

# Serratron 1B

## Weld Controller For Resistance Welding



- **217 Welding programs**
- **Constant current mode**
- **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, Succesive...**

### Working Modes

2

Hanging Stations (number of weld programs)	MAN ( 127 )
Pedestal Welders (number of weld programs)	STA ( 127 )
Robots (number of weld programs)	STA ( 127 )

### Physical Characteristics

Dimensions ( H x W x D )	202 x 134 x 49mm
Weight	1.0 Kg
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 editable 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

Synchronisation	20 VCA
Frequency ( Automatic Detection )	50/60 Hz
Power Supply	24 VA +15%/ -20%
Power Rating	12 W

### Inputs - Outputs

Digital Inputs ( 18...28V/10 mA )	18
Current Measuring Input ( 20 ÷ 2300 mV / kA )	1
Firing Outputs ( 24 VDC / 1A, 5kHz Pulses )	1
Digital Outputs ( 24 VDC / 1A )	8

### Optionals

CPC - Connect	Central programming software via Ethernet
SERRAstick	Memory stick for data log

