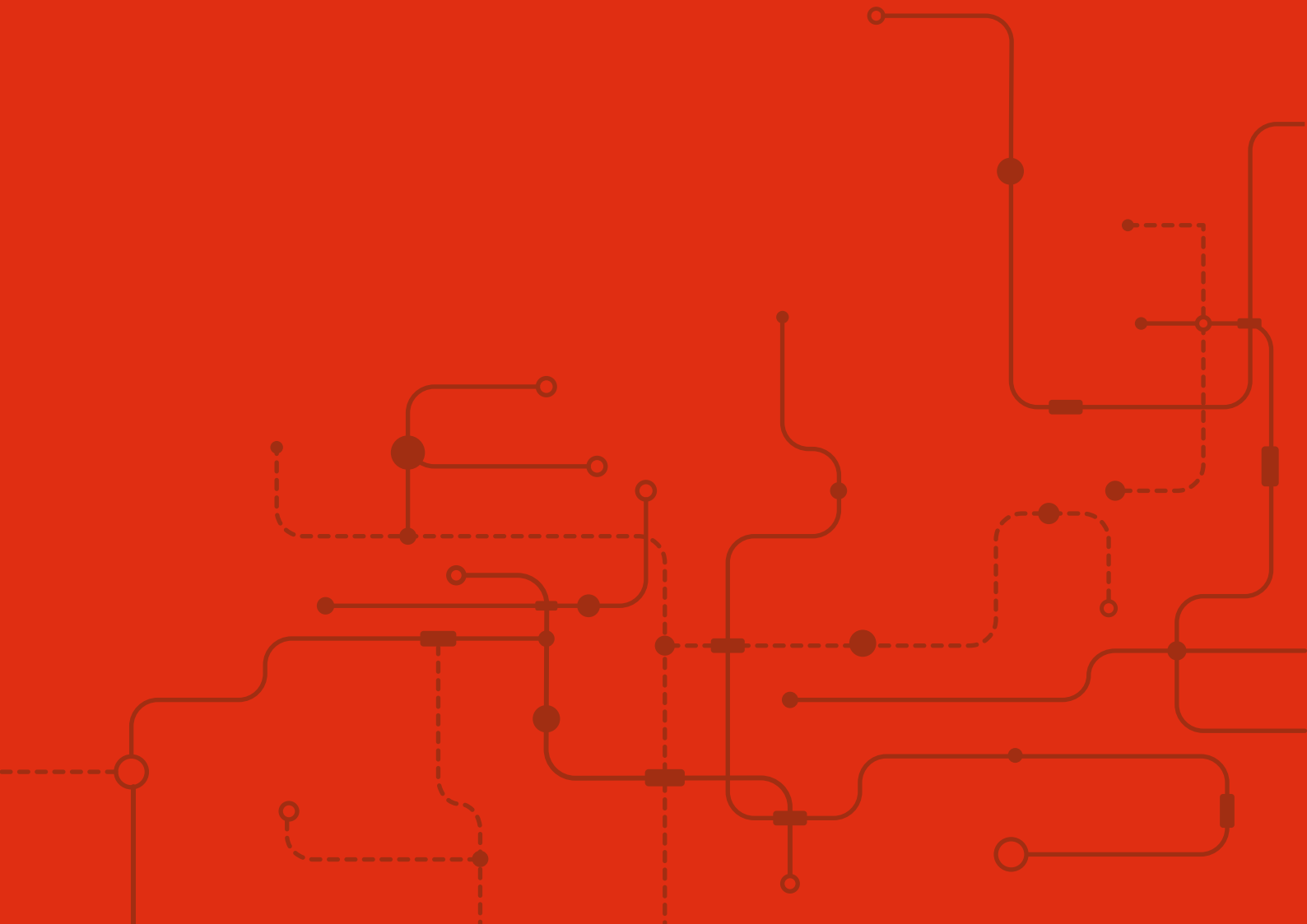
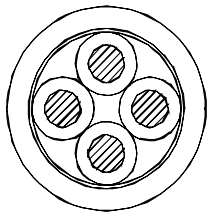


WELDING CABLES



Designed for the secondary (high current) connection to automatic or hand - held metal arc welding electrodes. It is suitable for flexible use under rugged conditions, on assembly lines & conveyor systems, in machine tool and automatically operated line & spot welding machines.

APPLICATION : Trailing, Land Line, Wind Mill, Thin Wall Cables, Motor Lead Wire, Panel Wiring, Battery Cable

Construction			
Cable Standard	: IS:9857:1990		
Conductor	: High Conductivity, Bare Annealed Copper Flexible Conductor, EC Grade Class-5.as Per IS:8130/1984.		
Separator	: Polyester Tape		
Covering	1. The general service 60°c normal duty elastometric compound shall be type se-1 conforming to the is:6380/1984. 2. The heat resisting and flame retardent (hoFR) 90°c Normal duty elastometric compound shall be type se-3 Conforming to the is:6380/1984.		
Colour	: Orange/Black.		
Standard Packing	: 500/1000 Meter.		
Technical Data		Voltage Drop	
Fixed Installation	: -20°C to max.+90°C	When total cable lengths in excess of 15mtr., are involved, it may be necessary to use cables of larger cross section to ensure that the voltage drop is not excessive & welding currents are maintained at adequate levels.	
Nominal Voltage	: 600 V		
Spark Test	: 3.5 KV (AC)		
Min. Bending Radius	: 6 X Cable Diameter		
Current Rating			
The maximum current ratings of flexible welding cables for different duly cycles are based on an ambient air temperature of 30° C and a maximum conductor temperature of 90° C. The percentage duly cycles for various processes and applications are as follows:		Automobile Welding	: up to 100%
		Semi Automatic Welding	: 30% to 85%
		Manual Welding	: 30% to 60%
		Very intermittent or Occasional Welding	: up to 20%

The General Service 60°C Normal Duty Elastomeric Cable

Cable Size	Conductor No of Strand	Nominal Insulation Thickness	Approx Overall Cable Dia	Max. Conductor Resistance at 20°C	Maximum duty Cycle Current Rating of Welding Application				
					100%	85%	60%	30%	20%
Sq.mm	Nos	mm	mm	Ω/km.	amp	amp	amp	amp	amp
16.0	126	2.00	9.0	1.21	94	102	121	172	210
25.0	196	2.00	10.30	0.780	125	136	161	228	279
35.0	276	2.00	11.50	0.554	156	169	201	285	349
50.0	396	2.20	13.40	0.386	197	214	254	360	440
70.0	551	2.40	15.40	0.272	248	269	320	453	555
95.0	760	2.60	17.60	0.206	299	342	386	546	669

Rating factors for variation in ambient temperature						
Ambient Temperature °C	25°	30°	35°	35°	40°	50°
Rating Factor	1.08	1.00	0.91	0.82	0.71	0.58

Ambient air temperature = 30°C
Maximum Conductor Temperature = 60°C

The Heat Resisting and Flame Retardant (HOFR) 90°C Normal Duty Elastomeric Cable

Cable Size	Conductor No of Strand	Nominal Insulation Thickness	Approx Overall Cable Dia	Max. Conductor Resistance at 20°C	Maximum duty Cycle Current Rating of Welding Application			
					100%	85%	60%	30%
Sq.mm	Nos	mm	mm	Ω/km.	amp	amp	amp	amp
16.0	126	2.00	9.0	1.21	135	146	174	246
25.0	196	2.00	10.30	0.780	177	192	228	343
35.0	276	2.00	11.50	0.554	221	240	285	403
50.0	396	2.20	13.40	0.386	279	303	360	509
70.0	551	2.40	15.40	0.272	352	382	454	643
95.0	760	2.60	17.60	0.206	424	460	547	774

Rating factors for variation in ambient temperature						
Ambient Temperature °C	25°	30°	35°	35°	40°	50°
Rating Factor	1.04	1.00	0.96	0.91	0.87	0.82

Ambient air temperature = 30°C
Maximum Conductor Temperature = 90°C

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