CDi 2302

Technical Data Sheet

HBS EFFICIENT TECHNOLOGY

Inverter-Capacitor Charging Technology

Maximum welding rates
Minimum energy consumption
Minimum weight
Maximum efficiency

CDi 2302

Stud Welding Unit (with digital display)
For CD stud welding (capacitor discharge welding) according to current standards

Technische Daten	
Welding range	M3 to M8 (M10 limited), dia. 2 to 8 mm (dia. 10 mm limited)
Welding material	Mild steel, stainless steel, aluminium and brass
Welding rate	M3 = 33 studs/min. (Charging voltage 60 V) M8 = 12 studs/min. (Charging voltage 170 V) (M10 = 9 studs/min. (Charging voltage 210 V))
Capacitance	99 000 µF
Welding time	1 to 3 ms
Energy	2 400 Ws
Charging voltage	50 to 220 V (stepless voltage regulation)
Primary power	230 V/115 V, 50/60 Hz, 10 AT
Power source	Capacitor
Cooling type	F (temperature controlled cooling fan)
IP-code	IP 23
Dimension L x W x H	480 x 205 x 250 mm (without handle)
Weight	17 kg
Order No	**92-10-2302B**

General Information

Application

- Especially suitable for thin sheets (at least 0.5 mm)

Process variants

- **Contact welding**
- **Gap welding**

HBS Bolzenschweiss-Systeme GmbH & Co. KG
Felix-Wankel-Strasse 18
85221 Dachau / Germany
Phone +49 8131 511-0
Fax +49 8131 511-100
post@hbs-info.com
www.hbs-info.com

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Advantages

Features

- **Microcontroller** – for precise process times, optimal functional reliability and maximum operating convenience
- **Function monitoring** – automatic function test following power-up; monitoring of all internal system functions
- **Display of error codes** – on digital display
- **Library function** – automatic specification of charging voltage through selection of stud diameter according to welding range; fine adjustment via arrow keys

Structure

- **Extremely easy to operate**
- **Compact**
- **Robust** – Powder coated steel housing withstands rough treatment in shop and on site

Safety

- With integrated **mains filter** (protection against voltage peaks)
- **Optimal for construction sites with large mains voltage fluctuations** – use even with critical voltage supply (- 25 % + 20 %)
- **EMC test** (DIN EN 60974-10)
- **High-voltage test with log** (DIN EN 60974-1)
- Logged **capacitor forming** for quality control of the stud welding capacitors
- **Self-forming capacitors** provide a longer life period and higher reliability
- **Retriggering lock-out** – prevents welding on a welding element that has already been set
- **Thermal monitoring of charging unit and internal temperature of stud welding unit**– automatic shutdown in case of overheating
- **Temperature controlled cooling fan** – reduces noise and dust in the stud welding unit (greater system reliability)
- **Optimal protection against external interferences**
- **IP-code: IP 23**

Welding

- **Display** – infinitely adjustable power setting (charge reversal via set-point switch); easy monitoring of all functions via LED displays
- **Powerful** – built-in power reserves
- **Trouble-free changing** of welding voltage polarity possible by reconnecting welding current and ground cables
- **Use of special capacitors** (developed for stud welding)

Suitable welding guns/-heads

- **C 08**
- **CA 08**

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