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typical applications

pedestal spot welder



miniature bench welder



robots



drum welder



MF-PAK medium frequency systems

data sheet



A better way to weld

By utilising cutting-edge power switching technology, this welding system has a high-efficiency inverter power pack and compact transformer unit, resulting in impressive welding characteristics and low power consumption. The MF-PAK range can be used in conjunction with the WS500/700/4000 timers for spot, seam and projection welding applications from 1 kVA to 1.5 MVA. Alternatively, the power pack can be provided separately for interfacing to existing BF ENTRON welding controls.

features	benefits
increased rate of heat input	reduced weld times
lower peak currents	less electrode wear
low transformer weight	smaller robots/increased speed
leading power factor	reduced maximum demand
3-phase supply	balanced load distribution
minimal design	high reliability
reduced secondary impedance	allows use of longer secondary cables
millisecond control	fast constant current response
wide range of power packs	application specific

options

WS500/700/4000 welding control; see documents 91-10-00-00-15/91-10-00-00-11/91-10-00-00-09

configurations

50/360/600/1500/2500 A models

MF-PAK medium frequency systems

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	MF-PAK 50A	MF-PAK 360W	MF-PAK 600W	MF-PAK 1500W	MF-PAK 2500W
maximum output power @ 20% duty	32 kVA	234 kVA	390 kVA	975 kVA	1.625 MVA
maximum line input voltage	480 V ac @ 50/60 Hz	480 V ac @ 50/60 Hz	480 V ac @ 50/60 Hz	480 V ac @ 50/60 Hz	480 V ac @ 50/60 Hz
maximum output current	50 A	360 A	600 A	1500 A	2500 A
maximum continuous output current	14 A	161 A	268 A	671 A	1118 A
maximum line input current per phase	29 A	209 A	347 A	866 A	1443 A
continuous rms line current per phase @ 20% duty	13 A	93 A	155 A	388 A	645 A
power factor	leading	leading	leading	leading	leading
regulation feedback	secondary or primary	secondary or primary	secondary or primary	secondary or primary	secondary or primary
current regulation accuracy	±2%	±2%	±2%	±2%	±2%
current regulation repeatability	±1%	±1%	±1%	±1%	±1%
inverter switching frequency	2/4 kHz	1/1.2 kHz	1/1.2 kHz	1/1.2 kHz	1/1.2 kHz
maximum averaging time	2 seconds	2 seconds	2 seconds	2 seconds	2 seconds
water flow rate	air cooled	5 l/min	5 l/min	8 l/min	10 l/min
maximum water inlet temperature	n/a	30° C	30° C	30° C	30° C
transformers					
40 kVA	✓	✓			
56 kVA 70:1		✓	✓		
76 kVA 54:1		✓	✓		
100 kVA 50:1		✓	✓		
170 kVA			✓	✓	
380 kVA				✓	✓

Information in the document is subject to change without notice.

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