

MARC

**Stud welding unit
IT 1002**
(93-60-1202)



**Nut and stud welding gun
A 12 M**
(93-20-244)



- Compact gun for nut and stud welding with magnetic rotating arc
- Length compensation (stable welding results)
- Especially suitable for workshop and assembly area

Nuts M6 to M12
Studs M5 to M10 / 3/16" to 3/8"



Suitable stud welding unit	IT 1002
Welding process	Drawn arc welding with magnetically impelled electric arc and shielding gas
Welding range	MARC welding nuts type Hex ^{Nut} M6 to M12 Hexagon nuts DIN 934 M6 to M12 SC welding elements M5 to M10, dia. 5 to 8 mm / 3/16" to 3/8", dia. 3/16" to 5/16" CD welding elements M5 to M10, dia. 5 to 8 mm / 3/16" to 3/8", dia. 3/16" to 5/16"
Sheet thickness	Nut welding: 1 to 3 mm / 0.04" to 0.12" Stud welding: min. 1 mm / min. 0.04" (other sheet thicknesses on request)
Welding element material	MARC welding nuts type Hex ^{Nut} : Stainless steel (A2-50) Hexagon nuts DIN 934: Stainless steel (A2-50,-70 / A4-50,-70, A5-50,-70) SC welding elements: Mild steel, stainless steel, type PT / UT / IT CD welding elements: Mild steel stainless steel, type PS / US / IS
Welding element type	MARC welding nuts type Hex ^{Nut} , hexagon nuts according to DIN 934 SC welding elements and CD welding elements according to DIN EN ISO 13918
Welding rate	Nut welding: up to 4 welding nuts/min. Stud welding: M10 = 25 studs/min The maximum welding sequence is limited by a number of parameters.
Length compensation	3 mm / 0.12", automatic
Lift	Adjustment range 3 mm / 0.12", lockable
Spring force	Adjustable, arresting
Welding cable	Welding gun: 4.85 m connecting cable, 35 mm ² 1.73 m field former cable, 10 mm ² (0.61 m welding current connection, 0.85 m control cable connection) Ground cable: 5 m, 25 mm ²
IP Code	IT 1002: IP 23, A 12 M: IP 20
Workplace noise level	Up to 90 dB (A) may occur during welding
Dimension LxWxH	200 x 65 x 140 mm / 7.87" x 2.56" x 5.51" (without cable, with leg assembly) Shielding gas leg assembly D = 60 mm Protective hose L = 4300 mm
Weight	0.8 kg / 1.76 lbs (without cable)

Order No.

93-20-244 (Welding gun A 12 with MARC equipment and protective hose)

93-60-1202 (Stud welding unit IT 1002)

93-40-020 (Ground cable, 5 m, 25 mm², 2x 10" vice grips)

Accessories – Nut welding

88-26-647 Adaptor for M8 internal thread

88-22-532 Nut fixture HBS Hex^{Nut} cpl. M6

88-21-107 Nut fixture HBS Hex^{Nut} cpl. M8

88-21-108 Nut fixture HBS Hex^{Nut} cpl. M10

88-21-109 Nut fixture HBS Hex^{Nut} cpl. M12

88-16-881 Nut fixture DIN 934 M6

88-16-882 Nut fixture DIN 934 M8

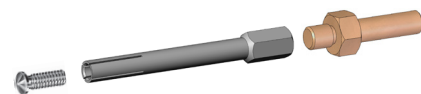
88-16-883 Nut fixture DIN 934 M10

88-16-884 Nut fixture DIN 934 M12

Accessories – Stud welding

80-05-689 Adaptor standard for ARC

93-40-128 Welding gun accessories ARC Gas;
M6 to M10

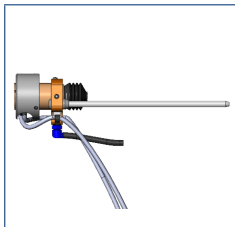
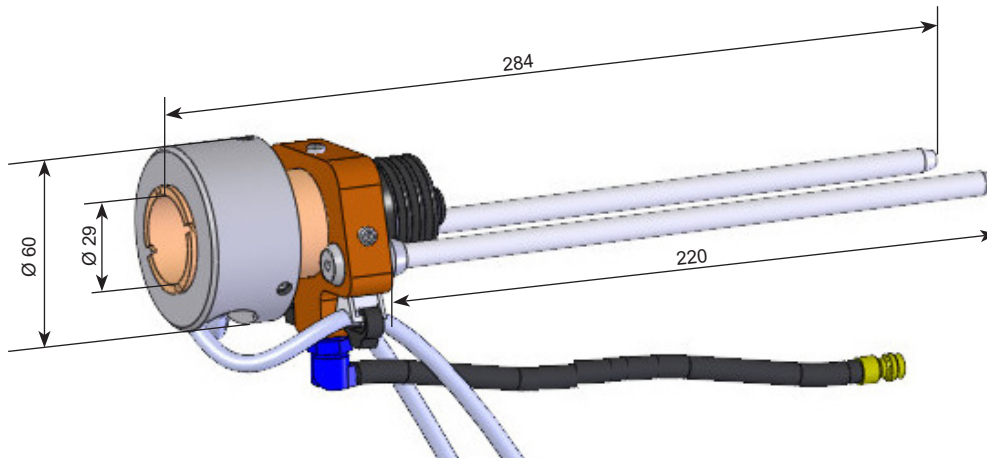


Legend

Welding process: MARC = Drawn arc welding with magnetically impelled electric arc and shielding gas

● Mild steel ● Stainless steel

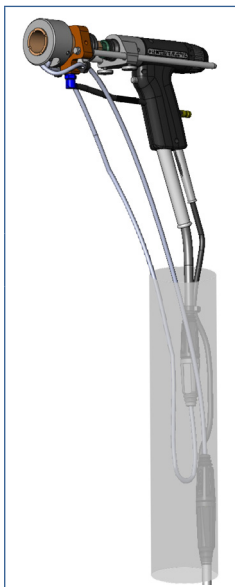
Equipment for A 12 M



Shielding gas leg
assembly with field
former

D = 60,
Legs 8 x 220
with shielding gas connection

88-26-880



Protective hose for
A 12 M

to protect the welding cables and the field former
cable from dirt, dust and welding sparks

Length: 430 cm
Width: 13.5 cm

80-10-2769