

3650CF20 3655CF20



Direct current welding station with inverter technology M.F. 25 kVA. (1000 Hz). Water-cooled pneumatic double program. Simultaneous connection of two tools, with automatic recall of the relevant memorized welding program, enabling to save time, avoid errors so to have a simple and safe working process. Fast Gun, patented pneumatic gun with adjustable stroke.

Car body shops repair works: spot welding with "C" gun, even for high strength steels both single-sided and twin spot; welding of nails and washers for sheet straightening (spotter function); localised heating with carbon electrode; sheet-metals spotting. By means of the inverter technology that allows a constant and high welding current, not influenced by the variations of the supply voltages and by the secondary circuit conditions, the quality of the spot is improved also on galvanized sheets. The high current value allows to save time resulting in a longer electrodes life. The reduced absorption balanced on the three phases reduces the connecting costs.

The epoxy-coated welding transformer is water-cooled. Analog welding control unit and potentiometer, with two independent programs, time adjustment in cycles, pulses, welding current and compensation.

Item	3650CF20	3655CF20	
Supply voltage	*400	*400	V
Mains frequency	*50 / 60	*50 / 60	Hz
Mains protection (delayed)	35	40	A
Nominal power 50% ED	25	25	kVA
Maximum welding power	125	--	kVA
Maximum secondary voltage	9	12	kA
Thermal current 100%	1,25	1,25	kA
No load secondary voltage	14	15	V
Weld time	1 ÷ 65	1 ÷ 65	cycles
Protection rating	21	21	IP
Weight	150	150	kg

* Different voltages and frequencies on demand

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NEW EVOLUTION direct current welding stations with inverter technology M.F. 25 kVA. (1000 Hz) equipped with:

- **NEW TE40i inverter WELDING CONTROL UNIT** provided with pre-settled main welding programs for high resistance materials too, time adjustment in ms, real welding current display, pulses, welding current and automatic compensation.
- **USB port** for upgrading and welding data managing on PC.
- **Automatic proportional valve** for managing the force at the electrodes.
- **Machine's NEW DESIGN. NEW TROLLEY** equipped with protected wheels providing greater stability and ergonomics.

The NEW EVOLUTION welding systems keep alive those features which made the TECNA welding systems versatile and reliable:

- Independent double program;
- Water-cooling;
- Pneumatic functioning with simultaneous connection of two tools and automatic recall of the relevant memorized welding program enabling to save time, avoid errors so to have a simple and safe working process.

The NEW EVOLUTION welding systems for car body repair are equipped with last generation's **Smart Guns and Fast Guns**, pneumatic guns providing maximum pressures from **320 daN up to 450 daN**

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Mains frequency	*50 / 60	*50 / 60	Hz
Mains protection (delayed)	35	40	A
Nominal power 50% ED	25	25	kVA
Maximum welding power	125	--	kVA
Maximum secondary voltage	9	12	kA
Thermal current 100%	1,25	1,25	kA
No load secondary voltage	14	15	V
Weld time	0,01 ÷ 2	0,01 ÷ 2	s
Protection rating	21	21	IP
Weight	150	150	kg

* Different voltages and frequencies on demand