

UNITROL SOLUTION Sizing Chart

SINGLE PHASE CONTROL SIZING CHART

WELDER PRIMARY VOLTAGE					MODEL NUMBERS		CABINET SIZE		
208 Volts	230 Volts	380 Volts	460 Volts	575 Volts	With Circuit Breaker	Without Protection	A	B	C
1-15 KVA	1-15 KVA	1-25 KVA	1-30 KVA	1-40 KVA	9180-990 — 9180L-990 9180D-990	9180-900 9180M-900 9180L-900 9180D-900	20 — 20 20	20 — 20 20	9 8 9 9
16-30 KVA	16-35 KVA	26-50 KVA	31-65 KVA	41-80 KVA	9180-810 — 9180L-810 9180D-810	9180-800 9180M-800 9180L-800 9180D-800	20 — 20 20	20 — 20 20	9 8 9 9
31-75 KVA	36-80 KVA	51-130 KVA	66-170 KVA	81-200 KVA	9180-620 — 9180L-620 9180D-620	9180-600 9180M-600 9180L-600 9180D-600	20 — 20 20	20 — 20 20	9 14 9 9
76-120 KVA	81-130 KVA	131-200 KVA	171-250 KVA	201-325 KVA	9180-630 9180L-630 9180D-630	same as above	24 24 24	24 24 24	9 9 9
121-200 KVA	131-250 KVA	201-450 KVA	251-500 KVA	326-600 KVA	9180-440 9180L-440 9180D-440 — — —	— — — 9180-400 9180L-400 9180D-400	30 30 30 20 20 20	30 30 30 20 20 20	13 13 13 9 9 9

COMPLETE 1Ø RETROFIT SYSTEMS WITHOUT POWER CABINETS

For use with existing SCR Contactors..... 9180-SCO, 9180M-S00, 9180-S00

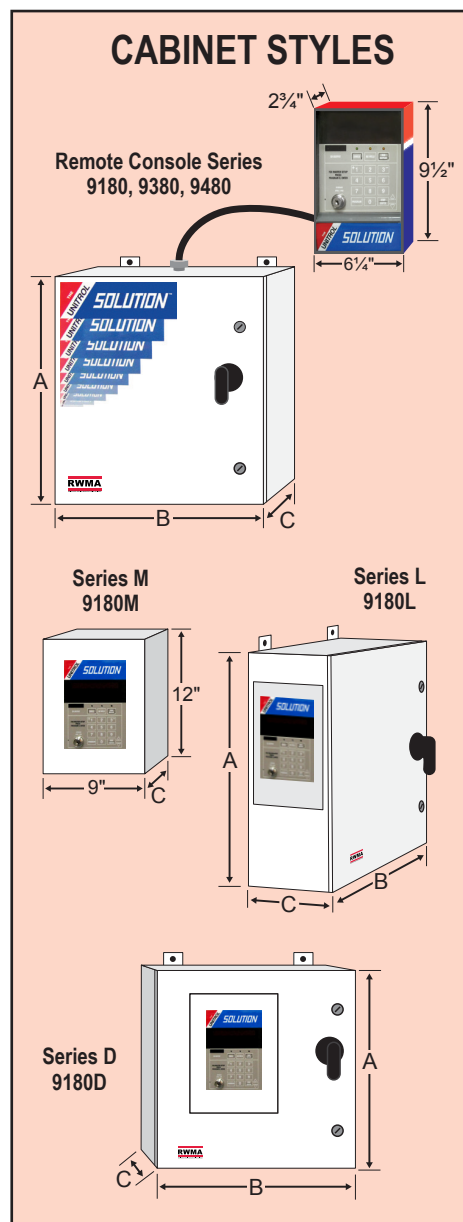
THREE PHASE CONTROL SIZING CHART

WELDER PRIMARY VOLTAGE				MODEL NUMBERS				CABINET SIZE		
208 & 230 Volts	380 Volts	460 Volts	575 Volts	FREQUENCY CONVERTER		D.C. SECONDARY		A	B	C
				With Circuit Breaker	Without Protection	With Circuit Breaker	Without Protection			
—	to 50 KVA	to 65 KVA	to 80 KVA	9380-610 —	9380-600	9480-610 —	9480-600	30 24	30 24	13 13
to 75 KVA	51-130 KVA	66-170 KVA	81-200 KVA	9380-620 —	9380-600	9480-620 —	9480-600	30 24	30 24	13 13
76-150 KVA	131-200 KVA	171-250 KVA	201-325 KVA	9380-430 —	9380-400	9480-430 —	9480-400	36 30	30 30	13 13
151-200 KVA	201-450 KVA	251-500 KVA	326-600 KVA	9380-440 —	9380-400	9480-440 —	9480-400	36 30	36 30	13 13

COMPLETE 3Ø RETROFIT SYSTEMS WITHOUT POWER CABINETS

Frequency Converter Control for use with existing SCR Contactors.....9380-S00

3Ø D.C. Secondary Control for use with existing SCR Contactors9480-S00



1. Find the **primary voltage** of your welder in the **red** area of the chart below.
2. Move **downward** from this **primary voltage** to the **blue** box that includes the KVA as shown on the nameplate of your welder.
3. From this point, move to the **right** for the **SOLUTION®** Model Number in the column that lists the desired **circuit protection** and **cabinet style** (see photos at right). Note that circuit breakers are recommended for most production welding systems.
EXAMPLE: The correct **single phase SOLUTION®** controls with **circuit breaker** protection for a **50 KVA** spot welder working at **460 volts** are: **#9180-810, 9180L-810, or 9180D-810** (depending on desired cabinet style).
4. Order this model number from your authorized **UNITROL** representative or distributor who will recommend control options.

Distributed by:

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