

WELDING CABLES



Double Insulated | Extra Flexible | Orange & Black Jacket

- 10Sq. mm. to 400 Sq. mm.
- 600 Volts
- -30°C to +90 °C

Conforms to, BS EN 50525 CENELEC HD 22-631, VDE 0282, IEC 245-6, BS 6899, IS 6830/84

Cable Structure

Conductor :

High conductivity, bare annealed copper flexible conductor, EC copper class 5 and class 6 generally conforms to IEC 60228, DIN VDE 0281

Insulation :

Double Sheathed with a specially developed Thermo plastic Elastomeric (TPR/NBR)

Application

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

NBR/NBR Welding Cable

Nominal cross sectional area of conductor Sq. mm.	Nominal insuln Thickness mm	Nominal sheath Thickness mm	Overall cable diameter		Max conductor resistance at 20°C Ω/km	Current rating					Non Welding Application on amp
			Lower limit mm	Upper limit mm		Welding Application & Duty Cycle					
						100% amp	85% amp	60% amp	30% amp	20% amp	
10	1.2	1.8	7.8	10.0	1.91	105	115	135	190	235	110
16	1.2	1.9	9.0	11.5	1.21	135	145	175	245	302	138
25	1.4	2.0	10.0	13.0	0.780	180	195	230	330	402	187
35	1.4	2.2	11.5	14.5	0.554	225	245	290	410	503	233
50	1.6	2.4	13.0	17.0	0.386	285	310	370	520	637	295
70	1.6	2.6	15.0	19.0	0.272	355	385	460	650	794	372
95	1.8	2.8	17.5	21.5	0.206	430	470	560	790	961	449
120	1.8	3.0	19.5	24.0	0.161	500	540	650	910	1118	523
150	2.0	3.2	21.5	26.0	0.129	580	620	740	1040	1297	608
185	2.2	3.4	23.0	29.0	0.106	660	715	850	1200	1476	690
240	2.4	3.5	27.0	32.0	0.0801	710	770	916	1296	1587	744
300	2.6	3.6	30.0	35.0	0.0641	800	850	1035	1450	1790	840
400	2.8	3.8	33.0	39.0	0.0486	925	1000	1195	1690	2070	970

Rating factors for variation in ambient temperature

Ambient temperature °C	20°	25°	30°	35°	40°	45°	50°	55°	60°	65°
Rating Factor	1.04	1.00	0.96	0.91	0.87	0.82	0.76	0.69	0.64	0.57

Voltage Drop :

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