



V.0704

alfa209

Spot welding



Alternative Current - Medium Frequency 1000 Hz
Pneumatic Drive - Servo Drive

S6 SERRA

alfa209



Technical features

Main Voltage	V	400 (50 Hz)
Electrode diameter (conical 10°)	mm	19
Electrode holder diameter	mm	35
Arms diameter	mm	70
Minimum distance between arms	mm	140
Maximum distance between arms	mm	450

MFC-3000

Medium Frequency Inverter with adaptative controller



Equipment:

- Pneumatic circuit with single pressure system
- I/O water valves 1/2".
- Air Inlet valve 1/2".
- Electric pedal
- Circuit breaker

Optionals:

- Distance between arms 550 mm
- Servo driven head. Force 750 daN.
- Pneumatic circuit with counterpressure system
- Proportional valve
- Flowmeter
- Elastomer for head tracking
- Automation integration set

ORDER CODE

Welding type

- A- Spot welding (Alfa Series)
- B- Projection welding (Beta)
- C- Microwelding
- D- Seam welding (Gamma)

Structure dimensions

- 1- 300 daN (Alfa 10)
- 2- 900 daN (Alfa 209)
- 3- 1400 daN (Alfa 314)
- 4- 1800 daN



Transformer

- 1- 70 kVA - 50/60Hz
- 2- 100 kVA - 50/60Hz
- 3- 125 kVA - 50/60Hz
- 4- 100 kVA - 1000Hz
- 5- 150 kVA - 1000Hz
- 6- 2x100 kVA-1000Hz
- 7- 2x150 kVA-1000Hz

Force unit

- 1- 300 daN - Single pressure
- 2- 450 daN - Single pressure
- 3- 450 daN - Double pressure
- 4- 450 daN - Double stroke
- 5- 750 daN - Simple pressure
- 6- 750 daN - Double pressure
- 7- 750 daN - Double stroke
- 8- 900 daN - Single pressure
- 9- 900 daN - Double pressure
- 0- Servo head

Alfa 209 - MACHINE CODES

		A2122	A2152	A2153	A2183	A2124	A2186	A2222	A2253	A2224	A2255	A2256	A2323	A2325	A2357
Welding frequency	Hz	50	50	50	50	1000	1000	50	50	1000	1000	1000	50	1000	1000
Power at 50 % D.C.	kVA	100	100	125	125	100	2x100	100	125	100	150	2x100	125	150	2x150
Admissible power	kVA	200	200	250	250	160	250	200	250	160	160	250	250	160	250
Delayed fuses	A	200	200	250	250	160	250	200	250	160	160	250	250	160	250
Main supply section by phase	mm ²	90	90	120	120	70	120	90	120	70	70	120	120	70	120
Secondary voltage	V	7,7/9	7,7/9	8,6/11	8,6/11	10	10	7,7/9	8,6/11	10	12	10	8,6/11	12	12
Max. short circuit current (5 periods)	kA	40	40	50	50	26	45	35	42	26	26	45	38	26	40
Max. welding current (5 periods)	kA	32	32	40	40	26	45	28	33	26	26	45	30	26	40
DIN throat depth	mm	400	400	400	400	400	400	600	600	600	600	600	750	750	750
Force at 6 bar	daN	450	750	750	900	450	900	450	750	450	750	750	450	450	450
Manoeuvres / minute (10 mm)	min ⁻¹	90	90	90	90	90	90	90	90	90	90	90	90	90	90
Width	mm	500	500	500	500	500	500	500	500	500	500	500	500	500	500
Length	mm	1230	1230	1230	1230	1230	1230	1630	1630	1630	1630	1630	1790	1790	1790
Height	mm	1893	1893	1893	2152	1893	2152	1893	1893	1893	1893	1893	1893	1893	1893
Weight	Kgs	610	620	640	640	580	600	610	630	580	585	600	660	620	640



SERRA SOLDADURA, S.A.

www.serrasold.com

QUALITY MANAGEMENT Certificate

Voluntary participation in regular monitoring according to ISO 9001:2000



ENVIRONMENTAL MANAGEMENT Certificate

Voluntary participation in regular monitoring according to ISO 14001



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