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typical applications

drum welders



WS700D welding control

data sheet



Specialised sequence for drum welding

The WS700D is intended for drum welding applications requiring high quality welding and monitoring. This timer has a specific seam weld sequence with selectable teach/phase angle/constant current modes. A simple to use 4-line LCD and keypad allows up to 64 programs of weld settings to be entered. The timer can be supplied in a combination cabinet with circuit breaker and SCR to suit all machine kVA sizes.

features	benefits
specific drum sequence	accurate positioning and slope control
phase angle/constant current	quality welds
integral programmer	always available
50 or 60 Hz operation	international
64 user-defined programs	store settings for different types of drum
counter function	can be used for electrode maintenance
weld current monitoring	quality welds
pressure monitoring	quality welds
proportional valve control	control the welding force
detailed cycle log	record current, heat and force for every cycle

options

WS98-700D PC software for programming and monitoring
3PA/2 3-phase adapter
PM150W/300W/500W

configurations

WS700, cabinet and SCR combinations are shown in document 91-10-00-00-16

WS700D welding control

data sheet

program parameters x 64

mode	TEACH/PHA/CCR
delay on	0..99 cycles
upslope	0..99 cycles
weld 1	0..99 cycles
weld 2	0..99 cycles
z-correction	+1 to -1 kA/cycle or +9.9 to -9.9 %/cycle
delay off	0..99 cycles
downslope	0..99 cycles
hold	0..99 cycles
pressure	0..10V

monitoring parameters x 64

current monitor	on/off
current low limit	0..99%
current high limit	0..99%
pressure monitor	on/off
pressure low limit	0..99%
pressure high limit	0..99%

configuration parameters

frequency	50/60 Hz
contactor time	0..200s
toroid test	on/off
sensor	toroid/CT
heat range	high/low

calibration parameters

toroid sensitivity	100..2000 mV/kA
CT sec:pri ratio	1:1..199:1
CT sec:pri offset	-1kA..+1kA
pressure	2 points, kN/V

counter

actual count	0..9999
end count	0..9999
at end of count	stop/continue

cycle log

current	each ½ cycle
target	each ½ cycle
heat	each ½ cycle
pressure	each ½ cycle

environmental

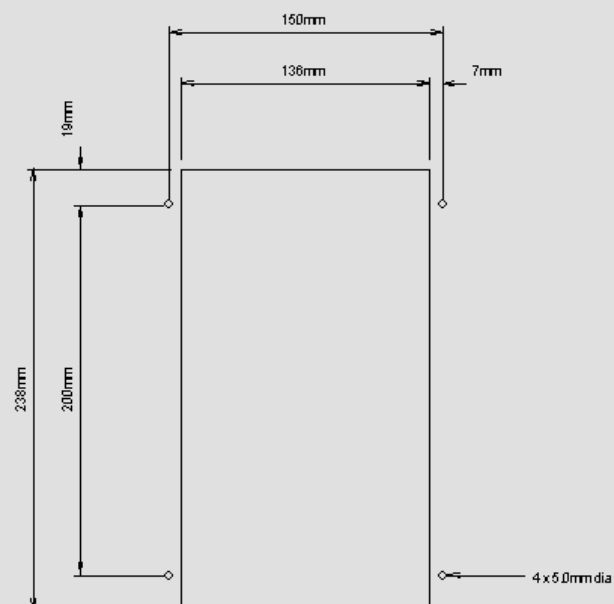
temperature	
- operating	+10° to +50°C
- storage	-25° to +70°C
humidity	
- operating	up to 80% (relative)
- storage	10% to 90%

dimensions

height	292mm
width	172mm
depth	38mm

mounting

cut-out dimensions



power/synchronisation requirements

maximum input current	1 A @ 24 V dc ±20%
line frequency	50/60 Hz ± 1 Hz

I/O ratings

2 outputs	500 mA @ 24 V dc each
6 outputs	100 mA @ 24 V dc each
12 inputs	10 mA @ 24 V dc each (max)

Information in the document is subject to change without notice.

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