

# Volvo Car Corporation Approved Spot Welder

## GYS

### Gyspot inverter BP.LC



# Gyspot Inverter BP.LC

Technical Data

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## Mains connection:

Nominal voltage	3 x 400 V, 50 Hz
Fuses	32 A (Circuit breaker)
Connecting cable	4 x 10 mm <sup>2</sup>

## Machine performance:

Nominal power at 50 % duty cycle	18 kVA
Short circuit current	13 000 A
Maximum current	16 V
Pressure min./max.	3 / 8 bar
Cooling water	3l / min.
Electrode force max.	380 daN (4 bar) 550 daN (8 bar)

## Construction:

Dimensions L x W x H	800 x 650 x 2050mm
Weight approx.	140 kg
Protection	IP 21
Insulation class	F
Cooling	WF
Certification	CE



# Volvo Car Spot Welding Specification

## Spot welding machine

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Volvo aftermarket test procedure OK

### Base requirement

Welding controller (direct current)

Welding current minimum  
(measured at the electrodes) 9 kA

Shall have constant welding current controller

Shall have current pulsing program

Shall have up-slope control

## Spot welding gun

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Equipped with C gun

Working depth minimum 300 mm

Electrode opening minimum 100 mm

Electrode pressure minimum  
with all arm sets. 240 daN  
(measured at 6 bars air pressure)

Welding duration adjustable:  
- Low limit 0  
- High limit minimum 1,2 s

# Volvo Car Corporation Approved Spot Welder

## GYS

### Gyspot inverter 125L-C



# Gyspot Inverter 125L-C

Technical Data

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## Mains connection:

Nominal voltage	3 x 400 V, 50 Hz
Fuses	32 A (Circuit breaker)
Connecting cable	4 x 10 mm <sup>2</sup>

## Machine performance:

Nominal power at 50 % duty cycle	18 kVA
Short circuit current	12 500 A
Maximum current	16 V
Pressure min./max.	3 / 8 bar
Cooling water	3l / min.
Electrode force max.	380 daN (4 bar) 550 daN (8 bar)

## Construction:

Dimensions L x W x H	800 x 650 x 2050mm
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