

Buttwelding machines with STRECKER dual upset method

For flashfree welds on solid wires or stranded conductors

The integrated automatic deburring cycle allows to achieve welded joints having the same diameter as the original material

Units with a 3 phase AC transformer allow symmetrical load division to the phases with abt. 40 per cent less supply system loading.

All units available with Full Parameter Control (FPC)



Type MS20-FPC



Type MS220-FPC



Type MK800-FPC

Welding of wires or solid conductors with highest strength of the weld

Welding of stranded conductors without tubes

Type	MS20	MS40	MS80	MS220	MS300	MS500	MK220	MK300	MK800	MK1200
kVA nominal	20	40	80	220	300	500 (3P)	220	300	800 (3P)	1200 (3P)
Welding range \varnothing [mm]										
Cu	3,0- 9	5 - 13	5 - 18	8 - 25	8 - 32	12 - 42	10 - 30	10 - 40	15 - 48	15 - 56
Al	4,5- 10	5 - 16	5 - 23	9 - 30	10 - 34	12 - 42	10 - 32	10 - 45	15 - 50	15 - 56
Brass	3,0- 9	5 - 16	5 - 23	8 - 28	8 - 34	-	10 - 30	10 - 35	-	-
Welding range [mm ²]										
Cu stranded	16 - 95	16 - 150	16 - 300	50-500	50- 800	95-1.000	50- 800	95 - 1.200	185 - 2.000	185 - 2.500
Al stranded	16 - 95	25 - 150	25 - 300	70-630	95-1.000	120-1.000	95-1.000	120 - 1.200	185 - 2.000	185 - 2.500
Weight [kg]	550	1.200	1.300	1.900	2.100	3.400	2.800	3.200	4.500	5.200

Machines between 100 kVA - 220kVA nominal capacity are available with a medium frequency transformer.
3P (3phase AC transformer, DC welding voltage, balanced load)

FPC (Full Parameter Control)

central control and administration of all welding parameters

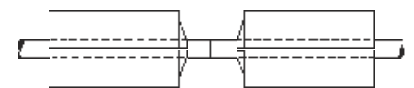


automatic deburring

burr free welds on wires and solid conductors



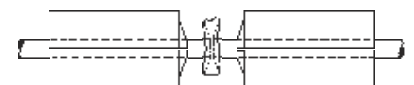
Operating diagram of a MS / MK weld



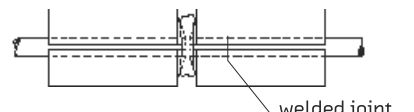
clamped wire ends before welding



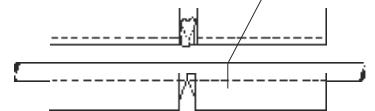
after welding and second upset cycle



position before flash removal . . .
. . . and after deburring

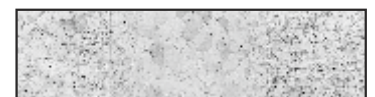


welded joint

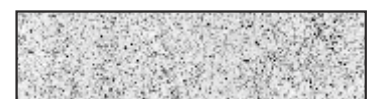


flash ring is torn apart

Grain structure



a) conventional welding technique



b) dual upset method