WATER-COOLED, METAL-JACKETED, MERCURY-POOL-CATHODE
TYPE HAVING MOUNTING PLATE FOR THERMOSTATIC CONTROL

For Intermittent-Power-Rectifier and
Resistance-Welding-Control Applications

GENERAL DATA

Electrical:
Cathode Excitation. ................. Cyclic
Cathode-Spot Starting ............... By Ignitor
Minimum Requirements for Cathode Excitation:
Peak ignitor voltage required to fire ...... 200 volts
Peak ignitor current required to fire ...... 30 amp
Starting time at required ignitor voltage
or current. ................. 100 μsec
Peak Tube Voltage Drop at peak anode amperes =
3400. .......... 26 volts
176 .......... 13 volts

Mechanical:
Operating Position. ........ Vertical, flexible lead up
Maximum Overall Length:
Including flexible lead ......... 23-13/16"
Excluding flexible lead ........ 13"
Maximum Radius (Including water connections) .......... 2-7/8"
Weight (Approx.) .............. 4.5 lbs

Terminal Diagram:

P - Anode
Terminal
(Flexible lead)
K - Cathode
Terminal
(Bar opposite anode terminal)

I - Ignitor
Terminal
(Within jacket
skirt at cathode end)
S - Shell

Thermal:
Cooling:
Maximum inlet-water temperature ........ 0 °C
Maximum cooling-system temperature
(Measured at thermostat mount):
For Intermittent-Power-Rectifier Service .... 45 °C
For Resistance-Welding-Control Service
at rms anode supply volts =
600 .......... 45 °C
500 .......... 50 °C
250 .......... 55 °C
Typical cooling requirements for Resistance-Welding-Control Service at rms anode supply volts = 500:

<table>
<thead>
<tr>
<th>Inlet Water Temperature (°C)</th>
<th>Required Water Flow (gpm)</th>
<th>Pressure Drop (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>With 100% load:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>1/4</td>
<td>0.4</td>
</tr>
<tr>
<td>30</td>
<td>1/2</td>
<td>0.75</td>
</tr>
<tr>
<td>40</td>
<td>1-1/2</td>
<td>3</td>
</tr>
<tr>
<td>With 50% load:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>1/16</td>
<td>0.1</td>
</tr>
<tr>
<td>30</td>
<td>1/8</td>
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</table>

Water-temperature rise with 100% load at flow of 1 gpm: ....... 2 °C
Temperature Rise (Approx.), inlet water to thermostat, with 100% load at flow of 1 gpm: ........... 4 °C

INTERMITTENT POWER-RECTIFIER SERVICE

Maximum Ratings, Absolute-Maximum Values:

For zero phase-control angle and frequencies from 50 to 60 cps

PEAK ANODE VOLTAGE:
- Forward: 500 max. 1200 max. 1500 max. volts
- Inverse: 500 max. 1200 max. 1500 max. volts

ANODE CURRENT:
- Peak: 700 max. 600 max. 480 max. amp
- Corresponding average: 5 max. 4 max. amp
- Average: 40 max. 22.5 max. 18 max. amp
- Corresponding peak: 135 max. 108 max. amp

AVERAGING TIME: 6 max. 10 max. 10 max. sec

RATIO OF AVERAGE ANODE CURRENT TO PEAK ANODE CURRENT for maximum averaging time (seconds) = 0.2 .... 0.166 max. 0.166 max.

RATIO OF PEAK FAULT ANODE CURRENT TO PEAK ANODE CURRENT: 12.5 max. 12.5 max. 12.5 max.

FAULT-ANODE-CURRENT DURATION: 0.15 max. 0.15 max. 0.15 max. sec
RESISTANCE-WELDING-CONTROL SERVICE

Maximum Ratings, Absolute-Maximum Values:

For two tubes in inverse parallel circuit, zero phase-control angle, frequencies from 25 to 60 cps, and rms supply voltages from 250 to 600 volts

DEMAND, ........................................ 600 max. kva
Corresponding average anode current (Per tube). .......... 30.2 max. amp
AVERAGE ANODE CURRENT (Per Tube)* 56 max. amp
Corresponding demand. ................................ 200 max. kva
AVERAGING TIME at rms supply volts =
600°C. .................................. 11.25 max. sec
250°C. .................................. 27 max. sec
RMS ANODE CURRENT (Per Tube)* See Rating Chart
PEAK FAULT ANODE CURRENT (Per Tube) Limited to 280% of maximum RMS Anode Current

IGNITOR

Maximum Ratings, Absolute-Maximum Values:

PEAK IGNITOR VOLTAGE:
Positive. .................. Equal to anode volts
Negative. .................. 5 max. volts

IGNITOR CURRENT:
Peak. .................. 100 max. amp
Average .................. 1 max. amp
RMS .................. 10 max. amp
AVERAGING TIME .................. 5 max. sec

a Ignition will occur if either the minimum peak ignitor voltage is applied or the minimum peak ignitor current flows for the minimum starting time.
b With the use of log-log graph paper, straight-line interpolation between tabulated points may be used to determine intermediate maximum ratings for Peak Anode Current and Average Anode Current.
c With the use of log-log graph paper, straight-line interpolation between tabulated points may be used to determine intermediate maximum ratings for RMS Anode Current and Average Anode Current or Averaging Time and RMS Supply Voltage.
ANODE-CURRENT RATING CHART
Resistance-Welding-Control Service

MAXIMUM OPERATING VALUES
WITH RMS SUPPLY VOLTS =
250
500

RMS ANODE AMPERES (PER TUBE)

DUTY FACTOR

92CS-11700