Technical Data
Systems for drawn arc

	IT 1002	IT 2002	IT 90
			
	• All-rounder for construction sites and workshops (IP 23) • Precise results through advanced inverter technology	• Energy Package for larger studs, used on construction sites and workshops	• Inverter (2 000 A) with options for 4 outputs, process monitoring and shielding gas
	M3 to M16 (type RD) #4 to 5/8“ (type RD)	M3 to M24 #4 to 1“	M3 to M24 #4 to 1“
			
Welding process	ARC, SC	ARC, SC	ARC, SC
Welding material			
Technology	Inverter	Inverter	Inverter
Equipment			
Welding with ceramic ferrule	X	X	X
Welding with shielding gas	X	X	X
Process control	(optional)	--	X
Automation	(optional)	--	X
4 gun/head connections	--	--	(optional)
Display	Digital	Digital	Digital
Welding range	M3 to M16 (type RD), dia. 2 to 14 mm / #4 to 5/8" (type RD), dia. 14 ga to 9/16“	M3 to M24, dia. 2 to 22 mm / #4 to 1“, dia. 14 ga to 1"	M3 to M24, dia. 2 to 22 mm / #4 to 1“, dia. 14 ga to 7/8“
Welding rate	M12 / 1/2" = 25 studs/min	Dia. 22 / 7/8" = 6 studs/min	Dia. 22 / 7/8" = 6 studs/min
Welding current	1 000 A (max.)	2 000 A (max.)	2 000 A (max.)
Current adjustment range	100 to 1 000 A, electrode 50 to 400 A (stepless)	300 to 2 000 A (stepless)	300 to 2 000 A (stepless)
Welding time	5 to 1 000 ms (stepless)	5 to 1 500 ms (stepless)	5 to 1 500 ms (stepless)
Primary power	400 V*, 3 phases, 50/60 Hz, 35 AT (slow blow) *alternative primary power see „Order No."	400 V*, 3 phases, 50/60 Hz, 63 AT (slow blow) *alternative primary power see „Order No.“	400 V*, 3 phases, 50/60 Hz, 63 AT (slow blow) *alternative primary power see „Order No.“
Primary plug	32 A (with 400 V mains)	63 A (with 400 V mains)	63 A (with 400 V mains)
Connected load	50 kVA (with 400 V mains)	100 kVA (with 400 V mains)	100 kVA (with 400 V mains)
Cooling type	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)
IP Code	IP 23	IP 23	IP 21
Dimension LxWxH (without handle)	660 x 280 x 340 mm / 26" x 11" x 13.4"	600 x 500 x 830 mm / 23.6" x 19.7" x 32.7"	650 x 560 x 1 290 mm / 25.6" x 22" x 50.8"
Weight	31 kg / 68.343 lbs	95 kg / 209.4 lbs	145 kg / 319.67 lbs (1 gun conn.) 165 kg / 363,76 lbs (4 gun conn.)
Suitable guns	A 12, A 12-FL, A 16, CA 08	A 12, A 12-FL, A 16, A 22	A 12, A 12-FL, A 16, A 22
	Order No.	**Order No.**	**Order No.**
	93-60-1202 (400 V) **93-66-1202** (480/460 V)	**93-60-2202** (Gas, 400 V) **93-66-2202** (Gas, 480/460 V)	**93-60-12096** (400 V - 1 gun connection) **93-60-42096** (400 V - 4 gun connection) **93-66-12096** (480/460 V - 1 gun connection) **93-66-42096** (480/460 V - 4 gun connection)
	**93-40-020** (Ground cable, 5 m, 25 mm², 2 vice grips 10“)	**93-40-019** (Ground cable, 2 pcs., 5 m, 70 mm², 1 vice grip 10“)	**93-40-019** (Ground cable, 2 pcs., 5 m, 70 mm², 1 vice grip 10“)

Legend

Welding process: ARC = Drawn arc stud welding, SC = Short cycle stud welding

Mild steel Stainless steel Aluminium

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