100

[1] to be checked by test weldings

[2] When using alloyed steels, the welding energy (welding current or welding time) must be reduced by about 10 %.

[3] Information and recommendations on this can be found in **DIN EN ISO 14555**.

[4] Information and recommendations on this can be found in **DVS 0902**.

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☞ The welding parameters necessary for **welding aluminium studs** according to DIN EN ISO 13918 are to be ascertained and checked by the user due to the material characteristics (differences in alloy composition) and the used shielding gas options.

Information and recommendations on this can be found in **DIN EN ISO 14555**.

☞ When **welding with shielding gas**, an approximately 10 % longer welding time is generally selected for the same welding current.

For alloyed steel, a 10 % lower current is generally selected.

The specified values apply for welding in welding position PA. When welding in welding position PC, the welding time must be reduced.

For short-cycle stud welding with drawn arc, the welding time is less than 100 ms. It is dependent not only on the stud diameter, but also on the available current:

(I in A = min. 100 x Ø in mm)

When welding without weld pool protection, the welding time should be selected as short as possible.

The welding energy is selected through the welding time alone.

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12.3 Checking Shielding Gas Flow Rate

Minimum flow rate for stud welding with shielding gas is approx. 8 l/min.

- Check that the stud welding unit is switched on.
- Switch on the „Shielding gas“ option on the stud welding unit.
- Actuate the welding gun button without placing the stud welding gun on the workpiece (= „air shot“).

The flow meter displays the amount of shielding gas flowing in l/min.

- Set the flow rate according to your welding task.

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12.4 Possible Settings

You can switch on the process-sequence control with the plus key [+].

Basic settings

You can set the machine according to your requirements. Call-up the main menu with the Enter key [↵].

The following menu items are available:

REFERENCE MODE	Activate process sequence control
SET DATE	Set the current date
SET TIME	Set the current time
SELECT LANGUAGE	Select a language

Basically, you select a menu item with the arrow key [>] and then you open it with the enter key [↵].

Confirmation of settings and quitting the menu item is also carried out with the enter key [↵].

12.4.1 Setting the Welding Parameters

Adjusting the Welding Time

- **First determine the necessary welding time.**
- Read and observe here Point 12.2 *„Determining the Welding Time and Welding Current“*.

- Only now set the welding time (digital display ◷) with the arrow keys.

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Adjusting the Welding Current

- **First determine the necessary welding current.**
- Read and observe here Point 12.2 *„Determining the Welding Time and Welding Current“*.

- Only now set the welding current (digital display) with the arrow keys.

Adjusting the Gas Pre-Flow Time

If working with shielding gas, you have to set the gas pre-flow time. Adjust at the display, how long the shielding gas should flow before the welding process starts. The gas flows automatically until the stud welding gun is removed from the joined welding element.

- Adjust the flow meter at the gas bottle to 8 to 16 litres/min (minimum 8 l/min.).
- Press the shielding gas key, LED shielding gas lights up.
- The display welding time ( ) shows the gas pre-flow time.
- Set the gas pre-flow time with the two arrow keys (longer – shorter).

After approx. 2 seconds, the display welding time ( ) automatically switches back to the previously set welding time.

- **If you are working with ceramic ferrules, then trigger the shielding gas key, the shielding gas LED is off. In this way, the gas valve remains closed during the welding procedure.**

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Adjusting the Stud Feeding Time (Blow Time)

In automatic mode, you can set the blow time (stud feeding time).

◆ Adjust the selected compressed air supply to 6 bars.

◆ Press the key Automation, LED Automation A lights.

The display welding time (🕒) shows the blow time.

◆ Set the blow time with the two arrow keys ⬆ ⬇.

The display welding time (🕒) automatically switches back to the last set blow time after approx. 2 s.

☞ **◆ If you do not work in automatic mode, press the key Automation, LED A extinguishes.**

The gas valve remains closed.

12.4.2 Library Mode

In the library mode, you can call up and modify charging voltages, depending on stud diameter (UD/pins).

◆ Simultaneously press both arrow keys of welding time ⬆ ⬇ for about one second.

The display welding time shows 0 - 06 (06 means the set welding current and welding time for stud diameter of 6 mm).

◆ You can pre-select the stud diameter (6 mm to 22 mm) with both arrow keys (⬆ longer – ⬇ shorter).

After about 3 seconds the display (🕒) jumps onto the pre-selected welding time and the display (⏚) onto the pre-selected welding current.

◆ In addition, you can modify the welding time and welding current individually by pressing the arrow keys (as described above).

☞ **If you are working with shielding gas, different welding parameters for stud diameters (from 6 mm to 12 mm) are available in library mode.**

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12.4.3 Adjusting the Controls

To be able to assess the process sequence during welding, an average value is calculated from the existing output voltage values. You don't need any special welding guns and/or additional welding cables for this system of function monitoring.

During welding the reference, the micro controller determines a reference output voltage value. This is the average value of eight consecutive weldings.

During standard working process, the current output voltage value is compared with the reference output voltage value. If this value is out of the set tolerance range, the system indicates a deviation which is displayed via LED's.

Green - value inside of adjusted tolerance range

Red - value out of adjusted tolerance range

If desired, the stud welding unit can be locked after a deviation was indicated.

As an option, you can manually enter an output voltage value. This value must be determined by 8 reference weldings in advance. In this way, the output voltage value can be stored for different program sequences. So you can store a special output voltage value for each stud/lot dimension and carry out a process monitoring.

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How to enable the control:

◆ Switch on the stud welding unit.

The following menu is displayed for a short time:

```
QS-FLEX
REV. 180707
```

The stud welding unit soon turns automatically to the program mode.

The following menu is displayed:

```
QS-FLEX
HEAD OFF
```

◆ Press the enter key [↵].

The following menu is displayed:

```
  SELECTION
HEAD 1 OFF
```

Use the arrow key [>] to select the right welding head.

With the keys [+] or [-] you can switch on or off the control function for the selected welding head.

◆ Press the enter key [↵]. Then toggle between the menu items *Welding* or *Input* by pressing the arrow key [>].

The following menus are displayed:

Sequence 1:

```
REFERENCE MODE
WELDING
```

Sequence 2:

```
REFERENCE MODE
INPUT
```

You determine the reference value with sequence 1, sequence 2 is manual entry. With the keys [+] or [-] you can toggle between the menu items.

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Reference Mode Welding (Sequence 1)

◆ Press the enter key ↵.

The following menu is displayed:

REFERENCE MODE TOLERANCE: 10%

◆ Here you define the tolerance range:

+ Increase tolerance range

- Decrease tolerance range

With the arrow key > you change the position

1 %	-	small tolerance range =	high sensitivity
20 %	-	large tolerance range =	low sensitivity

◆ Press the enter key ↵.

The following menus are displayed:

REFERENCE MODE STOP: OFF	or	REFERENCE MODE STOP: ON

With + or - you can toggle between the menu items.

Stop if Red >ON<	Your stud welding unit stops automatically if output voltage value is out of tolerance range. With a click on the enter key ↵, the stud welding unit is ready for welding again.
Stop if Red >OFF<	The stud welding unit continues to weld, LED's show whether welds are in or out of tolerance range.

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◆ Press the enter key ↵.

The following menu is displayed:

```
REF-K: 00.00V
REFERENCE: 8
```

The display shows the average voltage and the number of reference welds that are still possible.

◆ Now carry out the 8 reference welds.

☞ **The welded reference value is deleted if a setting at the stud welding unit is changed during sequence 1 or if the stud welding unit is switched off.**

New reference welds are required.

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Reference Mode Input (Sequence 2)

```
  PROGRAM SELECT
PRG 1:      25.00V
```

With [+] or [-] you can select the programs 1 to 8.

◆ Press the enter key [↵].

The following menu is displayed:

```
  PROGRAM 1
U-REF:      25.00V
```

With [+] or [-] you can enter the individual digits.

With the arrow key [>] you change the position.

U-REF 25.00V means that you define the set reference value 25 V for the program place 1.

◆ Press the enter key [↵].

The following menu is displayed:

```
  PROGRAM 1
TOLERANCE:     10%
```

◆ Here you define the tolerance range:

[+] increase tolerance range

[-] decrease tolerance range

With the arrow key [>] you change the position

1 %	-	small tolerance range	=	high sensitivity
20 %	-	large tolerance range	=	low sensitivity

HBS recommends a tolerance of 10 %.

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◆ Press the enter key ↵.

The following menu is displayed:

PROGRAM 1 STOP: OFF	or	PROGRAM 1 STOP: ON

With the keys + or - you can toggle between the menu items.

Stop with red >ON<	Your stud welding unit stops automatically if output voltage value is out of tolerance range. With a click on the enter key ↵ the stud welding unit is ready for welding again.
Stop with red >OFF<	The stud welding unit continues to weld, LED's show whether welds are in or out of tolerance range.

◆ Press the enter key ↵.

The following menu is displayed for appr. 3 seconds:

SELECTION HEAD 1 ON

The stud welding unit automatically switches to the program mode.

◆ Now carry out the welds.

The following menu is displayed:

REF - P1: 25.00V ACT - K1: 00.00V

REF-P1 displays the current program position and reference voltage set for it. For ACT-K1, the current head is displayed.

☞ **The settings of the stud welding unit must be checked after changes of base material, lot of welding elements or settings of the stud welding gun.**

With changed conditions, the reference value must be redetermined.

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12.4.4 Adjusting the Date

Via the serial interface of the stud welding unit, the continuously captured data can be output in ASCII format for possible recording *(see section 13.5 “Analysis of Parameters via RS 232 Interface CP“)*.

You can select the current date for your QA report in the main menu.

- To do this, press the arrow key [>] until the “Date” menu appears.

```
ADJUSTING DATE
  07.03.2012
```

- Open the “Date” menu item with the Enter key [↵].
- Use key [+] or [-] to set the individual numbers.

```
ADJUSTING DATE
  08.03.2012
```

- Press the arrow key [>] to switch between day, month and year.
- Confirm your entry with the Enter key [↵].

The set date is retained even after the stud welding unit is switched off.

Date and time are stored with the help of a battery.

- **Inform your service department** if the date and time settings are not displayed correctly after switching on.

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12.4.5 Adjusting the Time

Via the serial interface of the stud welding unit, the continuously captured data can be output in ASCII format for possible recording *(see section 13.5 “Analysis of Parameters via RS 232 Interface CP“)*.

You can select the current time for your QA report in the main menu.

- To do this, press the arrow key [>] until the “Time” menu appears.

```
ADJUSTING TIME
  15:07:30
```

- Open the “Time” menu item with the Enter key [↵].
- Use key [+] or [-] to set the individual numbers.

```
ADJUSTING TIME
  14:07:30
```

- Press the arrow key [>] to switch between hours, minutes and seconds.
- Confirm your entry with the Enter key [↵].

The set time is retained even after the stud welding unit is switched off.

Date and time are stored with the help of a battery.

STOP

- **Inform your service department** if the date and time settings are not displayed correctly after switching on.

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12.4.6 Adjusting the Language

In the main menu, you can select the “language” in which text is output on the display.

◆ To do this, press the arrow key [>] until the “Language” menu appears.

```
SELECTION LANGUAGE
  ENGLISH
```

◆ Open the “Language” menu item with the Enter key [↵].

◆ Use key [+] or [-] to select the language.

```
SET LANGUAGE
  ENGLISH
```

The following languages are available:

– German

– English

◆ Confirm your entry with the Enter key [↵].

The set language is retained even after the stud welding unit is switched off.

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12.4.7 Conversion the Current Curve

For better welding results for stud welding with ceramic ferrule, the current curve can be adjusted to the welding procedure.

A distinction is made between drawn arc stud welding with ceramic ferrule or with shielding gas.

Drawn arc stud welding with ceramic ferrule

- Use the two arrow keys (welding time display ◷: ⬆ lower – ⬇ higher) to set the time for welding the studs appropriately for your welding task.
- Then simultaneously press both arrow keys ⬆⬇ next to the welding current display (⏃) for about one second.

The current appears in the welding current display (⏃) with points:

1.9.4.0

Drawn arc stud welding with shielding gas

- Simultaneously press the two arrow keys ⬆⬇ next to the welding current display (⏃) for approx. one second.

The current appears in the welding current display (⏃) without points:

1 9 4 0

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12.4.8 Entry Library

By entering help **HELP** and pressing the key **ENTER**, the current computer command set is displayed!

By entering **T06N** and **ENTER** you can read-out the currently set welding time of a 6 stud for library mode.

By entering **I06N** and **ENTER** you can read-out the currently set welding current of a 6 stud for library mode.

If you enter **T06N=240** and press the key **ENTER** the value of 240 ms is stored as welding time for a 6 stud in library mode.

Enter command and press the key **ENTER** --> the current value is read-out.

Enter command, assign value and press the key **ENTER** --> the value is stored in the controller:

Computer command	Menu description	Meaning	
T06N	PRESET TIME 6MM-GAS	Welding time	Stud 6 mm without gas
I06N	PRESET CURR 6MM-GAS	Welding current	Stud 6 mm without gas
T08N	PRESET TIME 8MM-GAS	Welding time	Stud 8 mm without gas
I08N	PRESET CURR 8MM-GAS	Welding current	Stud 8 mm without gas
T10N	PRESET TIME 10MM-GAS	Welding time	Stud 10 mm without gas
I10N	PRESET CURR 10MM-GAS	Welding current	Stud 10 mm without gas
T12N	PRESET TIME 12MM-GAS	Welding time	Stud 12 mm without gas
I12N	PRESET CURR 12MM-GAS	Welding current	Stud 12 mm without gas
T14N	PRESET TIME 14MM-GAS	Welding time	Stud 14 mm without gas
I12N	PRESET CURR 14MM-GAS	Welding current	Stud 14 mm without gas
T16N	PRESET TIME 16MM-GAS	Welding time	Stud 16 mm without gas
I16N	PRESET CURR 16MM-GAS	Welding current	Stud 16 mm without gas
T19N	PRESET TIME 19MM-GAS	Welding time	Stud 19 mm without gas
I19N	PRESET CURR 19MM-GAS	Welding current	Stud 19 mm without gas
T22N	PRESET TIME 22MM-GAS	Welding time	Stud 22 mm without gas
I22N	PRESET CURR 22MM-GAS	Welding current	Stud 22 mm without gas
T25N	PRESET TIME 25MM-GAS	Welding time	Stud 25 mm without gas
I25N	PRESET CURR 25MM-GAS	Welding current	Stud 25 mm without gas

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Computer command	Menu description	Meaning	
T06G	PRESET TIME 6MM+GAS	Welding time	Stud 6 mm with gas
I06G	PRESET CURR 6MM+GAS	Welding current	Stud 6 mm with gas
T08G	PRESET TIME 8MM+GAS	Welding time	Stud 8 mm with gas
I08G	PRESET CURR 8MM+GAS	Welding current	Stud 8 mm with gas
T10G	PRESET TIME 10MM+GAS	Welding time	Stud 10 mm with gas
I10G	PRESET CURR 10MM+GAS	Welding current	Stud 10 mm with gas
T12G	PRESET TIME 12MM+GAS	Welding time	Stud 12 mm with gas
I12G	PRESET CURR 12MM+GAS	Welding current	Stud 12 mm with gas
T14G	PRESET TIME 14MM+GAS	Welding time	Stud 14 mm with gas
I14G	PRESET CURR 14MM+GAS	Welding current	Stud 14 mm with gas
T16G	PRESET TIME 16MM+GAS	Welding time	Stud 16 mm with gas
I16G	PRESET CURR 16MM+GAS	Welding current	Stud 16 mm with gas
T19G	PRESET TIME 19MM+GAS	Welding time	Stud 19 mm with gas
I19G	PRESET CURR 19MM+GAS	Welding current	Stud 19 mm with gas
T22G	PRESET TIME 22MM+GAS	Welding time	Stud 22 mm with gas
I22G	PRESET CURR 22MM+GAS	Welding current	Stud 22 mm with gas
T25G	PRESET TIME 25MM+GAS	Welding time	Stud 25 mm with gas
I25G	PRESET CURR 25MM+GAS	Welding current	Stud 25 mm with gas
LOCK	LOCK KEYPAD	Key lock of stud welding unit	

If LOCK=1 **the stud welding unit can only be operated via the serial interface. The command** LOCK=0 **cancels the key lock.**

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12.4.9 Remote Control

Computer command	Menu description		Meaning
DISP	DISPLAY ACTUAL VALUES		Current display values
HEAD	SWITCH PARAMETER		Head switch-over
HEAD=1			Head I
HEAD=2			Head II
HEAD=3			Head III
HEAD=4			Head IV
PCNT	PART COUNTER		Stud counter cannot be reset
WTIM	PULSE WELDING TIME		Welding time
WCUR	PULSE WELDING CURRENT		Welding current
TGAS	GAS TIME		Gas pre-flow time
TAUT	AUTOMATIC TIME		Blow time
AUTO	AUTOMATIC	ON/OFF	Blow time ON/OFF 1/0
OGAS	GAS	ON/OFF	Gas pre-flow time ON/OFF 1/0
KOBO	KOPFBOLZENMODE	ON/OFF	Head stud mode ON/OFF 1/0

Enter command and press the key **ENTER** **WCUR**
--> the current value is read-out

Enter command, assign value and press the key **ENTER** **WCUR=800**
--> the value is stored in the controller

This value relates to the individually adjusted head or gun output.

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12.5 Performing the Welding Process

- **First set the necessary welding parameters.**
- Read and observe here point *12.4.1 „Setting the Welding Parameters“*.

Electric shock and electric arc hazard

- Never touch the welding elements, chuck, retaining nut or electrically conductive parts in their vicinity during the welding process.

These parts are live.

- Never wear metal jewellery, even a wristwatch, on your body during the welding process.

This will help to avoid injuries and damage due to electric power or electromagnetic fields.

Electric shock and electric arc hazard

- Stand on an insulated mat if you have to weld under the following conditions:

– In confined spaces with electrically conductive walls
– Under cramped conditions between or against electrically conductive parts
– Where there is limited mobility on electrically conductive parts
– In damp, wet or hot rooms.

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Danger of deflagration of explosive gases and substances

- Never weld in rooms with an explosion hazard.
- Never weld on vessels containing or that have contained substances
  - which are inflammable or promote combustion,
  - which may create health-endangering gases, fumes or airborne particulates,
  - or which could cause explosions.

Such work may only be carried out by welding specialists.

- Do not carry out such work if you have not been specially trained for it.

Risk of fire and burns due to glowing weld spatter

- Wear your personal protective equipment and
- your safety goggles with sight glass of protection class 2.
- Wear a protective helmet when welding over head.
- Remove all inflammable materials and liquids from the vicinity of the place of work before starting welding.
- Ensure that an approved fire extinguisher is available at the place of work.
- Observe furthermore your working instructions and the accident prevention regulations.

Glowing hot weld and liquid spatter occur during welding.

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Danger due to noise

- Wear your ear protection during welding.
- Observe furthermore your working instructions and the accident preventi-on regulations.
- Inform colleagues working in the immediate vicinity accordingly before starting work.

A > 90 dB (A) bang can occur during the welding process.

- Ensure that the welding gun has been prepared in accordance with the corresponding operating manual.

- Check whether a welding element has been inserted into the welding gun.
- Insert a welding element, if necessary.
- Place the welding gun perpendicularly onto the workpiece as soon as the stud welding unit is ready for the welding process.
- Press the welding gun firmly with both hands against the workpiece until the wel-ding gun attachment (spacer) is resting uniformly on the workpiece.
- Hold the welding gun firmly, steady and straight.
- Ensure that you do not touch any metal parts of the welding gun.
- Only now should you press the button of the welding gun.

The welding process is started.

- **Always pull the welding gun perpendicularly away from the welding element after the welding process**.

If you pull the welding gun away at an angle, you will strain the chuck and shorten its service life.

Risk of burns

The gun head becomes very hot during the welding process. The same applies to the welded element and the workpiece.

- Wear your personal protective equipment.

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☞

- **Use only welding elements of one batch.**
- Pay strict attention not to mix welding elements from different batches.
- Carry out test welds again after a batch change.

Even the slightest changes to the geometry, in particular to the tip of the welding elements require different settings for the welding process.

☞

- Now check the quality of the welded joint before inserting a new welding element and repeating the welding process.
- Work in accordance with the following *point 13*.

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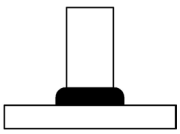
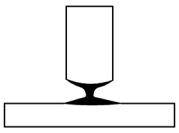
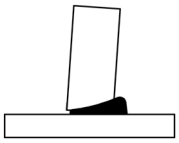
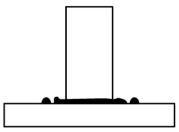
13 Checking the Quality of the Weld

You can check the quality of the weld by means of a visual inspection and a bending test.

The number and type or method of the tests to be performed and the acceptance criteria are defined in respective standards for quality demands.

13.1 Carrying out Visual Inspection

◆ Carry out a visual inspection on all welding elements.

Visual Inspection			
Condition		Possible cause	Corrective actions
	Collar regular, bright and complete. Lengths after weld within tolerances	Correct parameters	none
	Contraction of weld collar Welding element too long	Plunging depth or lift too low Weld power too high Ceramic ring not centered correctly Plunge rate too high	Increase plunging depth, check lift and centering of the ceramic ring Reduce current and/or time Check centering Adjust plunge and/or gun dumper
	Weakly developed, uneven weld collar with mat surface Welding element too long	Weld power too low Ceramic ferrule is moist Lift too low	Increase current and/or time Dry out ferrules in oven Increase lift
	Collar off centre Undercut	Effect of arc blow Ceramic ferrule incorrectly centred	See arc blow effect Check centring
	Weld collar low, shiny surface with many spatters Welding element too short	Weld energy too high Plunging speed too high	Decrease current and/or time Adjust plunging depth and/or damping factor

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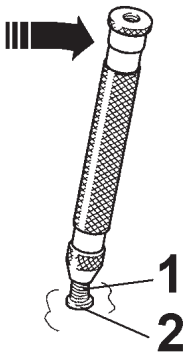
13.2 Carrying out Bending Test

You can purchase from HBS a bending device with inserts for various diameters of the welding elements.

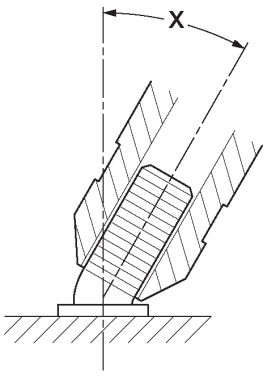
The bending test serves as an easy work sample and as a check for the selected welding parameters. The welded joint is stressed by bending in a non-defined way.



1 - Welding element

2 - Welded joint

◆ Place the bending device on the **welding element (1)** and



◆ bend the **welding element (1)** with the bending device once by 60° in any direction.

The bending test is passed if a crack or a fracture of the welded zone does not occur.

☞

◆ **Further tests should be conducted if the connection fails in the weld area.**

◆ In this case, **bend** the welding element exactly in the opposite direction by 60° towards the failing seam.

For a **non-destructive strength test** of the welding elements HBS offers a **torque bending test device** in accordance with DIN EN ISO 14555 (Order No. 92-40-135A).

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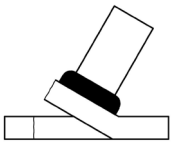
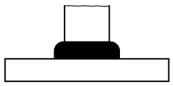
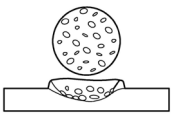
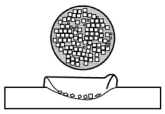
☞

◆ You don’t need to test all studs.

It is sufficient to carry out stud tests on several production samples that are picked at random.

Bending Test			
Type of fracture		Possible cause	Corrective actions
	Tearing of parent material	Correct parameters	none
	Fracture above collar after sufficient deformation	Correct parameters	none
	Fracture within the weld. High porosity	Weld energy too low Unclean surface Material not suitable for stud welding	Increase current and/or welding time Clean the surface Select suitable material
	Fracture of weld Bright appearance	Welding time too low.	Increase welding time

If the strength of the joint is inadequate, then:

◆ check the setting of the stud welding unit.

◆ check whether the surface of welding element and base material are clean and electrically conductive.

They must be free from scale, oil, paint, oxide layers.

◆ Grind off hardened workpiece surfaces (e.g. roll hardening).

◆ Check the piston of the welding gun for ease of movement.

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13.3 Optimisation of Welding Parameters

- **As first step, conduct the tests outlined under points 13.1 and 13.2.**
- As second step optimise the welding parameters according to the table under *point 12.2 „Determining the Welding Time and Welding Current“*.

- Optimise the welding parameters of the stud welding unit.
- Check the settings of the welding gun.
- If necessary re-adjust the lift and spring pressure.

- **Refer here to the operating manual of your welding gun.**

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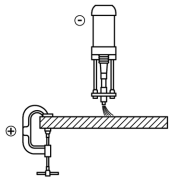
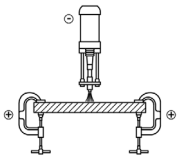
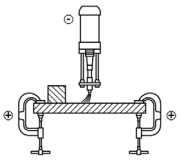
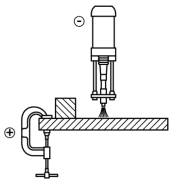
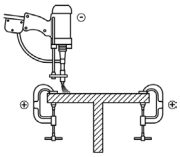
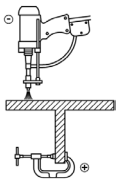
13.4 Blowing Effect and Remedies

With asymmetric ground connections, different material distributions or when welding at the edge of a workpiece a "blowing effect" can occur. This is an undesirable deflection of the electric arc. This results in uneven melting of the stud material, in increased poring and undercuts in the welding area.

The blowing effect is proportional to the current amperage and can be influenced by symmetrical connection of the ground terminals, by connecting compensating grounds or (on welding guns with external welding cable) by turning the welding gun about its vertical axis.

Blowing effect	
Cause	Remedy
	
	
	

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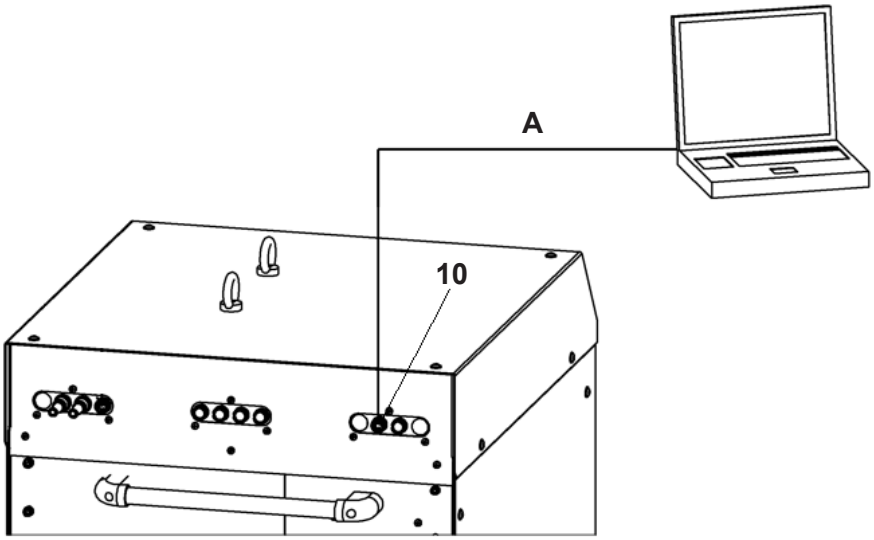
13.5 Analysis of Parameters via RS 232 Interface CP

Via the serial interface of the stud welding unit, the actually recorded data can be output for a potential storage in ASCII format.

A data cable is required which can be ordered as a consumable at HBS (order no. 80-70-308).



10 - RS 232 interface CP 7poles

A - Data cable, order no. 80-70-308

This data collection can be evaluated by a terminal program (e.g. Hyper Terminal).

Connection settings of the serial interface at a PC or notebook:

Bits per second:	115 200
Data bits:	8
Parity:	None
Stop bits:	1

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Transmission of Recognized Data With Microsoft® HyperTerminal

Microsoft® HyperTerminal is a tool to transfer performance data directly onto your PC or notebook. The program is automatically integrated into Microsoft Office until version 2007.

For later versions of Microsoft Office, such as Office 2010, the program HyperTerminal can be downloaded free of charge for your personal use.

- ◆ Switch on the controlling function of the output voltage.
- ◆ Proceed as described in section *„12.4.3 Adjusting the Controls“*.

Any data can individually be processed in the window Microsoft® Hyper Terminal.

- ◆ Link the data cable (HBS Order no. 80-70-308) to the serial sleeve of the stud welding unit and to the serial sleeve (com1 or com2) of a PC/notebook.

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◆ Now call up the Hyper terminal:

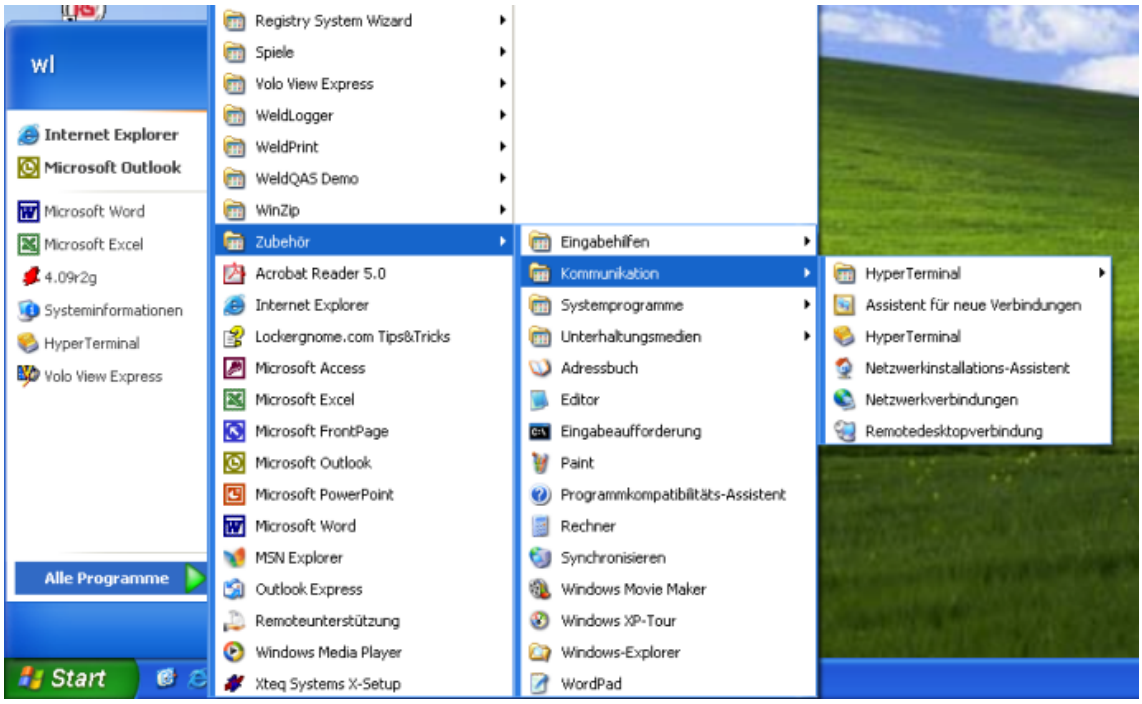
↳ Start

↳ Programs

↳ Accessory

↳ Communication

↳ Hyper Terminal



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- Name the connection (e.g. the company name or a date - however without dots).
- Select any icon.
- Confirm with OK.

- Define the interface (com1 or com2 at the PC).
- Confirm with OK.

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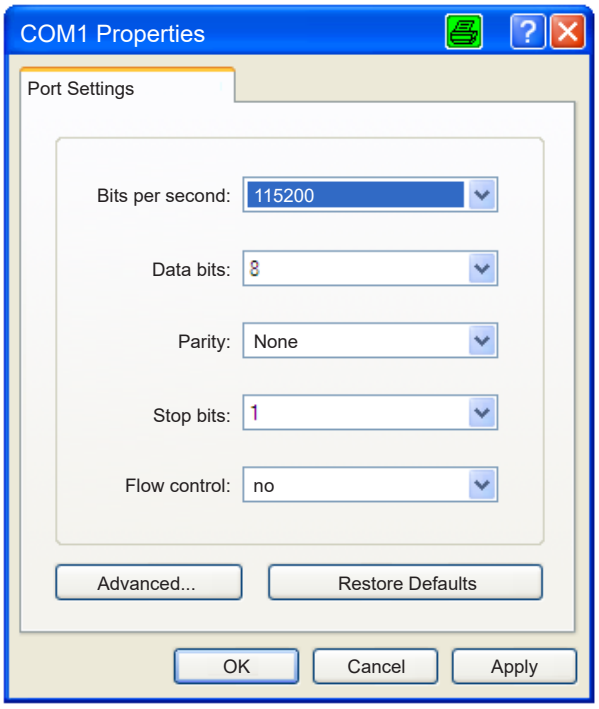

◆ Define the connection settings:

Transmission rate: (Bits per second)

– CDMi and IT stud welding units 115200

– CDM stud welding units 19200

◆ Confirm with OK.

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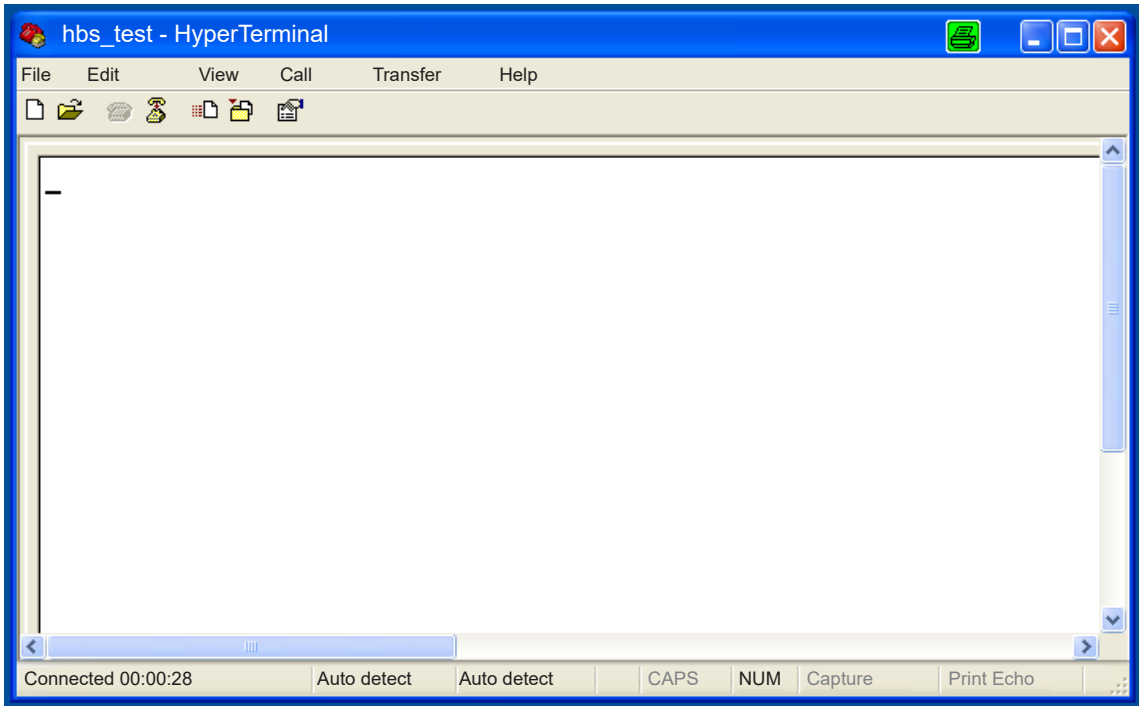
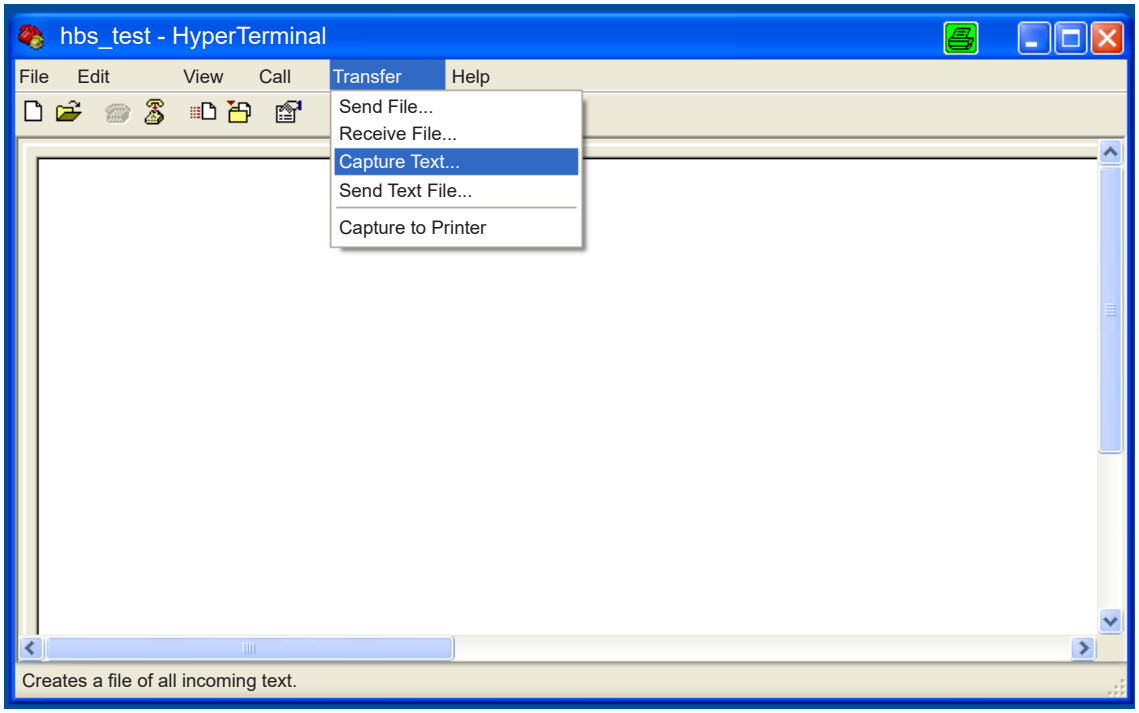


◆ Do not forget to save data.



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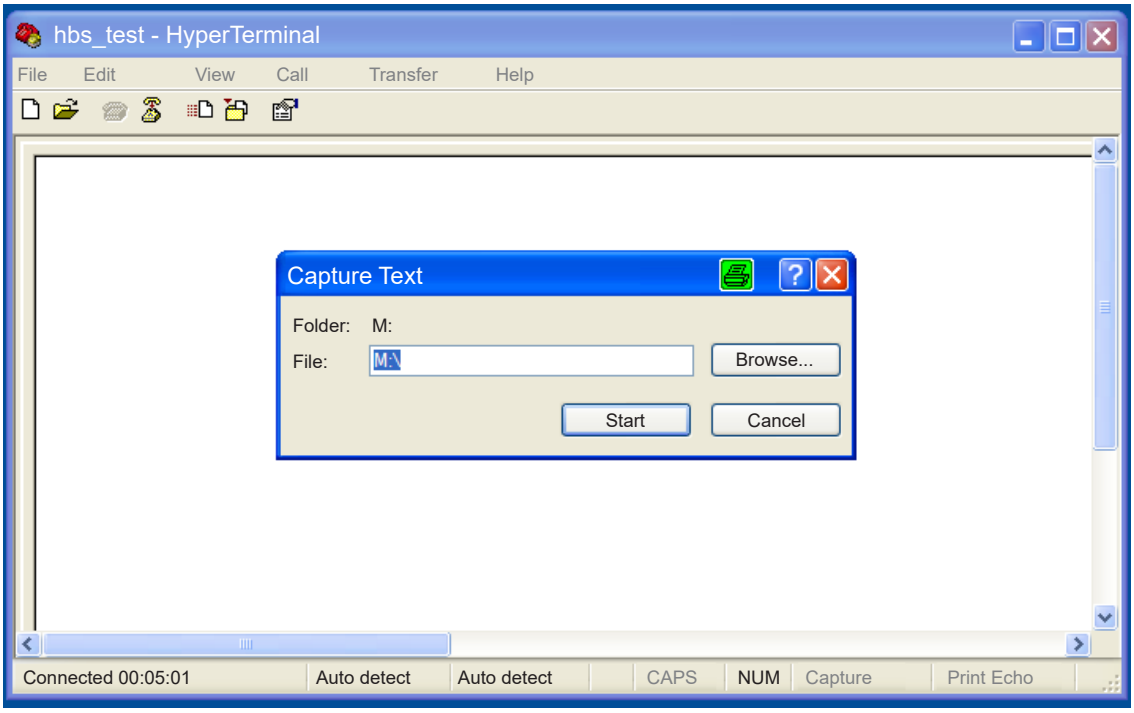

- Give a file name.
- Confirm with start.

Example for data output at serial output (e. g. Microsoft® Hyper Terminal):

Head	Counter	Date	Time	Mode	Curr. Nom	Time Nom	Gas time	R/M	Nom. Volt.	Stop	Toleran-ce	Act. Curr.	Act. Volt.	Act. Time	Energy	OK/ERR
KO:1	14776	26.08.2008	10:00:25	REF8	950A	15ms	900ms	R	32.82V	OFF	15%	943A	32.82V	15ms	464Ws	
KO:1	14777	26.08.2008	10:00:39	REF7	950A	15ms	900ms	R	31.69V	OFF	15%	942A	31.69V	15ms	447Ws	
KO:1	14778	26.08.2008	10:00:50	REF6	950A	15ms	900ms	R	33.34V	OFF	15%	942A	33.34V	15ms	470Ws	
KO:1	14779	26.08.2008	10:01:01	REF5	950A	15ms	900ms	R	32.20V	OFF	15%	940A	32.20V	15ms	454Ws	
KO:1	14780	26.08.2008	10:01:19	REF4	950A	15ms	900ms	R	32.82V	OFF	15%	943A	32.82V	15ms	464Ws	
KO:1	14781	26.08.2008	10:01:31	REF3	950A	15ms	900ms	R	33.22V	OFF	15%	943A	33.22V	15ms	469Ws	
KO:1	14782	26.08.2008	10:02:03	REF2	950A	15ms	900ms	R	31.75V	OFF	15%	940A	31.75V	15ms	447Ws	
KO:1	14783	26.08.2008	10:02:50	REF1	950A	15ms	900ms	R	32.39V	OFF	15%	942A	32.39V	15ms	457Ws	
KO:1	14784	26.08.2008	10:03:00		950A	15ms	900ms	R	32.53V	OFF	15%	940A	31.36V	14ms	412Ws	OK
KO:1	14785	26.08.2008	10:03:18		950A	15ms	900ms	R	32.53V	OFF	15%	943A	32.54V	14ms	429Ws	OK
KO:1	14786	26.08.2008	10:03:28		950A	15ms	900ms	R	32.53V	OFF	15%	944A	33.08V	14ms	437Ws	OK
KO:1	14787	26.08.2008	10:03:38		950A	15ms	900ms	R	32.53V	OFF	15%	945A	32.44V	15ms	429Ws	OK

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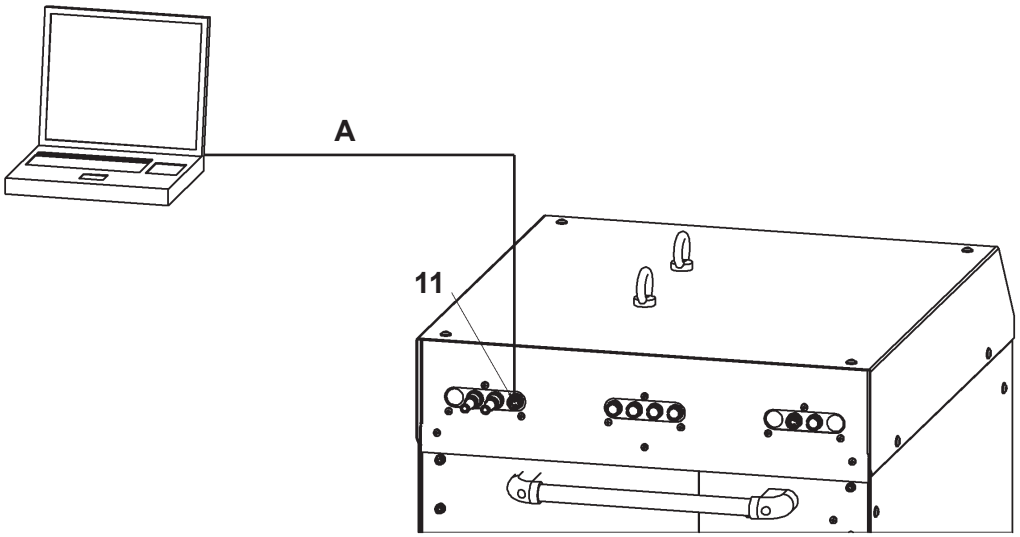
13.6 RS 232 Interface Pr

Via the serial interface for the control of the stud welding unit, the actually recorded data can be output for a potential storage in ASCII format.

A data cable is required which can be ordered as a consumable at HBS (order no. 80-70-308).



11 - RS 232 interface PR 7poles

A - Data cable, order no. 80-70-308

This data collection can be evaluated by a terminal program (e.g. Hyper Terminal).

If you want to use the data input and output, you should have available two serial interfaces. Thus you must open com1 and com2 at the terminal program.

Connection settings of the serial interface at a PC or notebook:

Bits per second:	115.200
Data bits:	8
Parity:	None
Stop bits:	1

The current order set is displayed using the entry **HELP** and the **ENTER** key.

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14 Troubleshooting

Danger from insufficiently qualified operating personnel

- Carry out only the work described here on your stud welding unit or stud welding gun.
- Repairs may only be carried out by appropriately qualified personnel.
- Inform your dealer or your maintenance department.

Fault	Possible cause	Fault localisation	Fault remedy	Performance
Primary switch does not rest in position 1	Primary switch defective	Check primary switch*)	Replace primary switch*)	Qualified specialists
	Fuse F4 1 AF for primary switch defective	Check voltage supply of primary switch*)	Replace fuse F4 1 AF*)	Qualified specialists
	Primary cable defective	Check primary cable for breaks*)	Replace primary cable*)	Qualified specialists
No LED display at the front	Fuse F5 1 AF defective	Check fuse F5 1 AF*)	Replace fuse F5 1 AF*)	Qualified specialists
No display	No ground connection	Check ground connection on workpiece	Tighten ground connection properly	Trained personnel
	Welding gun not connected	Check welding gun connection	Connect welding gun properly	Trained personnel
	Transition resistance (between stud and workpiece) too high	Check material surface	Clean or grind material surface	Trained personnel
	Ground cable broken	Check ground cable*)	Replace ground cable*)	Qualified specialists
	Welding gun cable broken	Check welding gun cable*)	Replace welding gun cable*)	Qualified specialists
No display	Defective connecting line of welding gun	Check function of connecting line*)	Replace connecting line*)	Qualified specialists
	Welding gun trigger button defective	Check control cable for electrical flow with triggered start button*)	Replace welding gun trigger button*)	Qualified specialists
	Control cable broken	Check control cable for electrical flow*)	Replace control cable*)	Qualified specialists

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Fault	Possible cause	Fault localisation	Fault remedy	Performance
Continuously red Display: 8888	Welding sequence too fast	Stud welding unit resets automatically	Let switched on stud welding unit cool down	Trained personnel
Gun does not lift, in spite of and	No lift adjusted	Check settings of welding gun	Modify set parameters	Trained personnel
	Short circuit of solenoid circuit of the gun	Check resistance value at control cable connector (18 Ω to 22 Ω) between Pin 1 and Pin 2*)	Replace control cable connector, control cable and solenoid*)	Qualified specialists
	Solenoid defective	Check solenoid (18 Ω to 22 Ω)*)	Replace solenoid*)	Qualified specialists
	Fuse F3 4 AF defective	Check fuse F3 4 AF*)	Replace fuse F3 4 AF*)	Qualified specialists
Lifting impossible	Solenoid circuit inter-rupted	Check resistance value at control cable connector (18 Ω to 22 Ω) between Pin 1 and Pin 2*)	Replace solenoid or control cable*)	Qualified specialists
No shielding gas	Shielding gas not connected	Check shielding gas connection	Connect shielding gas	Trained personnel
	Shielding gas control not enabled	Check gas control for activity	Switch on shielding gas control	Trained personnel
	Shielding gas valve defective	Check shielding gas valve*)	Replace shielding gas valve*)	Qualified specialists
No automatic stud feeding	Compressed air not connected	Check compressed air connection	Connect compressed air	Trained personnel
	Compressed air control not enabled	Check compressed air control for activity	Switch on compressed air control	Trained personnel
	Compressed air valve defective	Check compressed air valve*)	Replace compressed air valve*)	Qualified specialists

STOP

Work marked with *) may only be carried out by qualified electricians!

- Please contact our Service department if none of the measures described remedies the situation.
- Please use the form „Service & Support“ in the annex to send in the stud welding unit.

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15 Shutting Down

- Switch off the stud welding unit.
- Pull out the mains plug.
- Disconnect the control cable and welding cables from the stud welding unit.
- Protect the stud welding unit and its components against the ingress of liquids and foreign matter.

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16 Maintenance and Care

Electric shock hazard

- Always switch off the stud welding unit before starting maintenance and care work.
- Pull out the mains plug.

Danger from insufficiently qualified operating personnel

- Carry out only the work described here on your stud welding unit.
- Repairs may only be carried out by appropriately qualified personnel.
- Inform your dealer or your maintenance department.

16.1 Cleaning

- Clean the surface of the stud welding unit with a slightly damp cloth, when necessary.
- Add a little household detergent to the cleaning water.

- **Do not use solvents for cleaning.**

These can damage the surface of your stud welding unit.

The inside of the stud welding unit must be cleaned at least every three months.

- Inform your dealer or your maintenance department.

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16.2 Inspection and Tests

- **Inspect the condition of the mains cable.**
- Inform your dealer or maintenance department if you discover any damage.

- Check whether the readings on the display of the stud welding unit are still legible before starting work.
- Clean display and control panel in the event of soiling.

- Replace any removed or damaged signs:

Before opening machine disconnect mains

Observe the operating manual

Warning of electric shock hazard

We recommend that the stud welding unit be subjected to an annual periodic inspection in compliance with the standard IEC 60974-4 “Periodic inspection and testing”.

Please contact your customer advisor for further information.

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17 Storage

- Store the stud welding unit in a safe and dust-free location when not in use.
- Protect the stud welding unit from moisture and metallic contamination.

- Store the stud welding unit only under the following ambient conditions.

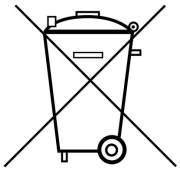
Storage temperature:

-5 °C to +50 °C

Relative humidity:

0 % - 50 % at +40 °C
0 % - 90 % at +20 °C

18 Disposal



- Dispose of the stud welding unit only via the manufacturer or a specialist disposal company.
- Never dispose of the stud welding unit in the domestic refuse.

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EC Declaration of Conformity

in Accordance with Directive 2006/42/EC, Annex II 1 A
(Original EC Declaration of Conformity)

Herewith the manufacturer

HBS Bolzenschweiss-Systeme GmbH & Co. KG
Felix-Wankel-Strasse 18
P.O. Box 13 46
85221 Dachau
GERMANY
Phone +49 8131 511-0

declares for the following product

Machine information: Stud welding unit
Type: IT 90
Order No: 93-60-42099
Serial No: 93-60-42099/251XXXX
Year of manufacture: 2025

in conjunction with HBS components

that the machinery fulfils all the relevant provisions to this Directive, including changes to the Directive to be applied at the moment of this declaration.

The product is conform with following further EU Directives, including changes to the Directives to be applied at the moment of this declaration:

„Low voltage guideline“ 2014/35/EU
„EMC guideline“ 2014/30/EU
„Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment“ 2011/65/EU

Following harmonised standards (or parts thereof) were applied:

DIN EN 60974-1	Arc welding equipment - Part 1: Welding power sources
DIN EN 60974-10	Arc welding equipment - Part 10: Product standard for arc welding equipment
DIN EN 60204-1	Safety of machinery - Electrical equipment of machines; Part 1: General requirements

The following national standards and other specifications (or parts thereof) were applied:

VDE 0544-1

Persons who are based in the European community and who are authorised to compile the technical documentation:

Name: Address: see manufacturer

Dachau, 02.01.2025
Place of issue, Date

Anja Bloch (CEO HBS)

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Service & Support

With the return please attach a copy of the filled out form together with the repair number given by HBS! Repairs without repair number will not be processed.

Repair number
(given by HBS)

_____

Company: _____
Name / Surname: _____
Street: _____
City, State and ZIP/Postcode: _____
Country: _____
Phone & Fax: _____
E-mail address: _____

Stud welding unit / stud welding gun type of model: _____
Serial number: _____
Date of purchase: _____
Purchased at distributor: _____

Detailed descriptions of errors: _____

Service & Support may be done up to the value of EUR _____ without quotation: ☐ Yes ☐ No

Could you find any damage / burn marks

on the cables: ☐ Yes ☐ No

on chucks: ☐ Yes ☐ No

Are all plug and screw connections tightly fastened *: ☐ Yes ☐ No

Are there any burn marks on plug or screw connections: ☐ Yes ☐ No

Is there any other visual damage (e.g. cracks, dents): ☐ Yes ☐ No

Have you checked the fuses: ☐ Yes ☐ No

Default on the display of the stud welding unit:

ARC / IT					CD / CDM / SC					
○	⊗				●		⊗			**

Which LED´s are illuminated (please mark with a cross)?

Please e-mail or fax this form to service@hbs-info.de or fax: +49 8131 511-100.
In case a repair is necessary a repair number will be given!

* See also operating manual chapter „Connection“
** Doesn´t light when using a contact welding gun

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