

# SPOTARC

TIG-Spot-Welding  
**Tec 5000/5505**



# TIG-Spot-Welding Gun

## Tec 5000/5505

**Rapid, clean tacking and spot-welding** of sheetmetal from steel, stainless steel and CrNi-alloys. The **TEC-spot-welding guns** are the tool to solve these tasks.

**Robust and ergonomic shaped gun handle to press down the sheetmetal.**

**Easy to exchange spare parts with long lifetime:**

**Ceramic insulator with conical seat, securely centered, turnable and adaptable to the position of the weldor.**

**Locator with exchangeable tips for several joints.**

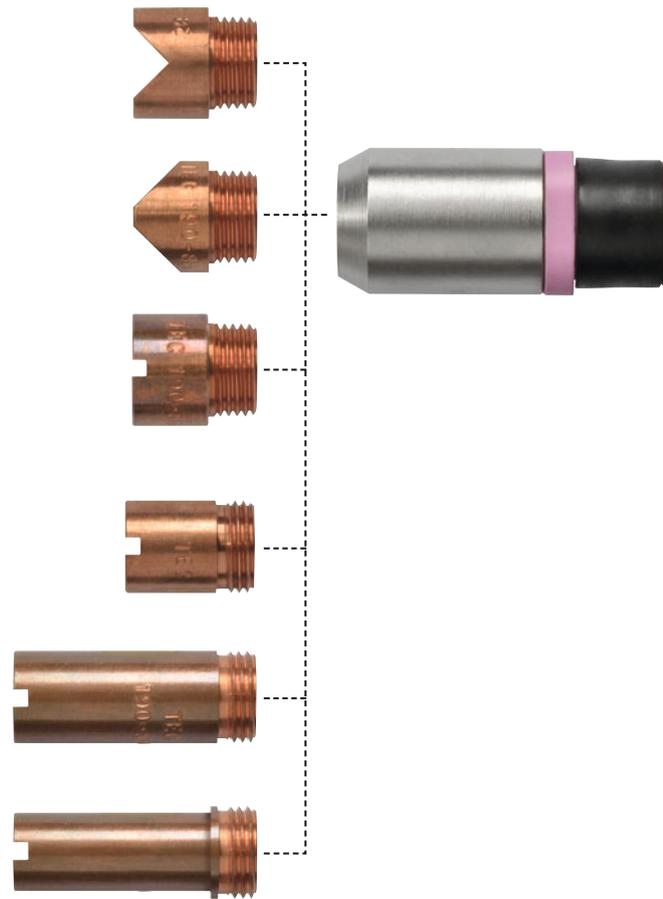
**Gauge for easy and precise setting of the tungsten electrode.**

The **TEC-spot guns** enable to make at low cost, clean, repeatable spot-welds.

### Application of TIG-spot-welding

While TIG-spot-welding, the upper metal sheet will be molten on the spot and the lower metal sheet will be fused. Herewith flat, clean spot-welds are created with nearly no need for reworking. The one-side application permits welding of sheet metal on dairy tanks, built-in constructions or hollow profile.

Furtheron TIG-spot-welding is used in mechanics, control cabinets, car manufacturing, home appliances, hence there, where thin sheets should be pointed together.



### TIG-Spot gun Tec 5505

**Capacity at 60 %**

**Duty cycle (10-min.-cycle):**

Direct current (DC) 240 Amp

**Type of cooling:** Air cooled

**Electrode dimensions:** 0.5–3.2 mm

**Gasflow:** approx. 8 l/min

**Standard:** acc. EN 60974-7 ☑

**Adaption:** For all power sources in the marketplace

### TIG-Spot gun Tec 5000

**Capacity at 60 %**

**Duty cycle (10-min.-cycle):**

Direct current (DC) 450 Amp

**Type of cooling:** Water cooled

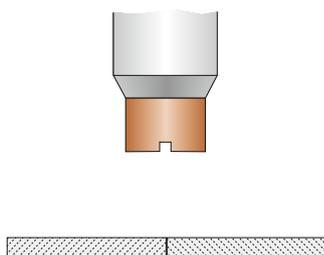
**Electrode dimensions:** 0.5–4.0 mm

**Gasflow:** approx. 8 l/min

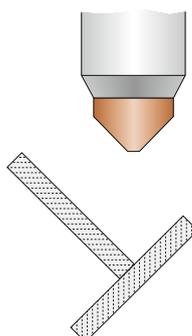
**Standard:** acc. EN 60974-7 ☑

**Adaption:** For all power sources in the marketplace

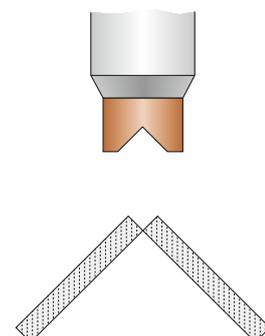
### Butt weld/Lap weld



### Fillet weld



### Corner weld





#### Automated application



#### Advantages of TIG-Spot-Welding

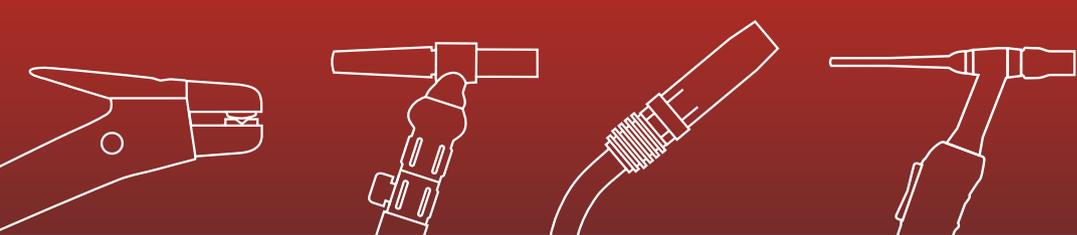
TIG-spot-welding creates some advantages against resistance welding. Important is the welding in one side accessible locations. Furtheron the sheet surface will not be dented as to the lesser pressure needed, this cannot be avoided when resistant welding.

Opposite to resistant MIG/MAG-spot-welding the TIG-spot-welding process creates better, cleaner and flat spot surfaces, materially advantageous for visible locations. Moreover the thermal input is low as to the short spotting time, so that little distortions arise.

#### Use standard TIG-welding power source

A further vantage of the TIG-spot-welding process lies in the use of standard equipment, normally used for seam welding. The simple requirements are high frequency and spot timer facility. So the investment is applicable for many actions and pays-off quickly.

Rohrman Schweißtechnik GmbH supplies TIG-spot guns adaptable to any TIG-power source.



TIG-Spot-Welding		Resistance Spot-Welding	
Sheet metal			Both sides
Sheet metal			One side
Closed section			Impossible



**Accessory Box:**

- Gauge wrench
- Electrode chuck  $\varnothing$  2.4 mm/3.2 mm
- Rubber gasket
- Ceramic insulator
- Adapter body
- Flat tip for butt weld
- Inside corner tip for fillet weld
- Outside corner tip for corner weld



**Optional for torch types # 17/18/26**

