



**SA Welding  
cv-characteristic**

**Welding Rectifier**

**GTH 1002**

**Welding rectifier (thyristor controlled) for submerged-arc welding up to 1,000 A direct current at permanent operation with constant-voltage characteristic, suitable especially for mechanised, semi-automated and automated welding processes in connection with Kjellberg welding automates of the KA series. For the heaviest application in tank and boiler construction, bridge construction, shipbuilding and industrial building.**



**Main features**

- Stationary operation
- Welding current steplessly adjustable.
- Remote control and contactless remote switch for high switching frequencies by means of the welding automates.
- Constancy of the adjusted welding values of  $\pm 1\%$  at mains voltage fluctuations of  $\pm 10\%$  and at internal temperature variations, therefore excellently suitable for extremely long welding seams at large workpieces.
- Excellent ignition properties.
- Very smooth arc for a stable welding process.
- Large analogue displays separate for welding current and welding voltage.
- Remote control connection for various remote controls.
- Two parallel welding cable connections M16 each.
- 4 lifting eyes.
- Dust-proof electronics.
- Option: Interface for external control (robot, guiding system, etc.).



**Technical data:**

<b>Mains voltage</b>	3 x 400 V -10%/+10% 50 Hz
<b>Connecting power / 100 % duty cycle</b>	78 kVA
<b>Fuse, slow (B characteristic)</b>	125 A
<b>Welding current range 100 % duty cycle</b>	100 A/19 V - 1,000 A/44 V 1,000 A
<b>Open-circuit voltage max.</b>	65 V
<b>Protection class</b>	IP 21
<b>Mass</b>	440 kg
<b>Dimensions L x W x H</b>	1,110 x 820 x 1,000 mm

- EN 60974-1, VDE 0544, VBG 15 (UVV 26.0) and CE sign, produced according to DIN EN ISO 9001
- S sign, applicable to welding jobs at work places with increased electrical endangment

Art. no.	Name
.11.903.102A	<b>Welding rectifier GTH 1002 (power source for SAW) in connection with setpoint preset by welding automat</b>

01/2016