

## Rubber Flexible

### HO1N2-D WELDING FLEXIBLE

Flexible plain annealed copper conductors, Rubber Insulated welding cable. 100/100 volts grade. to VDE0282 /HD 22.6 S1 and BS638 Part 4

**Harmonised code: HO1N2-D**

SIZE SQ.MM	CLASS OF CONDUCTOR	MAXIMUM DIAMETER OF WIRES MM	MEAN THICKNESS OF INSULATION	OVERALL DIAMETER MM		APPROX WEIGHT KG/KM
				MIN	MAX	
16	5	0.21	2.0	8.8	11.0	220
25	5	0.21	2.0	10.1	12.7	310
35	5	0.21	2.0	11.4	14.2	415
50	5	0.21	2.2	13.2	16.5	560
70	5	0.21	2.4	15.3	19.2	780
95	5	0.21	2.6	17.1	21.4	1030
120	5	0.51	2.8	19.2	24.0	1305
150	5	0.51	3.0	23.1	28.9	1600

**Operating temperature:**

Maximum 85°C, Minimum flexing -15°C.

**Minimum bending radius:**

6 x Overall Diameter.

**DUTY CYCLE.** The duty cycle is defined as the time for which the current flows expressed as a percentage of the complete cycle, which is taken as 5 minutes. Since the length of time for which the current flows during welding operation varies from occasional to continuous, the duty cycle can vary from as little as 20% to maximum of 100% on automatic operation. As conductor temperature varies according to the time in use as well as current, ratings shown are given as a guide.

Automatic welding : Up to 100%  
Semi - Automatic : 30 - 85%  
Manual Welding : 30 - 60%

**AMBIENT TEMPERATURES.** Cable operating temperature also varies according to the prevailing ambient temperature. EPR/CSP cables are designed to give optimum performance up to an operating temperature of 85°C at an ambient temperature of 25°C. The reduction factors for increased ambient temperatures are.

Ambient temperature :	30°C	35°C	40°C	45°C	50°C	55°C
Reduction Factor :	0.96	0.91	0.87	0.82	0.76	0.79

**OPERATIONS UNDER SEVERE CONDITIONS.** High operating temperatures or prolonged maximum loading of the cable reduces the life or makes the cable too hot to handle. Thus under conditions where a long service life cannot be expected or where a high surface temperature is tolerable, the current rating for 25°C may be applied up to an ambient temperature of 40°C.

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Telephone: +44 (0)121 508 6890

Fax: +44 (0)121 508 6891

Web: [www.cablesbritain.com](http://www.cablesbritain.com)

Email: [sales@cablesbritain.com](mailto:sales@cablesbritain.com)