

# 0361TQ BS EN 60332-1-2 BS 638 Orange Welding Cable

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## Application:

For the transmission of high currents from the electric welding machine to the welding tool. Suitable for flexible use under rough conditions, on assembly lines and conveyor systems, in machine tool and motor car manufacturing, ship building, for manually and automatically operated line and spot welding machines.

## Cable Standards:

Made in accordance with the following:  
BS 638 Part 4\*, BS EN 60332-1-2

## Construction:

Conductor	: 16mm <sup>2</sup> to 35mm <sup>2</sup> : Class 6 extra flexible tinned copper conductor according to BS EN 60228 (previously BS 6360) Separator: PET (Polyester Tape)
Insulation	: EPR (Ethylene Propylene Rubber) Type GP4 according to BS 7655
Sheath	: HOFR (Heat and Oil Resistant and Flame Retardant) Sheath Type EM5 Rubber compound according to BS EN 50363

## Characteristics:

Voltage Rating	: 100V (450V for non-welding applications if suitably protected from mechanical damage)
Temperature Rating	: -20°C to +85°C (Flexed)
Min. Bending Radius	: 6 × overall diameter (Flexed)
Sheath Colour	: Orange

**Note** : \*Sizes up to and including 185mm<sup>2</sup> conform to BS 638 Part 4

## Electrical Characteristics:

### Duty Cycle and Current Carrying Capacity:

The current carrying capacity of a welding cable depends on the length of the duty cycle. The duty cycle is the length of time during which a loaded current passes through the cable over an operation period of 5 minutes, expressed as a percentage of that period. For example, if the current is flowing for the whole 5 minutes the duty cycle is 100%, and if the current is flowing for 1 minute the duty cycle is 20%.

As conductor temperature varies according to the time in use as well as current, ratings shown are given as a guide.

The permissible loading of the cable for duty cycles other than those shown in the table can be calculated using the following formula:

$$I = I_{100} \times \sqrt{100/F}$$

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Where:

- I : is the maximum permissible loading current for the required duty cycle.
- $I_{100}$  : is the maximum permissible loading current for a duty cycle of 100%.
- F : is the required duty cycle calculated as a percentage of the 5 minute operation period.

Typical guidance values for different welding processes are as follows:

- Fully automatic welding 100%
- Semi-automatic welding 65 - 85%
- Manual Welding 30 - 60%
- Very infrequent or occasional welding 20%

### Current Carrying Capacity:

Part Number	Nominal Cross Sectional Area mm <sup>2</sup>	Current Rating for Single Cycle Operation over a Maximum Period of 5 Minutes Amps			
		100%	85%	60%	35%
PP000904	16	135	145	175	230
PP000906	25	180	195	230	300
PP000908	35	225	245	290	375

The above table is in accordance with Table A.5 of BS 638 Part 4

- Ambient Air Temperature : +25°C
- Max. Conductor Temperature : +85°C

### De-Rating Factors:

Ambient Temperature	+25°C	+30°C	+35°C	+40°C	+45°C
De-Rating Factor	1.0	0.96	0.91	0.87	0.82

The above table is in accordance with A.7 of BS 638 Part 4

### Conductors:

Class 6 Flexible Copper Conductors for Single Core and Multi-Core Cables

Part Number	Nominal Cross Sectional Area mm <sup>2</sup>	Max. Diameter of Wires in Conductor mm	Max. Resistance of Conductor at 20°C
			Metal-Coated Wires Ω/km
PP000904	16	0.21	1.24
PP000906	25	0.21	0.795
PP000908	35	0.21	0.565

The above table is in accordance with BS EN 60228 (previously BS 6360)



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## Dimensions:

Type 0361TQ - Tinned Copper Conductors

Part Number	Conductor Class	No of Cores	Nominal Cross Sectional Area mm <sup>2</sup>	Total Radial Thickness of Covering mm	Nominal Overall Diameter mm	Nominal Weight kg/km
PP000904	Class 6	1	16	2	9.7	215
PP000906	Class 6	1	25	2	11.2	305
PP000908	Class 6	1	35	2	12.4	400

## Part Number Table

Description	Reel Length (m)	Part Number
0361TQ BS EN 60332-1-2 BS 638 Orange Welding Cable	50	PP000904
		PP000906
		PP000908

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