



Total reliability is provided by British Federal BF450 type electronic welding control using 'state of the art' technology providing all electronic fully synchronous welding control and solid-state thyristor switching.



- **ADAPTABILITY** - Infinitely adjustable reach from 500 -800mm.
- **HIGH QUALITY WELDING** - Choice of state-of-the-art microprocessor weld control.
- **PRODUCTIVITY** - Welding speeds up to 250 spots per minute.
- **RELIABILITY** - 50% duty cycle encapsulated transformer.
- **VERSATILITY** - Simple adaption to projection welding

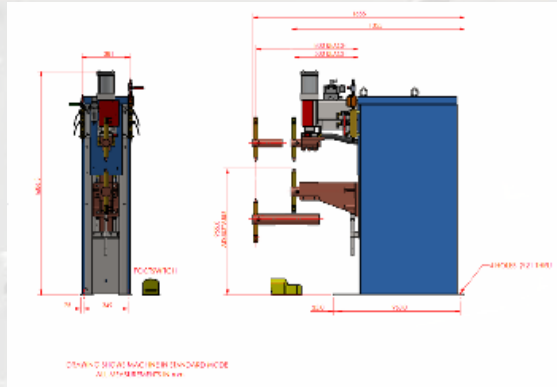
OPTIONAL EXTRAS

- High lift system.
- Soft Touch Safety system.
- Water-cooled lower arm.
- Reversible arms for angled electrodes.
- Closed circuit water-cooled system.
- Analogue PV valve.
- MFDC Transformer / Weld Control.
- Serra controls with optional Colour Touchscreen HMI.

MFDC OFFERS THE FOLLOWING 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 and Aluminium.
- 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.

STRONGHOLD SPOT WELDER



TECHNICAL SPECIFICATIONS			75 STRONGHOLD	100 STRONGHOLD	150 STRONGHOLD
Continuous power @100% duty cycle	Sp	kVA	53	71	106
Max short circuit power	Scc	kVA	290	360	460
Max welding power	Smax	kVA	230	290	360
Nominal power@50% Duty Cycle	S50	kVA	75	100	150
Nominal supply voltage	U1n	V	415	415	415
Continuous primary current at 100% duty cycle	I1p	A	130	170	250
Supply Frequency		Hz	50		
Supply Phases			2		
Supply Capacity		kVA	170	210	300
HRC fuse size to BS88		A	160	200	315
Feed cable c.s.a upto 30m long		mm2	50	70	95
Max short circuit primary current	I1cc	A	690	860	1200
Max short circuit secondary current	I2cc	A	32000	35000	42000
Max welding current	I2 max	A	25000	28000	33000
Duty cycle for max welding	Xmax	%	5.4	6.1	7.1
Continuous secondary current at 100% duty cycle	I2p	A	6000	7200	8900
Number of taps			3		
Secondary open circuit volts	U20	V	8.8/8/7	9.9/8.8/8	11.9/10.4/8.6
Weld cylinder diameter		kN			
Weld force min/max with a 1.5/5.5bar supply		lbf		1.8/6.7	
Weld force min/max with a 80psi supply		mm		400/1500	
Weld cylinder stroke max		bar		76	
Air pressure max operating		BSP/in		7	
Air connection/hose size				1/2" / 1/2"	
Cooling water min operating pressure		bar		3	
Cooling water consumption		lit/min		3	
Cooling water max inlet temp		°C / °F		30/86	
Cooling water connection/hose size		BSP/in		1/2" / 1/2"	
Shipping specification	Weight	Kg		595	
	size	mm		590Wx1350Dx1685h	