

# TECNA 6122N

90 kVA MFDC Press / Projection Welder

**IN-STOCK** **READY TO SHIP**

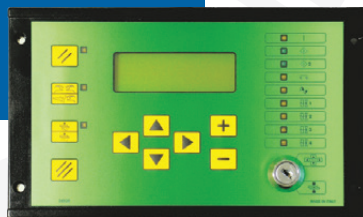
The TECNA 6122N is a 90 kVA, air-operated, MFDC / Inverter press / projection welder. Inverter technology provides greater welding quality and precision, more efficient use of electricity, smaller size, and less electrical loss due to impedance (power savings). With 32,000 current amps and 1,654 force lbs. (standard configuration), the 6122N is a powerful and versatile machine for welding fasteners to high-strength steels.

- Model: TECNA 6122N
- Power @ 50% duty cycle: 90 kVA
- Initiation: Air-operated
- Power supply: MFDC / Inverter
- Max. projection plate depth: 10.32 in. (700 mm)
- Weld current: 32,000 amps
- Max. weld force: 1,654 lbs. (standard)  
2,792 (cylinder 1242)



**TECNA**  
PRESS / PROJECTION  
**MODEL 6122N**

**TE700**  
WELD CONTROL



**OPTIONAL**  
WATER CHILLER



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SPECIFICATIONS		UNITS	MODEL: 6122N
WSI serial number			M0220048
Standard weld control			TE700
Power @ 25% duty cycle		kVA	142
Power @ 50% duty cycle		kVA	90
Short circuit current		A	32,000
Thermal current @ 100%		kA	6.1
Secondary voltage		V	9.9
Supply voltage (@ 60Hz)*		V	480 [ US Configured ]
Primary cables Ø (up to 30m)		mm≤	35
Delayed fuses (@ 440VAC)		A	100
Arm spacing range (gap)		in (mm)	6.9-18.7 (175-475)
Throat depth - to electrode holders		in (mm)	21.26 (540)
Throat depth - to tooling platens		in (mm)	16.22 (412)
# slots & spacing		# / in (mm)	2 / 2.48 (63)
Max electrode force - standard @ 87 psi (6 bar)		lbs. (daN)	1619.2 (736)
Max electrode force - high-force option 8235 @ 87 psi (6 bar)		lbs. (daN)	2732.4 (1242)
Working stroke		in (mm)	3.94 (100)
Adjustable retraction stroke (standard)		in (mm)	0.00-3.15 (0-80)
Compressed air supply		psi (bar)	94.3 (6.5)
<b>Air Consumption per 1000 Spots @ 94 psi (650kP / 6.5 bar)</b>			
Standard welder - 0mm stroke		SCF (N/m≥)	162 (4.6)
Standard welder - max stroke		SCF (N/m≥)	544 (15.4)
Option 6135 - 20mm stroke		SCF (N/m≥)	332 (9.4)
Option 6135 - max stroke		SCF (N/m≥)	766 (21.7)
Air hose inside Ø		in (mm)	0.63 (16)
Water cooling @ 36 psi (250 kP / 2.5 bar)		gpm (lpm)	2.64 (10)
Net weight		lbs (kg)	1100 (500)
Arm diameter		in (mm)	2.36 (60)
Electrode holder diameter		in (mm)	1.26 (32)
Electrode taper		2MT/5RW	2MT/5RW
Dimensions (L x W x H)		in (mm)	52.9 x 17.3 x 76.3 (1343 x 440 x 1938)
Max power		kVA	295
Maximum welding current on aluminum		kA	40
Maximum welding current on steel		kA	35
Tooling platen dimensions		in (mm)	4.72/5.51 (120/140)
Aerial noise produced		dB(A)	73
<b>Measured Conditions</b>			
Working stroke		in (mm)	1.97 (50)
Welding time		Cycles	11
Welding current		kA	34
Working rating (welds per minute)		#/min	6