

WELD CONTROLLER FOR RESISTANCE WELDING

SERRATRON 1B

V.0710



- ▶ 127 welding programs
- ▶ Integrated programming unit
- ▶ Proportional valve control
- ▶ Sequence with 3 weld times
- ▶ Electrode wear compensation
- ▶ Electrode tip dressing control
- ▶ Ethernet connectivity
- ▶ Wide weld sequences:
**CHAINED MODE,
SUCCESSION...**

WORKING MODES

2

PHYSICAL CHARACTERISTICS

Hanging stations (number of weld programs)	MAN (127)	Dimensions (H x W x D)	202 x 134 x 49 mm
Pedestal welders (number of weld programs)	STA (127)	Weight	1,0 Kg
Robots (number of weld programs)	STA (127)	Working temperature	-5° to 60°

BASIC FUNCTIONS

Max. number of power units	1
Communication network	Ethernet + TCP/IP
Control modes: constant current, current monitoring, firing angle	●
Electrode wear compensation through editabe curves	●
Sequence of 3 weld times	●
Log of the latest welds / Log of the latest error messages	512
Parameter storage without the need of battery back up	●

ELECTRICAL CHARACTERISTICS

INPUTS- OUTPUTS

Synchronisation	20 Vca	Digital inputs (18...28V/10 mA)	18
Frequency (automatic detection)	50/60 Hz	Current measuring input (20÷2300 mV / kA)	1
Power supply	24 VA +15%/-20%	Firing outputs (24 Vdc / 1A, 5kHz pulses)	1
Power rating	12 W	Digital outputs (24 Vdc / 1A)	8

OPTIONALS

CPC-connect	Central programing software via Ethernet
SERRAstick	Memory stick for data log



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**ENVIRONMENTAL
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