



ROCKER ARM WELDERS

- > Pedestal Welders
 - > Rocker Arm Spot Welders
 - > Press-Type Spot Welders
 - > Press / Projection Welders
- > Maintenance Welders
- > HVAC Duct Welders

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... on all **IN-STOCK TECNA** EQUIPMENT and ACCESSORIES

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4943 Driscoll Road
Warrensville Heights, OH 44146
Main: 844-44-TECNA
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TECNA Foot-Operated 16 – 25 kVA Rocker Arm Spot Welders from TECNADirect.com

TECNA 4640, 4641, 4642, 4643, 4644



TECNA foot-operated rocker arm spot welders are designed to meet every need of spot welding. The new stationary ergonomic frame designed by TECNA helps to facilitate the operator's work. In addition, the control unit has been positioned frontally to allow the operator to view the welding data even during the working cycle.

IN-STOCK TECNA Models

We currently stock the **WTR-4642** (20 kVA) and the **WTR-4644** (25 kVA) TECNA foot-operated rocker arm spot welders. Furthermore, additional TECNA models **WTR-4640** (16 kVA), **WTR-4641** (20 kVA) and **WTR-4643** (25 kVA) are available upon request.



TECNA 16 – 25 kVA Rocker Arm Spot Welder Features

- TE101 controls, mounted on the front of the machine.
- Water-cooled transformer, arms and electrodes. Epoxy resin coated transformer for maximum protection.
- Adjustable electrode stroke enables access to a greater range of parts.
- Chromium-copper electrode holders are designed for long life and heavy-duty service. May be mounted at 12° and 90° positions in the arm. Optional universal-style arms are available * **WSI EXCLUSIVE** * for 1" diameter electrode holders, and for mounting the electrode holders at 30° and 90°.
- Adjustable throat depth enables maximum flexibility.
- Ergonomic frame for long term operation in production environments.
- * **WSI EXCLUSIVE** * standard low-profile lower holder enables accessing parts as small as 3" diameter.
- Single foot pedal.

REQUEST A QUOTE, or give us a call at **888-44-TECNA**.

Models and Specifications

(Click on the TECNA model numbers below for more detailed information)

SPECIFICATIONS	WTR-4640N	WTR-4641N	WTR-4642N	WTR-4643N	WTR-4644N
Foot or air-operated	Foot-Operated	Foot-Operated	Foot-Operated	Foot-Operated	Foot-Operated
Power @ 50% duty cycle	16 kVA	20 kVA	20 kVA	25 kVA	25 kVA
Max power	35 kVA	48 kVA	39 kVA	68 kVA	55 kVA
Secondary voltage	3.4 V	4 V	4 V	4.6 4 V	4.6 4 V
Maximum short circuit current	12500 A	14500 A	12000 A	18000 A	14500 A
Maximum welding current on aluminum	-	-	-	16.3 kA	-
Maximum welding current on steel	10 kA	11.6 kA	9.6 kA	14.4 kA	11.6 kA
Thermal current @ 100%	3.3 kA	3.5 kA	3.5 kA	3.8 kA	3.8 kA
Supply voltage (@ 60Hz)*	220 or 440 V	220 or 440 V	Dual Voltage 220 / 440 V	220 or 440 V	Dual Voltage 220 / 440 V
Delayed fuses @ 220 VAC	80 A	80 A	80 A	100 A	100 A
Delayed fuses @ 440 VAC	30 A	40 A	40 A	50 A	50 A
Primary cables (up to 30m)	10 mm ²	10 mm ²	10 mm ²	16 mm ²	16 mm ²
Insulation class	F	F	F	F	F
Compressed air supply (psi / bar)	-	-	-	-	-
Air consumption per 1000 spots @ 94 psi (650kP / 6.5 bar)	-	-	-	-	-
Arm minimum length	9.0 in (230 mm)	9.0 in (230 mm)	15.0 in (380 mm)	9.0 in (230 mm)	15.0 in (380 mm)
> Max electrode force	528 lbs. (240 daN)	528 lbs. (240 daN)	330 lbs. (150 daN)	528 lbs. (240 daN)	330 lbs. (150 daN)
> Working stroke	0.3 - 1.7 in. (8 - 44 mm)	0.3 - 1.7 in. (8 - 44 mm)	0.4 - 2.4 in. (10 - 60 mm)	0.3 - 1.7 in. (8 - 44 mm)	0.4 - 2.4 in. (10 - 60 mm)
Arm maximum length	21.7 in. (550 mm)	21.7 in. (550 mm)	27.6 in. (700 mm)	21.7 in. (550 mm)	27.6 in. (700 mm)
> Max electrode force	209 lbs. (95 daN)	209 lbs. (95 daN)	176 lbs. (80 daN)	209 lbs. (95 daN)	176 lbs. (80 daN)
> Working stroke	0.6 - 3.3 in. (15 - 85 mm)	0.6 - 3.3 in. (15 - 85 mm)	0.6 - 4.1 in. (15 - 105 mm)	0.6 - 3.3 in. (15 - 85 mm)	0.6 - 4.1 in. (15 - 105 mm)
Short circuit current with arms @ MAX length	8.4 kA	10 kA	8.8 kA	13 kA	10.5 kA
Water cooling @ 36 psi (250 kP / 2.5 bar)	1 gpm (3.8 lpm)	1 gpm (3.8 lpm)	1 gpm (3.8 lpm)	1 gpm (3.8 lpm)	1 gpm (3.8 lpm)
Minimum water pressure	36 psi (2.5 bar)	36 psi (2.5 bar)	36 psi (2.5 bar)	36 psi (2.5 bar)	36 psi (2.5 bar)
Aerial noise produced	70 dB (A)	70 dB (A)	70 dB (A)	70 dB (A)	70 dB (A)
MEASURED CONDITIONS					
Working stroke	0.79 in. (20 mm)	0.79 in. (20 mm)	0.79 in. (20 mm)	0.79 in. (20 mm)	0.79 in. (20 mm)
Welding time	21 cycles	17 cycles	26 cycles	14 cycles	20 cycles
Welding current	9.4 kA	11 kA	9 kA	13.5 kA	11 kA
Working rating (welds per minute)	10 # / min	10 # / min	10 # / min	10 # / min	10 # / min
Net weight	297 lbs. (135 kg)	315 lbs. (143 kg)	321 lbs. (146 kg)	319 lbs. (145 kg)	326 lbs. (148 kg)
Arms	36 in. (914.4 mm)	40 in. (1016 mm)	40 in. (1016 mm)	40 in. (1016 mm)	40 in. (1016 mm)
Electrode holders	0.75 in. (19 mm)	0.87 in. (22 mm)	0.87 in. (22 mm)	0.87 in. (22 mm)	0.87 in. (22 mm)
Electrode taper size	4RW/1MT	4RW/1MT	4RW/1MT	4RW/1MT	4RW/1MT

*May be supplied capable of operating on other voltages/frequencies. Please ask for details.

TECNADirect.com by Weld Systems Integrators

TECNADirect.com, a division of **Weld Systems Integrators**, maintains an inventory of TECNA welding equipment, including **rocker arm spot welders**, **press-type spot welders** and **press / projection welders**. We also carry a complete line of **bench welders**, **portable spot welding guns**, **tool balancers** and **accessories**. Contact us TODAY at 844-44-TECNA, and ask about our **IN-STOCK** inventory at our Warrensville Heights, Ohio location.

