

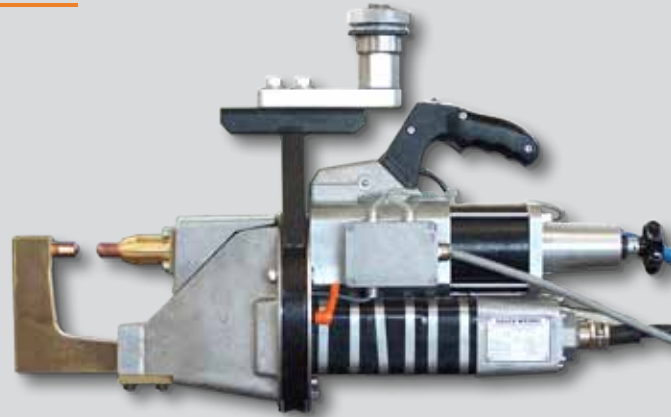
# SPOT WELDING GUNS

# 33

## 3349

### APPLICATION AREA

DALEX Spot welding guns of the series 33 find application in series operations for industrial usage.



### TECHNICAL DATA

Type	<b>3349</b>
Power rating 50 % d.c.	35 kVA
Secondary	26,3 kA
Armaabstand	100 mm
Elektrodenkraft	360 daN
Schweißleistung	Steel sheet 3 + 3 mm, max. 4 + 4 mm
zug. Steuergeräte	B 200 Free-stand.weld.contr. with slide in MPS 10
zug. Wasserrückkühler	COOL 1
zug. Federzug	D5/75

### TECHNICAL DETAILS

- high dot sequencing via compressed air cylinder
- 5/2-way solenoid valve
- gun and electrode arms, water-cooled
- distortion-free square electrode arms
- low-deflection square electrode arms for optimum performance of the electrode force
- rotation-resistant square mounting in gun body
- intensively cooled welding transformer and secondary circuit
- closed Cardan ring with safety hanger
- universal usage through an all-round mounting system
- welding transformer cast resin sandwich construction
- welding quality remains constant via the same sandwich construction
- toggle-joint system for raising electrode force
- connecting cable in standard 10m length and low connected load
- fusing 80 A

# SPOT WELDING GUN Typ 3349

Technical Data* acc. to DIN 44753 / ISO669			3349 EH	3349 DH	
Electrical Part	Throat depth	mm	100	100	
	Machine power	Power rating, 50 % d.c.	kVA	35	35
		Continuous rating	kVA	27,7	27,7
		Max. short-circuit power	kVA	186	186
		Max. welding power	kVA	148,8	148,8
	Machine voltage	Secondary idling voltage	V	7	7
		No. regulating steps		0	0
	Mains connection	Rated primary voltage	V	400	400
		Rated primary current	A	87,5	87,5
		Rated frequency	Hz	50	50
Supply power		kVA	111	111	
Primary short-circuit current		A	465	465	
1) Main switch / Fusing		A	80	80	
Wire range for cable length shorter= 15 m		mm <sup>2</sup>	16	16	
Secondary current	Rated operating current	kA	4,88	4,88	
	2) Continuous current	kA	3,45	3,45	
	Short-circuit current	kA	26,3	26,3	
	Max. welding current	kA	21	21	
	Perm. duty cycle at highest welding current	%	2,7	2,7	
Cylinder EH	Electrode stroke max.	mm	45 (5 – 45 stroke adjustment) / 70 6)	-----	
	Electrode force min. / max.	daN	360	-----	
	Max. movements at 10 mm stroke	min <sup>-1</sup>	200	-----	
	3) Air consumption for 1000 strokes	m <sup>3</sup>	0,5	-----	
Cylinder DH	Electrode stroke max / working stroke + operational stroke max.	mm	-----	70/0 - 60 + (10-70)	
	Electrode force max.	daN	-----	360	
	Max. movements at 10 mm stroke	min <sup>-1</sup>	-----	300	
	3) Air consumption for 1000 strokes	m <sup>3</sup>	-----	0,6	
Spot mounting	Throat gap min. / max.	mm	100	100	
	Electrode arm diameter, height x width	mm	34 x 24 Spigots	34 x 24 Spigots	
	Electrode holder Ø	mm	-----	-----	
	Electrode holder, adjustability	mm	-----	-----	
	Spot electrode seat no. / outer Ø	mm	2/18	2/18	
Compressed air	Pipe conn. nominal width / conn. thread	mm	NW 10/G 3/8"	NW 10/G 3/8"	
	Operating pressure min. / max.	bar	6/10	6/10	
Cooling water	Pipe conn. nominal width / conn. thread		NW 8/G 1/4"	NW 8/G 1/4"	
	Operating pressure min. / max.	bar	2/5	2/5	
	Consumption at max. loading	l/min <sup>-1</sup>	6	6	
Gun dimensions	4) Width x depth x height	mm	Gun 220 x 575 x 315 Hanger 70 x 300 x 960 Space reqd. compl. 433 x 735 x 1035	Gun 220 x 615 x 350 Hanger 70 x 300 x 960 Space reqd. compl. 415 x 615 x 1035	
	4) Weight gun excl. balancer connecting cable	kg	52 excl. cable and hanger / 59 compl.	62 excl. cable and hanger / 70,2 compl.	
Welding values	5) Steel sheet C-content smaller = 0,2 %	mm	3 + 3, max. 4 + 4	3 + 3, max. 4 + 4	
	5) Round steel C-content smaller = 0,2 %	mm	-----	-----	
Power stages	Thyristor power stage		1/90 L	1/90 L	

Mechanical Part

## Notes:

- 1) operating class gL
- 2) at max. transformer level
- 3) at operating pressure 6 bar stroke max.
- 4) excl. electrode mounting
- 5) subject to influences
- 6) by 3349 EH with 70 mm stroke

Technical alterations reserved.  
\*Details for shortest throat depth.