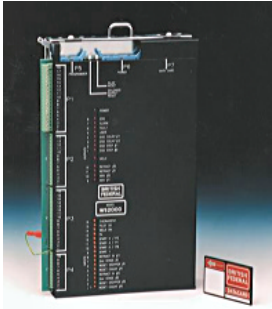




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typical systems

WS2000 + data card



CMU network system



WS2000 custom case



WS2000 welding control

data sheet



Proven features and flexibility

The WS2000 welding control is based on a high-performance 16-bit microcontroller and uses cost effective construction techniques to produce a low-cost, high-specification system that is easy to use and maintain. The standard configuration is as a fully integrated controller that includes SCR, power supply, circuit breaker and welding timer in a single compact package. The WS2000 is suitable for most types of resistance welding application including automotive, manual, projection and seam equipment.

features	benefits
single/dual gun	flexible
16 welding programs	versatile
three-interval welding sequence	suitable for coated materials
constant current or phase angle control modes	quality welding
programmable digital outputs	easy to interface with other equipment
stepping and counting	quality welding
network or local programming	for large or small installations
analogue pressure control	can be used with proportional valves
data card option	for backups and monitoring
extensive monitoring and diagnostics	pinpoint most welding problems
options	

CMU2/Starchive PC software for programming and monitoring

RS232 (printer) or RS485 (network) adapters

two-hand start

medium frequency adapter

3-phase drive card

data card

welding cable monitor

configurations

SCRs from 63 A to 250 A • circuit breakers from 63 A to 600 A • ELR

WS2000 welding control

data sheet

welding programs x 16		SCR options	
3-interval weld sequence with phase angle/constant current control		SCR type	kVA
spot/repeat/seam with long/short weld sequences		TC50/1WS	50
slope control		TC150/1WS	150
single/dual gun		TC500/1WS	500
pulsation		all SCRs are water cooled	
electrode stick detection			
analogue pressure control			
automatic retry			
programmable digital outputs			
monitoring programs x 16		circuit breakers	
low/pre/high limits for each weld interval		type	rating
fail counter			breaking capacity
		63AS	63 A
		63AH	63 A
		125AS	125 A
		125AH	125 A
		225AS	225 A
		225AH	225 A
		400AS	400 A
		400AH	400 A
		600AS	600 A
		600AH	600 A
		all circuit breakers are available with an optional ELR	
electrode programs			
	1 schedule per gun		
maximum steps	5		
welds per step	0..999		
change per step	-50..+200 % heat/current		
automatic interpolation between steps			
optional stop at end of stepping			
optional output at end of stepping			
prewarning on last step			
reset via input/programmer/CMU2			
counter		environmental	
	1 per gun	temperature	
components	0..65000	- operating	-5° to +60°C
welds per component	1..99	- storage	-25° to +70°C
optional stop at end of count		humidity	
optional output at end of count		- operating	up to 90% (relative)
reset via input/programmer/CMU2		- storage	up to 90%
i/o ratings			
4 outputs	1 A @ 24 V dc/110 V ac each		
8 outputs	500 mA @ 24 V dc/110 V ac each		
14 inputs	10 mA @ 24 V dc each (max)		
power/synchronisation requirements			
voltage	50VA @ 380/400/420/440 V ac		
line frequency	50/60 Hz ±1Hz		

Information in the document is subject to change without notice.

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