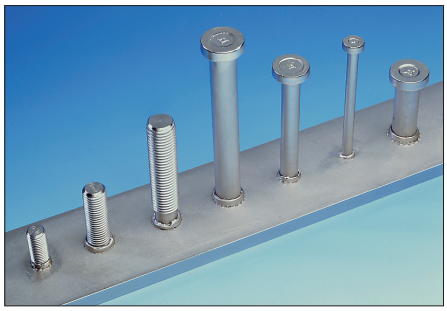
Product information
Drawn arc stud welding

BMH-22SV Stud Welder

- Safety tested
- Production controlled

The BMH-22SV stud welder serves as an energy source for welding different welding elements on metallic workpieces using the PH-5L welding gun.



BMH-22SV SOYER stud welder with integrated current indicating instrument for drawn arc stud welding

Description:

The high technical comfort of the BMH-22SV stud welder is due to the adjustability of important welding parameters. It is operated via coding switches with digitalization.

Technical data:

Welding range:	M6 - M22 or Ø 6 - 22 mm
Material:	Steel, stainless steel and heat-resistant steel (aluminium conditionally, depending on the respective requirements)
Standard gun:	PH-5L stud welding gun
Welding current:	300 - 2000 A (option: 2500 A)
Welding time:	1 - 999 ms
Welding sequence:	Studs Ø 22 mm 2 studs/min = when using a protection fuse of 63 AT > 2 studs/min = when using a protection fuse of 125 AT
Mains supply:	3 x 400 V - 50/60 Hz - 63 AT +/- 10%, short-time connecting power (1 s), 200 kVA maximum (special voltage on request)
Dimensions:	660 x 620 x 900 mm (w x h x d)
Weight:	280 kg

Subject to technical changes

Heinz Soyer Bolzenschweißtechnik GmbH
Inninger Straße 14 · 82237 Wörthsee · Germany
Tel.: +49 8153 885-0 · Fax: +49 8153 8030 · Internet: www.soyer.de / www.soyer.com

BMH-22SV-E/10.2005

Innovative Special Features of the BMH-22SV Stud Welder

The BMH-22SV SOYER stud welder with outstanding quality and performance features represents the current and future state of stud welding technology. The all-digital stud welder with computer intelligence guarantees absolutely uniform and reproducible functional sequences for optimum welding results. The modular construction, the modern design and progressive technology provide the SOYER stud welder with its unique appearance. The whole is incorporated in a useful and easy-to-service compact housing. The BMH-22SV stud welder is universally applicable and combines 3 different stud welding methods in a compact case.

- **Drawn arc stud welding**
- **Stud welding with protective gas**
- **Short-cycle drawn arc stud welding**

Additional performance features of the BMH-22SV stud welder include:

- Development and production fulfil all prescribed safety targets such as
  - the latest safety and accident prevention regulations (Act on the Safety of Technical Working Equipment)
  - electromagnetic compatibility (EMC Act)
  - European regulations (EU Directives on Machinery)
- GS/CE/S emblem for verified safety
- Certificate proof of mentioned safety targets
- Simplest operator guidance via highly sophisticated coding switches with clear symbols for all necessary parameter inputs
- Perfect, clearly arranged and simple standard value table on the front panel showing optimum setting values for all commercial stud types
- Officially approved for welding operations in an environment with increased electrical danger (S sign - EN 60974-1 and VDE 0544-T1)
- Shielding gas preflow time variably adjustable
- Preweld current time variably adjustable
- Welding time variably adjustable
- Integrated protective gas operating facilities
- Optional simple and low-cost retrofitting possibility with an automatic module for semi- and fully automatic stud feed
- Interface for signal interchange with external controls
- Constant current controller (current fluctuation control)
- Welding current adjustment in 10 A steps
- Integrated self-protecting device in case of excess temperature
- Gas and preweld current test without welding current
- Function tests without welding current for welding guns and heads to adjust the lift (lift test)
- New abrasionproof, scratch-resistant and anti-soiling plastic film coating on the front panel to protect all inscriptions even after many years of use
- Useful Plexiglas cover protecting all operating elements against water, dirt and damage
- Phase failure control
- Optical welding current control via integrated indicator
- Operating range with short-cycle drawn arc welding: M6 - M10 or ∅ 6 - 10 mm
- Operating range with shielding gas operation: M6 - M12 or ∅ 6 - 12 mm
- Operating range with drawn arc welding: M6 - M22 or ∅ 6 - 22 mm

SOYER top-of-the-range products awarded the following prizes for

Production

Quality

Technology

Industrie Forum Design Hannover

Design

Stud Manufacture

DVS ZERT DIN EN ISO 9001:2000

Quality Management

c UL us LISTED 2UD7

International Approval

Safety

CE

EC Conformity