



IT 1002



IT 90



- All-rounder for automation
- Precise welding results through advanced inverter technology

- 4 outputs (optional), process monitoring and shielding gas
- For critical surfaces (e.g. galvanised)

M3 to M16 (type RD)
#4 to 5/8" (type RD)

M3 to M24
#4 to 1"



(Ceramic ferrule only for manual application)

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Welding process	ARC, SC	ARC, SC
Welding material		
Technology	Inverter	Inverter
Equipment		
Welding with ceramic ferrule	X	X
Welding with shielding gas	X	X
Process control	(optional)	X
Automation	X	X
4 gun/head connections	--	(optional)
Display	Digital	Digital
Welding range	M3 to M16 (type RD), dia. 2 to 14 mm #4 to 5/8" (type RD), dia. 14 ga to 9/16"	M3 to M24, dia. 2 to 22 mm / #4 to 1", dia. 14 ga to 7/8"
Welding rate	M12 / 1/2" = 25 studs/min	Dia. 22 / 7/8" = 6 studs/min
Welding current	1000 A (max.)	2000 A (max.)
Current adjustment range	100 to 1000 A, electrode 50 to 400 A (stepless)	300 to 2000 A (stepless)
Welding time	5 to 1000 ms (stepless)	5 to 1500 ms (stepless)
Primary power	400 V*, 3 phases, 50/60 Hz, 35 AT (slow blow) *alternative primary power see „Order No.“	400 V*, 3 phases, 50/60 Hz, 63 AT (slow blow) *alternative primary power see „Order No.“
Primary plug	32 A (with 400 V mains)	63 A (with 400 V mains)
Connected load	50 kVA (with 400 V mains)	100 kVA (with 400 V mains)
Cooling type	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)
IP Code	IP 23	IP 21
Dimension LxWxH (without handle)	660 x 280 x 340 mm / 26" x 11" x 13.4"	650 x 560 x 1290 mm / 25.6" x 22" x 50.8"
Weight	31 kg / 68.343 lbs	145 kg / 319.67 lbs (1 gun conn.) 165 kg / 363.76 lbs (4 gun conn.)
Suitable guns/heads	PAH-1, KAH 412, KAH 412 LA	PAH-1, KAH 412, KAH 412 LA

Order No.

93-60-1206 (400 V – process control)
93-66-1206 (480/460 V – process control)

Order No.

93-60-12096 (400 V – 1 gun connection)
93-60-42096 (400 V – 4 gun connection)
93-66-12096 (480/460 V – 1 gun connection)
93-66-42096 (480/460 V – 4 gun connection)

Legend Welding process: ARC = Drawn arc stud welding, SC = Short cycle stud welding

Mild steel Stainless steel Aluminium