

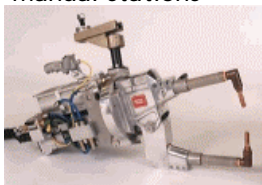


## typical applications

### projection welders



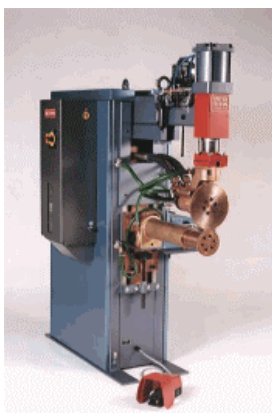
### manual stations



### robot stations



### seam welders



# WS700 welding control

data sheet



## Value-priced features and flexibility

The WS700 has been designed as an easy to use welding control timer intended for the customer who requires monitoring and quality welds. This timer has spot/pulsation/seam and roll-spot sequences with selectable phase angle or constant current control. A simple to use 4-line LCD and keypad allows up to 64 programs of weld settings to be entered. The timer can be supplied in a combination cabinet with circuit breaker and SCR to suit all machine kVA sizes.

features	benefits
easy to use	ready to go
phase angle/constant current	quality welds
integral programmer	always available
250 statement sequencer	reduce additional hardware
64 user-defined programs with program linking	store settings for different material and thicknesses
retract control	suitable for most types of gun operation
counter function	can be used for electrode maintenance
weld current/pressure monitoring	quality welds
proportional valve control	control the welding force
50 or 60 Hz operation	international
printer output	record weld quality

## options

WS98-700 PC software for programming and monitoring #03-20-03-29

ELR/1 earth-leakage relay • 2-hand start unit

16 position remote program select unit #90-80-28

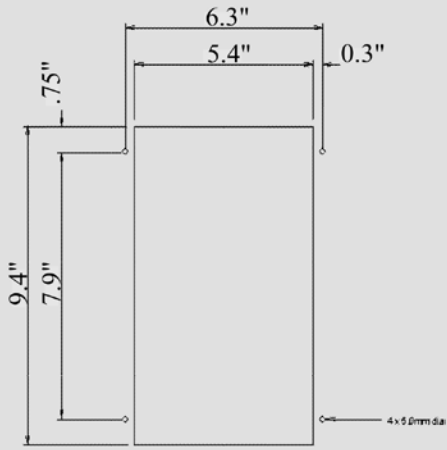
3PA/2 3-phase adapter

## configurations

WS700, cabinet and SCR combinations are shown in document 91-10-00-00-16

# WS700 welding control

## data sheet

program parameters x 64		environmental			
presqueeze	0..99 cycles	temperature			
squeeze	0..99 cycles	- operating	+32° to +122°F		
weld1 & 2, cool1 & 2, upslope/downslope	0..99 cycles	- storage	-13° to +158°F		
pulses	0..9	humidity			
hold	0..99 cycles	- operating	up to 80% (relative)		
off	0..99 cycles	- storage	10% to 90%		
pressure	0..10 V				
heat1 and heat 2	0..99 %				
current1 and current 2	0..60 kA				
i/o control		dimensions			
4 events per program synchronised to the weld sequence		height	11.5"		
full-feature 250 statement logic sequencer		width	6.75"		
16 programmable inputs		depth	1.5"		
8 programmable outputs					
monitoring parameters x 64		mounting			
current monitor	on/off	cut-out dimensions			
weld1 and 2 high/pre/low limit	0..99 %				
pre-limit count	0..99				
pressure monitor	on/off				
pressure high/low limit	0..99 %				
configuration parameters				power/synchronisation requirements	
sequence	spot/roll-spot/seam			maximum input current	1 A @ 24 V dc ±20%
retract	standard/hilift			line frequency	50/60 Hz ±1Hz
frequency	+ /hilift- 50/60 Hz				
contactor time	0..200 s			i/o ratings	
blanking	on/off	2 outputs	500 mA @ 24 V dc each		
await pressure	on/off	6 outputs	100 mA @ 24 V dc each		
toroid test	on/off	12 inputs	10 mA @ 24 V dc each (max)		
sensor	toroid/CT				
heat range	high/low	secondary monitoring options			
calibration parameters		description	part number		
toroid sensitivity	100..2000 mV/kA	3" flexible toroid	296545		
CT sec:pri ratio	1:1..199:1	6" flexible toroid	296546		
CT sec:pri offset	-1 kA..+1 kA	12" flexible toroid	296547		
pressure	2 points, kN/V	5 m extension lead (calibrated toroid)	90-90-02-09		
		5 m extension lead (uncalibrated toroid)	90-90-02-10		
counter					
actual count	0..9999				
end count	0..9999				
at end of count	stop/continue				

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