

# TECNA



# DIRECT

INDUSTRIAL RESISTANCE WELDERS AND TOOL BALANCERS



## 6010 - 6013 SERIES

25kVA MFDC Rocker Arm Spot Welders

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# TECNA<sup>®</sup>

Advanced Resistance Welding Systems and Balancers



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of TECNA Resistance Welders  
and Tool Balancers

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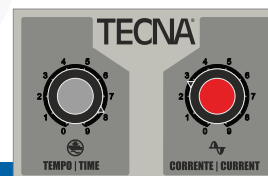
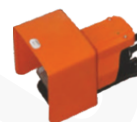
WELD  
SYSTEMS  
INTEGRATORS, INC.

## Rocker Arm Spot Welders: 25 kVA

TECNA 6010-6013 Series foot and air-operated 25 kVA MFDC rocker arm spot welders uses inverter technology. Inverters offer advantages over single-phase AC, including greater welding quality and precision, more efficient use of electricity, smaller size, and less electrical loss due to impedance (power savings). These benefits have encouraged Automotive manufacturers to become a major user of inverter technology.

TECNA 6010-6013 Series foot and air-operated 25 kVA MFDC rocker arm spot welders includes TIME and CURRENT controls, mounted on the front of the machine.

Powered by Weld Systems Integrators, TECNADirect.com is stocking master distributor of TECNA industrial resistance welders and tool balancers. We stock, sell, repair and support our entire line of TECNA inventory.



## TECNA 6010-6013 SERIES WELDER FEATURES

- Adjustable arms allowing a better working flexibility.
- Chrome-copper electrode-holders for long life and heavy-duty service, designed for straight and angled fitting.
- Adjustable electrode stroke.
- Epoxy resin coated transformer.
- Water-cooled transformer, arms and electrodes.
- Easy and intuitive welding control unit with TIME and CURRENT manually adjustable by potentiometer.

### FOOT-OPERATED WELDERS - Models 6010 / 6011

- Adjustable electrode force; a microswitch starts the welding cycle when the desired pre-set value is reached.
- The foot pedal is adjustable in length.

### AIR-OPERATED WELDERS - Models 6012 / 6013

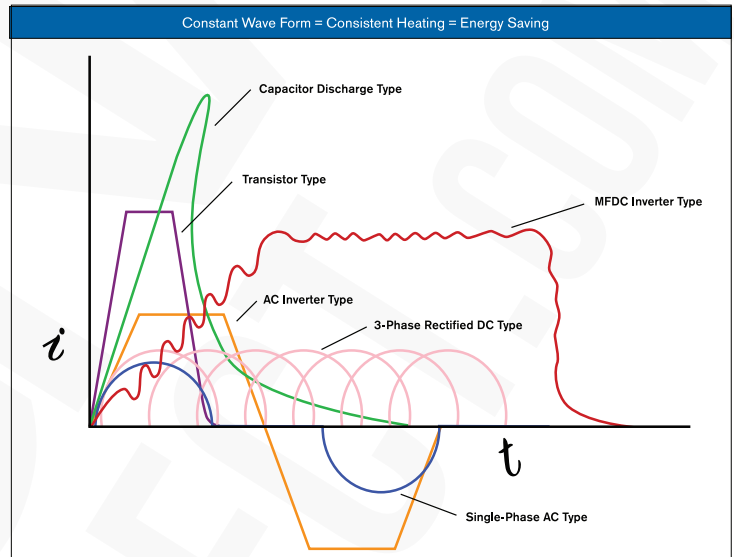
- Pneumatic commands and compressed air pressure gauge have been placed at the top for easier adjustment and reading.
- Air-operated lube-free cylinder eliminates oil mist.
- Electrode force adjustment through air filter reducer and gauge.
- Semi-automatic drainage system.
- Shock absorber for cylinder's end of stroke and air discharge silencers.
- The foot pedal allows the normal single spot use to tighten and weld the pieces correctly positioned.

MFDC Inverter technology has advantages over traditional single-phase AC welding, including improved precision, more efficient use of electricity, smaller size, and less electrical loss due to impedance.



## The main advantages of a TECNA MFDC Systems over traditional AC systems:

- Excellent precision on the current control. In fact, the system checks the current every 500 microseconds.
- Reduction of operating and maintenance costs. In order to obtain the same welding results, a traditional AC system would require a higher installed power and a higher current withdrawn from the mains. Moreover, thanks to reduced welding times, the service to the electrodes is reduced, hence a higher productivity.
- Compared to AC welder, the medium frequency system also produces a more efficient heat supply and it allows to obtain the same welding results with shorter time reducing the heat dispersed around the welding nugget (HAZ heat affected zone) and avoiding to alter the material features.
- A balanced mains load and a total independence from the mains frequency if compared with AC welders.
- It always keeps constant the welding current even in presence of changes in the mains voltage, in impedance of the secondary circuit, in the conditions of the welding tools and in the superficial conditions of the material to be welded.



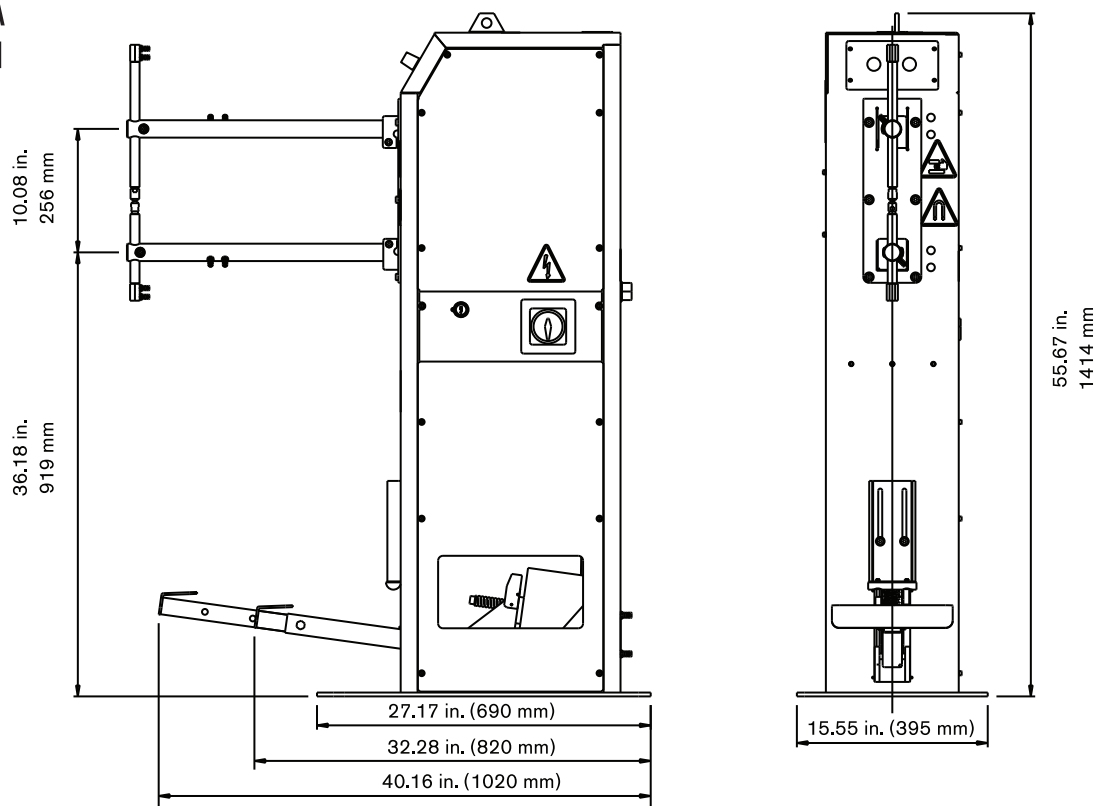
In conclusion, TECNA MFDC - medium frequency systems summarized as follows:

Operating costs reduction. Lower energy consumption. Higher productivity. Remarkable control of the welding resulting in a higher final quality. Larger application fields which make the same machine suitable to carry out different types of jobs.

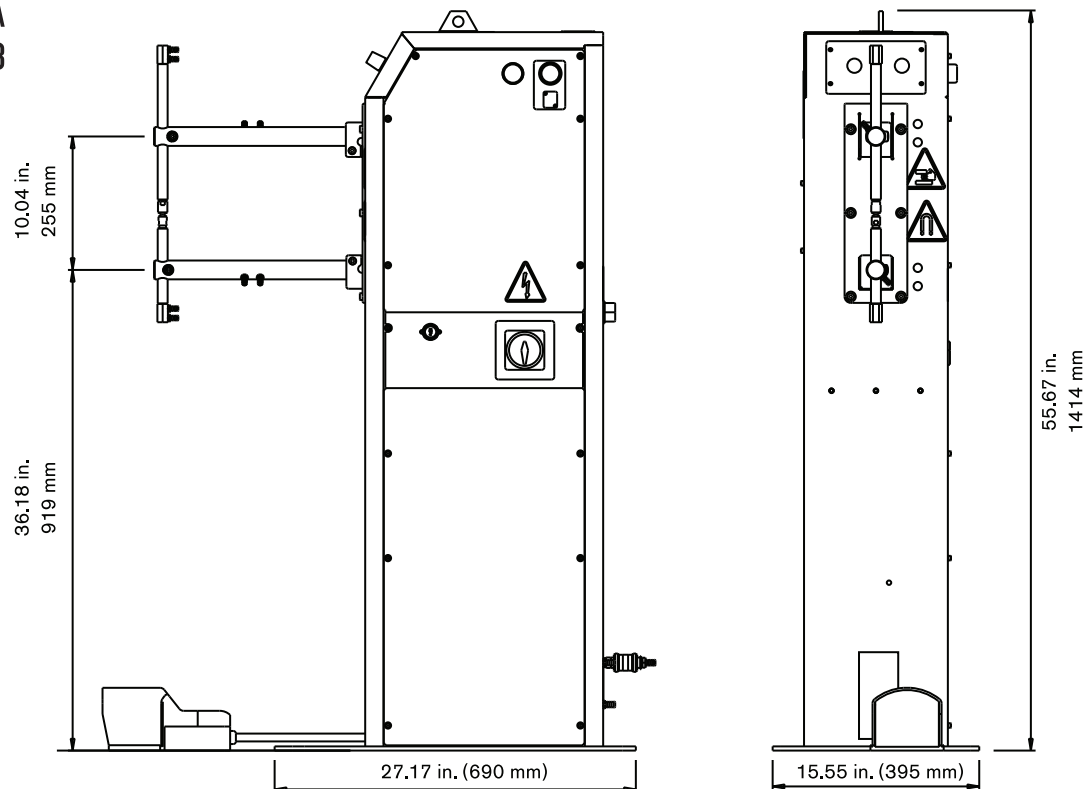
SPECIFICATIONS		WSI-TECNA 6010	WSI-TECNA 6011	WSI-TECNA 6012	WSI-TECNA 6013
Foot or air-operated		Foot	Foot	Air / Pneumatic	Air / Pneumatic
Nominal power at 50%	kVA	25	25	25	25
Maximum welding power	kVA	118	118	118	118
No load secondary voltage	V	9.8	9.8	9.8	9.8
Maximum short circuit current	kA	12	12	12	12
Supply	*V	400	400	400	400
	*Hz	50	50	50	50
Delayed fuses	A	35	35	35	35
Cables section L=30 m	in.	0.02	0.02	0.02	0.02
	mm	10	10	10	10
Insulation class		F	F	F	F
Compressed air	bar	-	-	6.5-10	6.5-10
Consumption for 1000 spots	N/m3	-	-	4.3	4.3
Min. electrodes throat depth	in.	9.06	14.96	9.06	14.96
	mm	230	380	230	380
Max. electrode force (6 bar)	daN	240	150	150	165
Electrode stroke	in.	0.31-1.73	0.39-2.36	0.31-1.73	0.39-2.36
	mm	8-44	10-60	8-44	10-60
Max. throat depth	in.	21.65	27.56	21.65	27.56
	mm	550	700	550	700
Max. electrode force (6 bar)		95 daN	80 daN	115 daN	90 daN
Electrode stroke	in.	0.59-3.35	0.59-4.13	0.59-3.35	0.59-4.13
	mm	15-85	15-105	15-85	15-105
Water cooling	l/min	5	5	5	5
Min. water pressure	bar	2.5/4	2.5/4	2.5/4	2.5/4
Net weight (approx.)	lbs.	319.67	330.69	319.67	330.69
	kg	145	150	145	150
Arms	in.	1.57	1.57	1.57	1.57
	mm	40	40	40	40
Electrode holders	in.	0.87	0.87	0.87	0.87
	mm	22	22	22	22
Electrode cone	in.	0.58	0.58	0.58	0.58
	mm	14.8	14.8	14.8	14.8

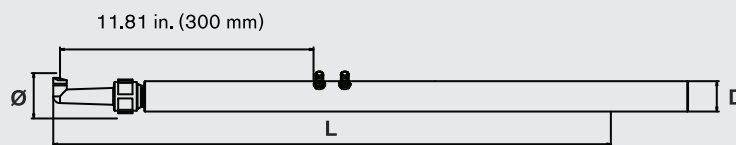
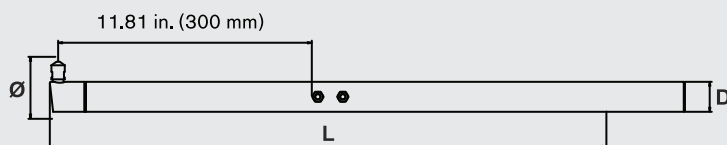
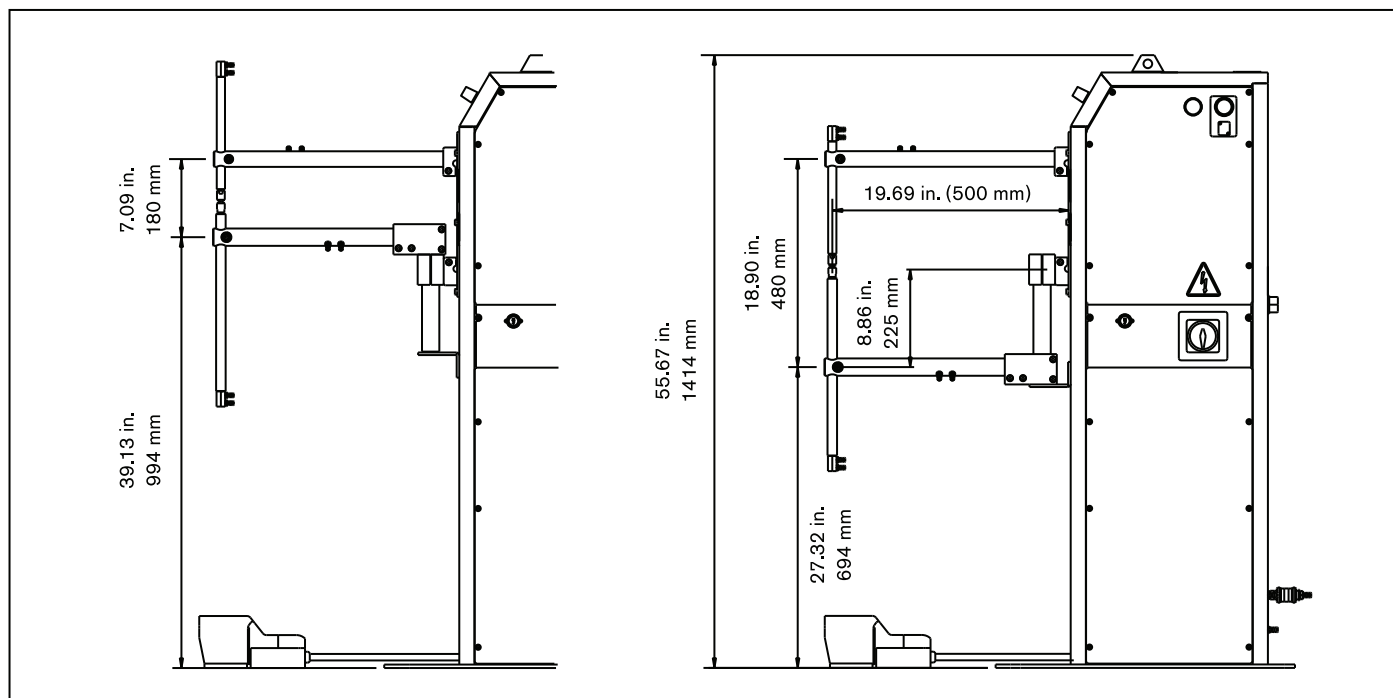
\* Different voltages and frequencies on demand

**WSI-TECNA  
6010 / 6011**



**WSI-TECNA  
6012 / 6013**



**Item 4564**

Reduced-size brass arm with tip.

- Ø 2.68 in. (68 mm)

**Item 4565**

Reduced-size brass arm with ring nut and frontal electrode.

- Ø 1.97 in. (50 mm)

**Item 4566**

Reduced-size brass arm with tip

- L = 14.96-27.56 in. (380-700 mm) | D = 1.58 in. (40 mm)

**Item 4567**

Reduced-size copper arm with tip

- L = 14.96-27.56 in. (380-700 mm) | D = 1.58 in. (40 mm)

**Item 4568**

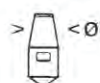
Reduced-size copper arm with ring nut and frontal electrode

- L = 14.96-27.56 in. (380-700 mm) | D = 1.58 in. (40 mm)

**Item 4569**

Reduced-size brass arm with ring nut and frontal electrode

- L = 14.96-27.56 in. (380-700 mm) | D = 1.58 in. (40 mm)



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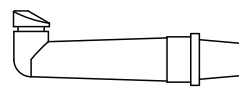
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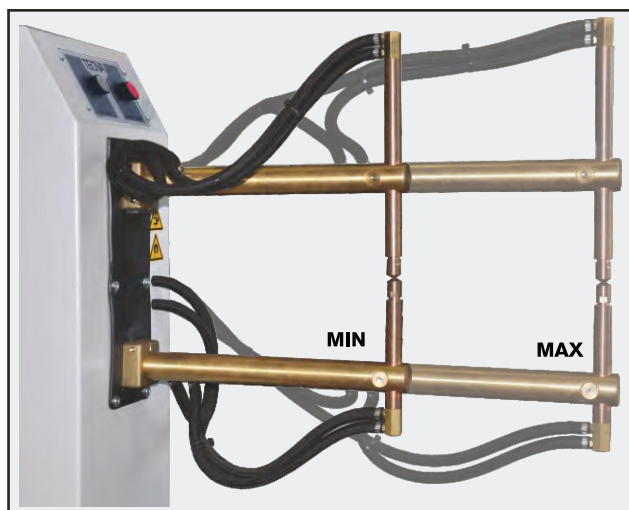
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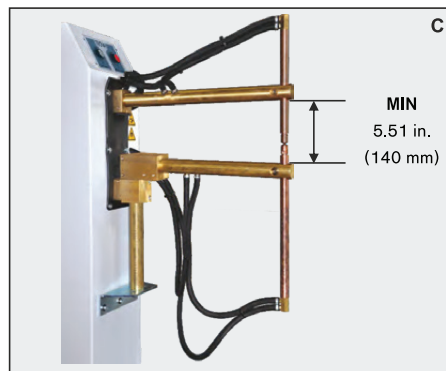
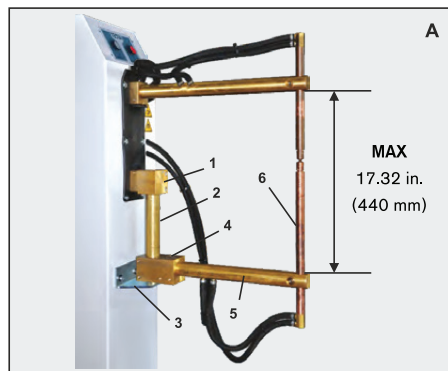
4729



Adjustable arms depth 12.60 in. (320 mm) according to the working requirements.

#### Item 4618

Adjustable arms large gap assembly. (parts 1-2-3-4-5-6).



A = Max. gap | B = Intermediate gap | C = Min. gap



Industrial Resistance Welders and Tool Balancers



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