

## BMH-22i Stud Welder



### BMH-22i SOYER inverter stud welder for universal application

#### Description:

The new BMH-22i inverter stud welder is a multifunctional high-tech development perfectly suitable for stud welding, electrode welding and TIG welding. Its performance and quality features are unequalled in stud welding technology. The lightweight stud welder in compact design allows reliable and problem-free welding of studs up to M24 (7/8"). This stud welder has only approx. one fifth the weight of comparable stud welders and features high technical performance due to an extremely steady arc. The adjustability of all important welding parameters and user guidance via membrane keyboard with digital display allow optimal ease of use and first-rate welding results. (For innovative special features, please see over).

#### Technical data:

##### Welding range:

M8 - M24 RD or 8 - 22 mm in diameter

##### Material:

Steel, stainless steel, heat-resistant steel

##### Standard gun:

PH-5L stud welding gun or alternatively, the PH-4L for studs up to M20

##### Welding current:

300 - 2000 A, adjustable and regulated with stud welding  
80 - 300 A, adjustable with electrode welding  
80 - 200 A with TIG welding

##### Welding time:

10 - 1000 ms with stud welding

##### Welding sequence:

up to 50 studs/min, depending on stud diameter

##### Mains supply:

3 x 400 V - 50/60 Hz, 63 AT, other voltage on request

##### Dimensions:

560 x 420 x 650 mm (w x h x d)

##### Weight:

70 kg

##### Colour:

RAL 5009 azure

Technical specifications are subject to change without notice



# Innovative Special Features of the BMH-22i Inverter Stud Welder

The new BMH-22i inverter stud welder with outstanding quality and performance features represents the future state of stud welding technology. The all-digital stud welder with computer intelligence guarantees absolutely uniform and reproducible functional sequences for optimum welding results. The modular construction in useful and easy-to-service compact housing, the modern design and progressive technology provide the SOYER stud welder with its unique appearance. The BMH-22i inverter stud welder is universally applicable and combines in a compact case the following stud welding methods

- Drawn arc stud welding
- Stud welding with protective gas
- Short-cycle drawn arc stud welding
- Stud welding in radially symmetrical magnetic fields (option)

and welding systems

- Stud welding
- Nut welding
- Electrode welding
- TIG welding

Additional performance features of the BMH-22i inverter stud welder include:

- ▶ Development and production fulfil all prescribed safety targets such as
  - the latest safety and accident prevention regulations (Act on the Safety of Technical Working Equipment)
  - electromagnetic compatibility (EMC Act)
  - European regulations (EU Directive on Machinery)
- ▶ Certificate proof of mentioned safety targets
- ▶ Extremely simple operator guidance via sophisticated membrane keyboard with clear symbols for all necessary parameter inputs
- ▶ CE mark and safety mark for verified safety
- ▶ Welding current variably adjustable
- ▶ Shielding gas preflow time variably adjustable
- ▶ Welding time and preweld current time variably adjustable
- ▶ High-dynamic regulation of the welding process
- ▶ High clock frequency of 30 kHz
- ▶ Integrated inert gas operation mode
- ▶ Low connected load and low weight
- ▶ High welding current of 2000 A for stud welding
- ▶ High welding current of 300 A for electrode welding and 200 A for TIG welding
- ▶ Constant current controller (current fluctuation control)
- ▶ Interface for signal interchange with other external control systems (optional simple and low-cost retrofitting possibility with an automatic module for semi-automatic and fully automatic stud feed)
- ▶ Interface for stud welding in radially symmetrical magnetic fields (option)
- ▶ LED display panel with control function of all operational states
- ▶ Self-protecting device in case of excess temperature or excessive welding sequence
- ▶ Computer check on operability and simulated program run of all setting parameters on stud welder and gun without welding current
- ▶ New abrasionproof, scratch-resistant and antisoiling plastic film coating on the front panel to protect all inscriptions even after many years of use
- ▶ Table at the front panel showing standard values for all common stud types and diameters
- ▶ Integrated quality control (option)
- ▶ Operating range with short-cycle drawn arc welding: M8 - M10 or 8 - 10 mm in diameter
- ▶ Operating range with drawn arc welding: M8 - M24 RD or 8 - 22 mm in diameter
- ▶ Operating range with inert gas operation: M8 - M12 or 8 - 11 mm in diameter
- ▶ Operating range with stud welding in radially symmetrical magnetic fields: M8 - M16 or 8 - 13 mm in diameter (option)

SOYER top-of-the-range products awarded the following prizes for



Production



Quality



Technology



Design



Stud Manufacture



Quality Management



International Approval



Safety



EC Conformity