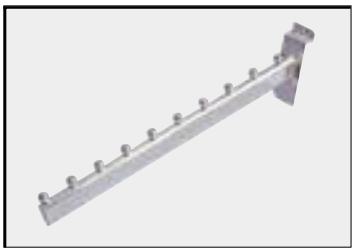
Product information
Short-cycle drawn arc stud welding

BMK-12W Stud Welder

The PH-3N welding gun is the standard gun for the BMK-12W stud welder



BMK-12W SOYER stud welder for short-cycle drawn arc welding

Description:

The high technical comfort of the BMK-12W stud welder is due to the adjustability of important welding parameters. It is operated via membrane keyboard and display. (For innovative special features, please see over).

Technical data:

Welding range:	M3 - M12 RD and/or Ø 2 - 11 mm
Material:	Steel, stainless steel and heat-resistant steel (brass and aluminium conditionally, depending on the respective requirements)
Standard gun:	PH-3N positioning welding gun
Welding current:	800 A
Welding time:	1 – 1,000 ms
Welding sequence:	up to 30 studs/min, depending on stud diameter
Mains supply:	3 x 400 V - 50/60 Hz - 32 AT, other voltage on request
Dimensions:	360 x 325 x 500 mm (w x h x d)
Weight:	48 kg

Integrated protective gas operating facilities and optional equipment for semi- and fully automatic stud feed

Subject to technical changes

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Innovative Special Features of the BMK-12W Stud Welder

The BMK-12W 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 in useful and easy-to-service compact housing, the modern design and progressive technology provide the SOYER stud welder with its unique appearance. The BMK-12W stud welder is universally applicable and combines 3 different stud welding methods in a sturdy compact case.

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

Additional performance features of the BMK-12W 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)
- Certificate proof of mentioned safety targets
- Simplest operator guidance via highly sophisticated membrane keyboard with clear symbols for all necessary parameter inputs
- GS/CE/S emblem for verified safety
- Shielding gas preflow time variably adjustable
- Preweld current time variably adjustable
- Welding time variably adjustable
- Integrated gas operating facilities
- Easy to carry and ideal for mobile application
- 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
- LED display panel with control function of all operational states
- Integrated self-protecting device in case of excess temperature or excessive welding sequence
- Computer check on operability and simulated program run of all setting parameters on stud welder and gun without welding current
- New abrasionproof, scratch-resistant and antisoiling plastic film coating on the front panel to protect all inscriptions even after many years of use
- Table on the front panel indicating standard values for all common stud types and diameters
- Operating range with short-cycle drawn arc welding:
  M3 - M12 RD or Ø 2 - 11 mm
- Operating range with shielding gas operation:
  M3 - M12 RD or Ø 2 - 11 mm
- Operating range with drawn arc welding:
  M3 - 12 RD or Ø 2 - 11 mm

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

Production

Quality

Technology

Industrie Forum Design Hannover
Design

DVS ZERT DIN EN ISO 9001:2000
Quality Management

c UL us LISTED 2UD7
International Approval

TÜV Rheinland GS geprüfte Sicherheit
Safety

CE
EC Conformity