

# 厂家直销 中频点焊机 电阻点焊机 全国联保

产品名称	厂家直销 中频点焊机 电阻点焊机 全国联保
公司名称	广东德力焊接设备有限公司
价格	9800.00/台
规格参数	品牌:德力 型号:MF系列 额定功率:50KVA
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## 产品详情

### MF系列中频逆变直流电阻焊接机

MF Series Middle Frequency Inverter DC Welding Machine

### 设备主要特点

1.电阻焊是靠焊接电流通过工件而工件本身的电阻产生的高温热来熔合焊接的，因此可通过调整提高和改变焊接电流的频率来使焊接过程更加优化，焊接过程控制的更好，从而提高产品的焊接质量。

中频焊机就是在此原理基础上研发产生，普通交流工频焊机的频率是50HZ或者60HZ，而中频焊机的频率是1000HZ，时间控制精度高，功率因数达98%，无电磁感应涡流干扰，焊接质量相对提高很多。

2.但是并非所有工件的焊接电流最佳值都是1000HZ，有些需要更大一些的焊接频率，有些则需要小一些，我们公司在此基础上又研发出焊接电流频率可调可变的性能更优良的VF系列变频焊机。其原理是通过加有IGBT的脉冲宽度可调的“焊接控制器”及输出电压V和变压器匝数N可调的“焊接变压器”一起实现焊接频率可调。

3.然而这两种焊接都不会根据工件的细微变化自动调整焊接电流的大小，为了满足汽车，飞机等高端产品对焊接质量的更高需要，我们公司又在以上两种焊机的基础上加装了“动态电阻原理的中频自适应控制系统”，

该系统以恒流方式控制技术为基础，根据工件板厚、工件表面污垢及锈蚀程度，操作人员个体差异性等因素的细微变化及焊点的分流等情况，自动调整焊接过程中的每一个焊点的焊接电流，保证焊接质量和焊接效果的高度一致性。

4.中频电源及变频电源都是由三相电网供电，而不是传统的工频交流焊机的两相供电，不会造成电网的波动，同时对电网自身的波动，电压的突然升降，适应性也较强。电流输出更精确、更稳定，更节能、更高效。

5.特别适合焊接导电率较高的铝，铜材料，比较厚的工件，汽车，航天飞机，其他高端产品及行业的焊接。

### Main Application and Characteristic

1. Resistance Welding is one kind of welding technology which melt the metal material by the resistance heating energy which is generated by the welding current passing the workpiece itself. Therefore by increase or adjusting the welding current frequency, it can change and improve the welding quality.

Just basing on this theory, we develop the Middle Frequency Inverter DC Welding Machine, its welding current frequency increase to 1000HZ from common 50HZ or 60HZ.

The controlling time precision is much higher, the power factor is more than 98%, without eddy current electromagnetic induction interference, the welding quality is also improved a lot.

2. While not for all the workpiece, the current optimum value is all same as 1000HZ, some need bigger welding frequency, others need less, just because this reason, basing on the Middle Frequency Welding Technology, we also develop VF Series Variable Frequency Welding Machine which welding frequency is adjustable.

The principle is that by the added a IGBT pulse width adjustable "Welding Controller" and the output voltage of V and transformer turns N all adjustable "Welding Transformer" to fulfill the function of adjustable frequency.

3. However, these two kinds of welding methods both can not adjust welding current value of each welding automatically according to the subtle changes of workpiece.

In order to meet much higher request to welding quality, such as for the automotive, aircraft and other high-end products, we develop one kind of "Dynamic Resistance Principle Auto Self Adaptive Control System". It can install to both MF and VF Welder, by this way they can adjust the welding current automatically basing different product.

This system is based on the constant current mode control technique, according to the workpiece thickness, different dirt surface of workpiece and the corrosion degree, current shunt, the operator's individual difference factors, such as the subtle changes and solder joints, it can automatically adjust welding current during the welding process of each welding spot, ensure the consistency of the welding quality and effect.

4. Middle Frequency and Variable Frequency Welder are both powered by three-phase power, compared to the traditional AC welder two-phase power supply, will not cause the fluctuation of power supply, also can adapt suddenly lifting voltage strongly. Current output is also more accurate, more stable, more energy saving and more efficient.

5. These kinds of higher technology is specially suitable for welding higher conductive rate of material, such as aluminum, copper, silver, and so on. Also good at welding much more thicker workpiece, automobile, aerospace, and other high request products and industry.

### 技术参数

#### Technical Parameter

参数/型号 Parameter/Model	MF-50KVA	MF-90KVA	MF-150KVA	MF-170KVA	MF-250KVA
额定电源 Rated Voltage	3相(3-Phase) , 交流 ( AC ) , 380-----415----480V,50/60HZ.				
额定容量 Rated Capacity	50KVA	90KVA	150KVA	170KVA	250KVA
额度占载率 Rated Duty Cycle	50%	50%	50%	50%	50%
最大焊接电流 Max Welding Current	18500A	23500A	32000A	40500A	60500A
电极行程 Electrode Stroke	75MM		100MM		
电极臂间距 Welding Arm Spacing	260MM		320MM		
气源压力 Air Source Pressure	0.6MPa				
冷却水流量 Cooling Water Flow	16L/Minute	25L/Minute	35 L/Minute	45L/Minute	