

SERIES LBH



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The compact LBH stud welding units are designed for drawn arc and short cycle stud welding. They convince through easy operation and high welding quality. The robust construction ensures high reliability and high power-on time. All functions are indicated by clearly arranged LED. The welding time is continuously adjustable by the rotary knob on the front.

Optionally, the models LBH 710 and LBH 910 can be equipped with an inert gas module for welding with inert gas for weld pool backing and with an automatic module to control the automatic stud feeding system VBZ and an automatic welding gun.

Technical Data

	LBH 410	LBH 710	LBH 910
Welding range	Ø 2-8 mm	Ø 2-10 mm	Ø 2-12 mm
Welding material	steel, stainless steel		
Welding rate	up to 25 studs/minute (depending on application and stud diameter)		
Welding methods (acc. to DIN EN ISO 14555)	drawn arc (ceramic ferrule)	drawn arc (ceramic ferrule), short cycle optional: drawn arc (inert gas)	
Welding current	400 A	680 A	900 A
Welding time	40-350 ms, continuously adjustable	5-950 ms, continuously adjustable	
Power source	transformer/rectifier		
Mains plug	CEE 32 A		
Mains supply (special voltages optional)	400 V, 25 A, 50/60 Hz		400 V, 32 A, 50/60 Hz
Mains fuse external	25 AT		35 AT
Protection	IP 23		
Dimensions (WxHxL)	195x260x400 mm	275x260x470 mm	
Weight	27 kg	37 kg	37kg
Item number	B-90-30-3032	B-90-30-3411	B-90-30-3413
Suitable welding guns *only with option automatic module	PHM-12	PHM-10, PHM-12, PHM-160, PHM-161 PHA-500*, PHA-500-6*	



Details

- easy operation
- high welding quality
- welding time continuously adjustable (LBH 710/910: timing divided up into two time domains for especially precise adjustment) (fig. 1)
- indication of all functions by LED (fig. 1)
- indication of error messages by LED (fig. 1)
- LBH 710/910: digital display of selected welding time (fig. 1)
- compact construction
- low weight
- optional for LBH 710/910 (also retrofittable): inert gas module for welding with inert gas for weld pool backing (fig. 2)
- inert gas pre-flow time continuously adjustable (with option inert gas module)
- optional for LBH 710/910 (also retrofittable): automatic module to connect the automatic stud feeding system VBZ and an automatic welding gun

- highest operational reliability and high power-on time through exclusive use of high-quality components
- electronic control of all functions
- repeat cycle lock to avoid welding on an already welded welding element
- automatic function test after switch-on
- temperature control as protection against destruction caused by excess temperature
- automatic switch-off in case of excess temperature and phase failure
- protection of the unit in case of a fault on welding/control line cable and solenoid
- thermic controlled ventilator
- robust, powder-coated metal housing
- stable fixing of welding cable sockets at own plug holder, prevents damage on housing caused by pulling of cable