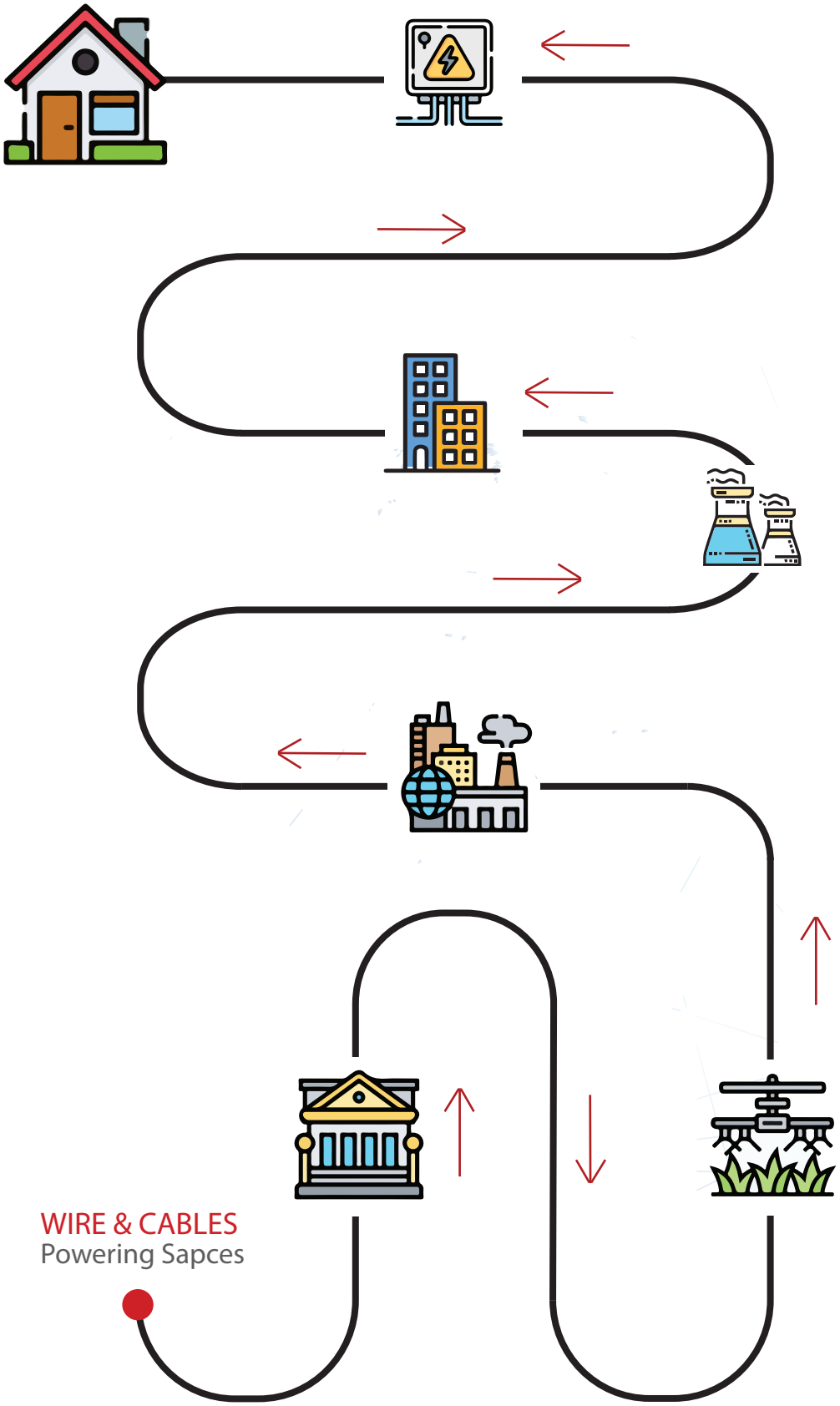
ROLSON®
WIRES & CABLES

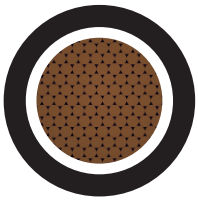
Product Catalogue



ROLSON®
WIRES & CABLES

IS : 694
CM/L - 7500269814

WELDING CABLES





Cable Standard

Generally conforms to, Based on IS-9857-1990
VDE 0282, IEC 245-6, BS 6899

Silent Features

- Ultra high performance flexible welding lead, double insulated for longer life and added safety
- Better flame retardant properties
- Outstanding toughness & durability
- High resistance to cuts, tears & abrasion
- Resistance to oil, solvents and chemicals
- Excellent ozone and weather resistant

Technical Data

Fixed Installation : -20°C to max.+90°C
Nominal Voltage : 600 V
Spark Test : 3.5 KV(ac)
Min. Bending Radius : 6 x Cable Diameter

Standard Packing

Coils 100, 200, 300 and 500m

Conductor : High conductivity, bare annealed copper flexible conductor, EC copper class 5 & class 6 generally conforms to IS:8130-1984, IEC 60228

Separation : Polyester tape

Insulation : Double Insulated/single insulated flexible Nitrile rubber HOFR insulated as per IS:6380-1984

Colour : Orange/Black Jacket

Current Rating

The maximum current ratings of flexible welding cables for different. duly cycles are based on an ambient air temperature of 25 C and a maximum conductor temperature of 90 C. The percentage duly cycles for various processes and applications are as follows:

- Automobile Welding: up to 100%
- Semi Automatic Welding: 30% to 85%
- Manual Welding: 0% to 60%
- Very intermittent or Occasional Welding: up to 20%

Voltage Drop

When total cable lengths in excess of 15mtr., are involved, it may be necessary to use cables of larger cross section to ensure that the voltage drop is not excessive & welding currents are maintained at adequate levels.

Application

Designed for the secondary (high current) connection to automatic or hand-held metal arc welding electrodes. It is suitable for flexible use under rugged conditions, on assembly lines & conveyor systems, in machine tool and automatically operated line & spot welding machines.

Cable Size	Nominal Inner Insulation Thickness	Nominal sheath thickness	Overall Cable Diameter		Max. Conductor Resistance at 20°C	Current Rating Welding Applications					Non Welding Application
			Single Insulated	Double Insulated		100%	85%	60%	30%	20%	
Sq.mm	mm	mm	mm	mm	Ω/km.	amp	amp	amp	amp	amp	amp
10.0	1.0	1.10	7.0	8.50	1.910	105	115	135	190	235	110
16.0	1.10	1.30	9.0	10.0	1.210	135	145	175	245	302	138
25.0	1.20	1.40	10.30	12.0	0.780	180	195	230	330	402	187
35.0	1.20	1.60	11.85	13.50	0.554	225	245	290	410	503	233
50.0	1.30	1.70	14.0	15.20	0.386	285	310	370	520	637	295
70.0	1.40	1.80	15.80	18.0	0.272	355	385	460	650	794	372
95.0	1.80	2.0	17.70	20.60	0.206	430	470	560	790	961	449
120.0	2.0	2.10	19.50	23.0	0.161	500	540	650	910	1118	523

Rating factors for variation in ambient temperature

Ambient Temperature °C	20°	25°	30°	35°	40°	45°	50°	55°	60°	65°
Rating Factor	1.04	1.04	1.04	1.04	1.04	1.04	1.04	0.69	0.64	0.57

Note:The number of wires and diameter mentioned in the table are approximate and nominal; however they shall meet the requirements of conductor resistance as per standards.In view of continuous improvements in our design and process, the information, Dimensions and specifications given herein are subject to change without notice.

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WIRES & CABLES

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