



British Federal Projection welders are designed to give optimum welding conditions covering a wide range of applications.



- **FLEXIBILITY** - Choice of 150, 250, 300 kVA AC Transformers & MFDC Transformers.
- **TOOLING VERSATILITY** - Fully adjustable platen gap and T-slotted platens.
- **RELIABILITY** - 50% duty cycle encapsulated transformer.
- **HIGH QUALITY WELDING** - Choice of state-of-the-art microprocessor weld control.
- **OPERATOR SAFETY** - Twin button initiation as standard.
- **LINEAR BEARING HEADSLIDE**

OPTIONAL EXTRAS

- High lift and or 160mm air cylinder.
- 150KVA, 250KVA, 300KVA single phase AC or 250KVA 3-phase DC Medium Frequency Transformer.
- Custom Built tooling.
- Closed circuit water cooled system.
- Integration of automatic nut and bolt feed machines.
- Light guard and peripheral guarding systems.

MFDC OFFERS THE FOLLOWING BENEFITS:

- PA2 projection welding machines are also available as inverter controlled medium frequency machines and offer the following added benefits:
- Improved weld quality.
- Reduced Power consumption costs.
- Lower peak currents providing increased electrode life.
- 3-phase even load distribution.
- Ideal for welding coated materials.
- Weld times reduced through increased rate of heat input to work piece.
- Reduced weld splash owing to lower peak currents.
- Can be retrofitted to existing machines.

PA2 & PA3 PROJECTION WELDER



TECHNICAL SPECIFICATIONS			PA2			PA3	
			150	250	300	400	600
Continuous power @100% duty cycle	Sp	kVA	80	135	135	215	300
Max short circuit power	Sc	kVA	80	820	920	1245	1700
Max welding power	Smax	kVA	430	650	740	1000	1350
Nominal power@50% Duty Cycle	S50	kVA	115	195`	195	300	425
Nominal supply voltage	U1n	V	380/440	380/440	380/440	380/440	380/440
Continuous primary current at 100% duty cycle	I1p	A	200	330	330	515	725
Supply Frequency		Hz	50	50	50	50	50
Supply Phases			2	2	2	2	2
Supply Capacity		kVA	325	490	550	750	1000
HRC fuse size to BS88		A	250	355	355	560	800
Feed cable c.s.a upto 30m long		mm2	95	185	185	300	630
Max short circuit primary current	I1cc	A	1300	1950	2220	3000	4100
Max short circuit secondary current	I2cc	A	52000	64000	72000	80000	100000
Max welding current	I2 max	A	42000	51000	58000	64000	80000
Duty cycle for max welding	Xmax	%	3.6	4.4	3.5	4.6	5
Continuous secondary current at 100% duty cycle	I2p	A	8300	11200	9900	14000	17000
Number of taps			6	6	6	6	6
Secondary open circuit volts	U20	V	9.9-6	12.2-6.9	13.8-6.9	15.4-8.8	17.3-9.9
Weld cylinder diameter		mm	200	200	200	250	250
Weld force min/max with a 1.5/5.5bar supply		kN	4.7/17.3	4.7/17.3	4.7/17.3	7.5/27	7.5/27
Weld force min/max with a 80psi supply		lbf	1000-3900			1700/6150	
Weld cylinder stroke max		mm	100	100	100	100	100
Free air consumption for a 50mm stroke		Dm3	25.2	25.2	25.2	42.3	42.3
Air pressure normal		bar	5.5	5.5	5.5	5.5	
Air pressure max operating		bar	7	7	7	7	7
Air connection/hose size		BSP/in	1/2" / 1/2"			1/2" BSP/ 3/4"	
Cooling water min operating pressure		bar	3	3	3	3	3
Cooling water consumption		lit/min	30	30	30	30	30
Cooling water max inlet temp		°C / °F	30/86	30/86	30/86	30/86	30/86
Cooling water connection/hose size		BSP/in	3/4" / 3/4"			1" BSP / 3/4"	
Shipping specification	Weight	Kg	1015	1165	1165	2100	2100
	Size	mm	510Wx1204Dx1932H			925Wx1450Dx1993H	