



5822-A IGNITRON

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

For intermittent rectifier and frequency-changer welder service

GENERAL DATA

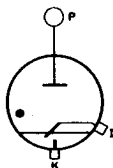
Electrical:

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 voltage or current.	100 μ sec
Tube Voltage Drop:	
At peak anode current of 1500 amperes	25 volts

Mechanical:

Operating Position.	Vertical, flexible lead up
Maximum Overall Length (Including flexible lead).	27-1/4"
Maximum Radius (Including water connections).	3-5/8"
Weight.	8.25 lbs
Terminal Connections (See Dimensional Outline):	

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



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

Cooling:

Type.	Water
Minimum inlet water temperature	10 $^{\circ}$ C
Maximum outlet water temperature.	35 $^{\circ}$ C
Minimum water flow.	1.5 gpm
Maximum water-temperature rise.	6 $^{\circ}$ C
Maximum pressure drop	5 psi

INTERMITTENT RECTIFIER SERVICE and FREQUENCY-CHANGER WELDER SERVICE

Maximum Ratings, Absolute-Maximum Values:

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

RATING I

PEAK ANODE VOLTAGE:

Forward	1200 max.	1200 max.	volts
Inverse	1200 max.	1200 max.	volts



5822-A IGNITRON

ANODE CURRENT:

Peak.	420 max.	1500 max.	amp
Average (Averaged over any interval of 6.25 seconds maximum)	70 max.	20 max.	amp
Average (Averaged over any interval of 0.2 second maximum).	70 max.	250 max.	amp
Fault, for duration of 0.15 second maximum.	18750 max.	18750 max.	amp

RATING II

PEAK ANODE VOLTAGE:

Forward	1500 max.	1500 max.	volts
Inverse	1500 max.	1500 max.	volts

ANODE CURRENT:

Peak.	336 max.	1200 max.	amp
Average (Averaged over any interval of 6.25 seconds maximum)	56 max.	16 max.	amp
Average (Averaged over any interval of 0.2 second maximum).	56 max.	200 max.	amp
Fault, for duration of 0.15 second maximum.	15000 max.	15000 max.	amp

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 (Averaged over any interval of 5 seconds maximum)	1 max.	amp
RMS	10 max.	amp

OPERATING CONSIDERATIONS

The 5822-A is equipped with a mounting plate for mounting a thermostatic control calibrated either for controlling the flow of cooling water through the water jacket, or for protection of the ignitron against overheating.

When the cooling water is circulated successively through the water jackets of two or more ignitrons, the water-saving thermostat, if used, should be mounted on the ignitron connected directly to the water supply.

The water-saving thermostat, which has normally open contacts, is calibrated to close a circuit energizing a solenoid valve in the water-supply line and thus permit water



5822-A

IGNITRON

5822-A

flow to start when the temperature of the thermostat mounting plate exceeds approximately 35° C. Because of the lag between the heating of the ignitron envelope and the functioning of the water-saving thermostat to start water flow through the water jackets, the ignitron may overheat before the flow of cooling water starts.

Such overheating can be prevented by the use of an auxiliary contactor shunted across the contacts of the water-saving thermostat and actuated by the welding-control switch. The contactor causes the solenoid valve in the water-supply line to open as soon as welding current flows.

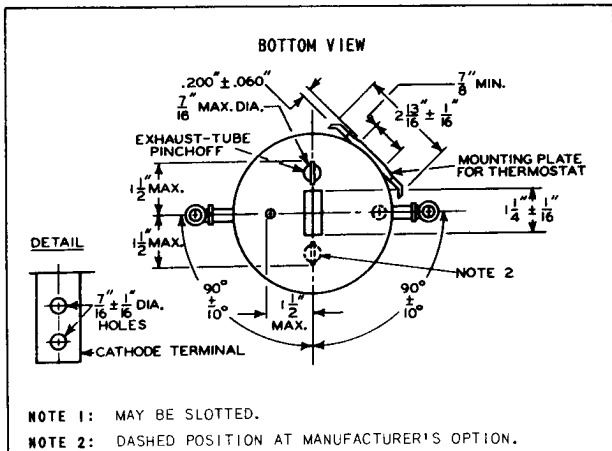
When a *protective thermostat* is used, it should be mounted on an ignitron from which the cooling water discharges into the drain. The protective thermostat is calibrated to open a set of normally closed contacts at a jacket temperature of approximately 52° C. The opening of these contacts causes a protective device to function. This device may be a relay opening the ignitor firing controls, or preferably, a circuit breaker which removes power from the ignitrons.

Care must be taken to insure that the water jacket of each ignitron is completely filled before power is applied. Tube operation with a partially filled water jacket may cause abnormal heating of the tube envelope with resultant arc-back which impairs tube life. It is also necessary to arrange the cooling system so as to prevent any draining of the water jackets when the flow of water ceases.



5822-A IGNITRON

5822-A



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RATING CHART FREQUENCY-CHANGER WELDER SERVICE

