



Visar 650



Visar 650 (Shield. gas version)

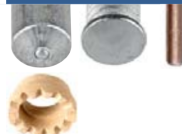


- Robust inverter unit with **single-phase** mains connection (100 to 240 V)
- Compact lightweight unit (18 kg) with high protection class (IP 44)
- Current setting range from 25 to 650 A

- Further development:**
- with **display** and **shielding gas connection**
 - **USB port** for saving and loading welding programs
 - Comprehensive **customer-specific setting options** as well as **detailed process optimisation** and control

M3 to M10 (type RD)
#4 to 7/16" (type RD)

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#4 to 7/16" (type RD)



Welding process	ARC, SC	ARC, SC
Welding material	 	   ¹⁾
Technology	Inverter	Inverter
Equipment		
Welding with ceramic ferrule	X	X
Welding with shielding gas	--	X
Process control	--	X
Display	--	Digital
Welding range	ARC: M3 to M10 (type RD), dia. 2 to 8 mm / SC: M3 to M6, dia. 2 to 6 mm	ARC: M3 to M10 (type RD), dia. 2 to 8 mm / SC: M3 to M6, dia. 2 to 6 mm

¹⁾ Welding element is not standardized according to DIN EN ISO 13918, but manufactured by the manufacturer's discretion. The welding parameters should be determined by test weldings.

Welding rate (Duty cycle ²⁾)	25 °C	100 %			50 %			35 %					
		F [studs/min]	8/min.	14/min.	18/min.	F [studs/min]	8/min.	14/min.	18/min.	F [studs/min]	8/min.	14/min.	18/min.
	t [ms]		160	160	160		160	160	160		160	160	160
	I ₂ [A]		650	650	650		650	650	650		650	650	650
	U ₂ [V]		30	30	30		30	30	30		30	30	30

²⁾ The term "duty cycle" refers to the ratio of welding duration to work pause of a stud welding unit. It describes the uninterrupted operating time of a unit over a period of 10 minutes. The largest possible studs are used in the test.
100 % duty cycle = 10 min. of continuous welding, no shutdown due to overtemperature.
50 % duty cycle = 5 min. of welding followed by 5 min. pause.
35 % duty cycle = 3.5 min. of welding followed by 6.5 min. pause.

Welding current	650 A (max.)	650 A (max.)
Current adjustment range	25 - 650 A	25 - 650 A
Welding time	5 - 200 ms (stepless)	5 - 200 ms (stepless)
Primary power	100 - 240 V, 1 phase, 50/60 Hz, 16 AT	100 - 240 V, 1 phase, 50/60 Hz, 16 AT
Primary plug	16 A, 2-pin grounded safety plug (plug type F; CEE 7/4)	16 A, 2-pin grounded safety plug (plug type F; CEE 7/4)
Connected load	3 kVA	3 kVA
Cooling type	F (temperature controlled cooling fan)	F (temperature controlled cooling fan)
IP Code	IP 44	IP 44
Dimension LxWxH (without handle)	474 x 337 x 351 mm	474 x 337 x 351 mm
Weight	18 kg	18 kg
Suitable guns	A 12, A 12-FL (welding cable not possible to extend)	A 12, A 12-FL (welding cable not possible to extend)



Order No.	Order No.
93-60-0650 (Plug E+F; Europe + China)	93-60-0652 (Plug E+F; Europe + China)
93-66-0650 (Plug B; USA, Canada + China)	93-66-0652 (Plug B; USA, Canada + China)
	Expected to be available from 07/2019
93-40-020 (Ground cable, 5 m, 25 mm ² , 2 vice grips 10")	93-40-020 (Ground cable, 5 m, 25 mm ² , 2 vice grips 10")
88-24-466 (Toolbag) (accessories and welding gun are not included)	88-24-466 (Toolbag) (accessories and welding gun are not included)

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

 Mild steel  Stainless steel  Aluminium