

MULTI GRADE STEELS
MULTI PHASENSTÄHLE

PROTON

+



VAS 6249 VAS 6249L

FAN

SPOT WELDING PERFECTED

DEVELOPED, TESTED & EXAMINED
FOR THE CAR INDUSTRY



BETTER COOLING
AND UNSURPASSABLE



WORKSHOP
EQUIPMENT

VAS 6249 12.000 A*
VAS 6249 L 9.000 A*

RELIABLE PROCESS, TIME SAVING THROUGH
THE SUPERIOR WATER COOLING CIRCLE
MODULE. HIGH PERFORMANCE INVERTER.
SELF EXPLANATORY AND CLEAR CONTROL
PANEL WITH MEMORY KEY.

WORKSHOP FRIENDLY: ENCLOSED
ERGONOMIC DESIGN. NO UNNECESSARY
EXPOSED EQUIPMENT OR CABLES



*)Actual, continuous power at the tip of the electrodes at
constant load. Tested & confirmed in practice and endurance tests.

NEW COMBINATIONS OF MATERIALS
IN CAR ENGINEERING DETERMINE
THE FUTURE OF AUTOBODY REPAIR
SOLUTIONS.

"The welding spot must be of the same
quality as in the car production line."
This binding criteria is the unique
strength of the FAN **PROTON I / I+**
Generation

PRECISE SPOT WELDING CONNECTIONS
OF MULTI GRADE STEELS (DUAL / TRIP),
MATERIALS OF DIFFERENT THERMAL
CONDUCTIVITY AND GALVANIZED SHEETS.

FAN 36
months warranty

INCREASED WELDING POWER – PERFECTLY ENGINEERED: CONTROLLED WATER COOLING RIGHT TO THE TIP

- ➔ **COOLING** of the individual components is of vital importance for productivity and the quality of the welding spot. The fully integrated cooling system, developed by FAN, guarantees the precise cooling of **THE WHOLE MACHINE RIGHT TO THE ELECTRODE CAPS**. This ensures the maximum quality of the welding spot and a long lifespan for the electrodes.

OVERHEATING IS IMPOSSIBLE

The clever water re-cooling system FK 4.000 R of the PROTON I / I+ manages constant temperatures and includes the welding cable, connections, rectifier, high performance transformer, tongs, impact point pack and earthing hose pack.

CONSISTENT AND SECURED WELDING PROCESS UNDER CONSTANT LOAD

Consistently high welding current power – guaranteed by the high performance inverter (as used in car assembly). No drop in performance! Buffer circuit compensation levels out drops in mains current immediately.

+++ Continuous acoustic and optical monitoring of the welding spot – sensitive to varnish residue, low electrode pressure or electrode contamination.

PROCESS RELIABILITY & TIME SAVING

Exact reproduction of any welding spot possible due to the built-in digital processor. The memory key recalls all preset parameters. Time and energy frequencies can be programmed according to set factory requirements. These frequencies can be preset exactly for any body and sheet strength.



PROTON I I+

Welding arm set:



Celect III **0774-100**
L = 200 mm



Celect III **0774-102**
L = 400 mm



Celect III **0774-105**
L = 250 mm, with arched electrode



Celect III **0774-106/07**
wheel arch / roof



Celect III **0774-101**
L = 300 mm



Celect III **0774-103**
L = 350 mm



Celect III **0774-104**
L = 525 mm



Celect III **0774-141** **0774-143**
electrode caps

Technical data

| | PROTON I VAS 6249 L | PROTON I+ VAS 6249 |
|------------------------------------|----------------------------|---------------------------|
| Supply voltage | 3 x 400 V | 3 x 400 V |
| Frequency inverter | 1,000 Hz (2,000 Hz) | 1,000 Hz (2,000 Hz) |
| Max. welding current | 9,000 A DC | 12,000 A DC |
| Max. welding output | 83 kVA | 114 kVA |
| Dimensions l/w/h (without trolley) | 690 / 290 / 475 | 690 / 290 / 475 |
| Weight (without trolley) | 58 kg | 58 kg |
| Mains fuse protection | 32 / 40 / 50 A | 32 / 40 / 50 A |
| Welding current | 9 kA | 12 kA |
| Open circuit voltage | 15 V | 16 V |
| Insulation class | I.C.I.F | I.C.I.F |
| Protection class | IP 21 | IP 21 |
| Cooling | AF | AF |

Spot welding tongs pneumatic, water cooled

| | PROTON I VAS 6249 L | PROTON I+ VAS 6249 |
|------------------------|-------------------------------------|-------------------------------------|
| | Celect II to 300 KN | Celect II to 300 KN |
| | Celect Easy to 350 KN | Celect Easy to 350 KN |
| | Celect III to 480 KN | Celect III to 480 KN |
| Welding cable / length | 150 mm ² / 2.5 m (3.0 m) | 150 mm ² / 2.5 m (3.0 m) |
| Operating pressure | 6-10 bar | 6-10 bar |
| Electrodes | 10 / 12 / 14 mm | 10 / 12 / 14 mm |

Cable sets water cooled

| | PROTON I VAS 6249 L | PROTON I+ VAS 6249 |
|----------------------|------------------------------|------------------------------|
| Gun cable / length | 150 mm ² / 2.30 m | 150 mm ² / 2.30 m |
| | 150 mm ² / 2.80 m | 150 mm ² / 2.80 m |
| Earth cable / length | 150 mm ² / 2.30 m | 150 mm ² / 2.30 m |
| | 150 mm ² / 2.80 m | 150 mm ² / 2.80 m |

Incl. in package

| |
|---|
| Inverter spot welding machine |
| Trolley |
| Cable Holder |
| Spot welding tong: pneumatic, water cooled: Celect Easy |
| Gun cable 0601-721 / Earth cable 0601-62 2.30 m, water cooled |
| Cooling system FK 4.000 R |
| Pull-hammer |
| Welding arm set incl. electrode caps, water cooled, consisting of art. no.: 0774-100, 0774-102, 0774-105, 0774-106/07 |

Servicebox

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|--|
| Single-Side electrode |
| Carbon shrinking electrode |
| Shrinking electrode |
| Pick-up electrode for washers studs T-pins |

FAN 36
months warranty

FAN AUSTRIA GMBH
Spot welding &
auto-body-repair
technologies

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