

**KOCO**

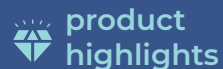
More than just  
stud welding.

**Strength  
that leaves  
its mark.**



**ELOTOP +25** *Grizzly*

**Efficient quality assurance.  
Active process control.**



## product highlights

# ELOTOP + 25 *Grizzly*

- + Self-diagnostics for: Overtemperature, short circuit in control cable, mains phase failure and pilot current fault
- + Fully-controlled thyristor bridge
- + Microprocessor-controlled
- + Constant current control
- + Retriggering safety device
- + Mains connection special voltages (V): optional
- + Control unit protected against dust and moisture
- + Steel housing, powder-coated
- + Stud counter
- + Connection of automatic components: optional
- + Menu navigation: multilingual
- + Parameter library for head bolts
- + Process control based on current, voltage and lift curves; evaluation based on mean values and deviations
- + Parameter documentation/saving of process data and curves in 'CSV format'; USB port
- + Save error logs for service purposes
- + Support for all existing and future KÖCO lifting systems
- + Display of protrusion in conjunction with a stud welding gun with measuring sensors
- + Display lock
- + Can be expanded in the future with additional modules such as LTE, automation interface, etc.

\* only applies to standard 400V configuration with supplied cable/mains plug (without extension of the mains and welding cables; larger cable cross-sections are required for  $\leq 230V$  mains voltage)

\*\* to be interpreted individually, local regulations and conditions must be observed

a: unless otherwise stated, for all available voltages

b: The permissible lengths for mains and welding cable extensions can be increased if welding is carried out at a lower current than specified. If the power supply is weak, it may not be possible to fully utilise the maximum lengths of the mains and welding cable extension together.

## TECHNICAL DATA<sup>a</sup>

## ELOTOP + 25 *Grizzly*

|                                                                                         |                                          |
|-----------------------------------------------------------------------------------------|------------------------------------------|
| Stud diameter (Ø) for stud welding with ceramic ring                                    | 6-25 mm                                  |
| Stud diameter (Ø) for short cycle stud welding                                          | -                                        |
| Stud diameter (Ø) for gas-shielded stud welding                                         | 6-16 mm                                  |
| Protective gas equipment                                                                | optional                                 |
| Continuous current setting range                                                        | 300-2600 A                               |
| Continuous time setting range                                                           | 100-2000 ms                              |
| Shielding gas pre-flow time (ms)                                                        | 100-2000 ms                              |
| Shielding gas post-flow time (ms)                                                       | 100-1000 ms                              |
| Storage option (parameter sets)                                                         | 2x20                                     |
| Max. studs/min.                                                                         | 55/min at 6 mm Ø *<br>7/min at 25 mm Ø * |
| Mains connection                                                                        | Three-phase<br>current 50/60 Hz          |
| Mains plug (400 V) CEE                                                                  | 125 A                                    |
| Appliance connection cable (400V) with 5 m length                                       | 16 mm <sup>2</sup>                       |
| Appliance connection cable (208V/230V/460V)                                             | - **                                     |
| Slow-blow mains fuse (400 V)                                                            | 125 A                                    |
| Slow-blow mains fuse for special voltage devices (208 V / 230 V / 460 V)                | 200 A/150 A/100 A **                     |
| Mains power consumption (P <sub>1max</sub> )                                            | 225 kVA                                  |
| Max. welding cable length with specified welding current and cross-section <sup>b</sup> | 2000 A / 50 m<br>at 120 mm <sup>2</sup>  |
| Mains voltage tolerance                                                                 | -15/+6 %                                 |
| Protection type                                                                         | IP 23                                    |
| Protection class                                                                        | I                                        |
| Cooling type                                                                            | AF                                       |
| Storage temperature range                                                               | -20 °C to +70 °C                         |
| Relative humidity                                                                       | up to 50 % at 40°C<br>up to 90 % at 20°C |
| Housing dimensions (L x W x H) mm                                                       | 920x610x975                              |
| Castor wheels/fixed wheels                                                              | 2/2                                      |
| Handle                                                                                  | 1                                        |
| Crane eye                                                                               | 2                                        |
| Weight (kg)                                                                             | approx. 490 kg                           |
| Welding gun connections                                                                 | 2                                        |
| Earth sockets                                                                           | 4                                        |