



Visar 650



- Robust inverter unit with **single-phase** mains connection (100 to 240 V)
- Compact lightweight unit (18 kg) with high protection class (IP 44)
- Current setting range from 25 to 650 A

M3 to M10 (type RD)
#4 to 7/16" (type RD)



Visar 650 (Shield. gas version)



- Further development:**
- with **display** and **shielding gas connection**
 - **USB port** for saving and loading welding programs
 - Comprehensive **customer-specific setting options** as well as **detailed process optimisation** and control

M3 to M10 (type RD)
#4 to 7/16" (type RD)



Welding process	ARC, SC			ARC, SC			
Welding material							
Technology	Inverter			Inverter			
Equipment							
Welding with ceramic ferrule	X			X			
Welding with shielding gas	--			X			
Process control	--			X			
Display	--			Digital			
Welding range	ARC: M3 to M10 (type RD), dia. 2 to 8 mm / #4 to 7/16" (type RD), dia. 14 ga to 5/16" SC: M3 to M6, dia. 2 to 6 mm #4 to 1/4", dia. 14 ga to 1/4"			ARC: M3 to M10 (type RD), dia. 2 to 8 mm / #4 to 7/16" (type RD), dia. 14 ga to 5/16" SC: M3 to M6, dia. 2 to 6 mm #4 to 1/4", dia. 14 ga to 1/4"			
Welding rate (Duty cycle ²⁾)	25 °C	100 %	50 %	35 %	100 %	50 %	35 %
	F [studs/min]	8/min.	14/min.	18/min.	8/min.	14/min.	18/min.
	t [ms]	160	160	160	160	160	160
	I ₂ [A]	650	650	650	650	650	650
	U ₂ [V]	30	30	30	30	30	30
<small>²⁾ The term "duty cycle" refers to the ratio of welding duration to work pause of a stud welding unit. It describes the uninterrupted operating time of a unit over a period of 10 minutes. The largest possible studs are used in the test. 100 % duty cycle = 10 min. of continuous welding, no shutdown due to overtemperature. 50 % duty cycle = 5 min. of welding followed by 5 min. pause. 35 % duty cycle = 3.5 min. of welding followed by 6.5 min. pause.</small>							
Welding current	650 A (max.)			650 A (max.)			
Current adjustment range	25 - 650 A			25 - 650 A			
Welding time	5 - 200 ms (stepless)			5 - 200 ms (stepless)			
Primary power	100 - 240 V, 1 phase, 50/60 Hz, 16 AT			100 - 240 V, 1 phase, 50/60 Hz, 16 AT			
Primary plug	16 A, 2-pin grounded safety plug (plug type F; CEE 7/4)			16 A, 2-pin grounded safety plug (plug type F; CEE 7/4)			
Connected load	3 kVA			3 kVA			
Cooling type	F (temperature controlled cooling fan)			F (temperature controlled cooling fan)			
IP Code	IP 44			IP 44			
Dimension LxWxH (without handle)	474 x 337 x 351 mm / 18.66" x 13.27" x 13.82"			474 x 337 x 351 mm / 18.66" x 13.27" x 13.82"			
Weight	18 kg / 40 lbs			18 kg / 40 lbs			
Suitable guns	A 12, A 12-FL (welding cable not possible to extend)			A 12, A 12-FL (welding cable not possible to extend)			



Order No.	Order No.
93-60-0650 (Plug E+F; Europe + China)	93-60-0652 (Plug E+F; Europe + China)
93-66-0650 (Plug B; USA, Canada + China)	93-66-0652 (Plug B; USA, Canada + China)
	Expected to be available from 07/2019
93-40-020 (Ground cable, 5 m, 25 mm ² , 2 vice grips 10")	93-40-020 (Ground cable, 5 m, 25 mm ² , 2 vice grips 10")
88-24-466 (Toolbag) (accessories and welding gun are not included)	88-24-466 (Toolbag) (accessories and welding gun are not included)
Legend	Welding process: ARC = Drawn arc stud welding, SC = Short cycle stud welding