



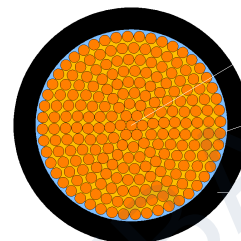
TEBAOFLEX CABLE

DATA SHEET

Industrialcable

WCT

Natural rubber sheathed welding cable



APPLICATION

Natural rubber sheathed flexible cable mainly used on the secondary side of arc welders. Designed for welding-current connection service requiring flexibility, durable rubber sheathing and reliable conductor performance.

CONSTRUCTION

Component	Description
Conductor	Annealed copper wire or tinned annealed copper wire
Separator	Suitable separator applied over the conductor
Sheath	Natural rubber compound
Sheath thickness	Average thickness not less than 90% of the tabulated value
Minimum sheath thickness	Not less than 80% of the tabulated value

OPERATING CHARACTERISTICS

Parameter	Value
Application	Secondary-side conductor cable for arc welders
Dielectric withstand voltage	1000 V for 1 minute in water
Sheath tensile strength	Not less than 14 MPa
Sheath elongation	Not less than 430%
Thermal aging	Tensile strength and elongation not less than 50% before heating
Standard unit length	20 m bundle for smaller sizes; 200 m drum for larger sizes

STANDARDS

Parameter	Value
Applicable standards	JIS C 3005; JIS C 3102; JIS C 3152; JIS C 3404
Electrical safety	Technical standards for electrical installations

PERFORMANCE REQUIREMENTS

TEST CHARACTERISTICS

Item	Characteristic	Test method
Appearance	Surface is smooth and free from flaws in use	JIS C 3005 4.1
Construction	According to the attached structure and size table	JIS C 3005 4.3
Conductor resistance	Not more than the value in the construction table	JIS C 3005 4.4
Dielectric withstand	Capable of withstanding 1000 V for 1 minute in water	JIS C 3005 4.6 a)
Tensile strength	Sheath tensile strength not less than 14 MPa	JIS C 3005 4.16
Elongation	Sheath elongation not less than 430%	JIS C 3005 4.16
Thermal aging	Tensile strength and elongation not less than 50% before heating	JIS C 3005 4.17
Impact	No damage or crack; broken component wires in each core not to exceed 30%	JIS C 3005 4.28

TECHNICAL DATA

Construction, size, weight and electrical characteristics. Manufacturer-specific markings have been omitted.

Dimensions and Electrical Characteristics (1)							
Size mm2	Composition	Conductor OD mm	Sheath mm	Overall OD mm	Approx. mass kg/km	Conductor resistance ohm/km	Packing
14	88/0.45	4.9	2.3	9.6	200	1.32 / 1.39	20 m bundle
22	7/20/0.45	7.0	2.3	11.5	305	0.844 / 0.892	20 m bundle
30	7/27/0.45	8.1	2.5	13.0	400	0.625 / 0.661	20 m bundle
38	7/34/0.45	9.1	2.6	14.1	490	0.496 / 0.525	20 m bundle
50	19/16/0.45	10.4	2.7	15.6	600	0.394 / 0.411	200 m drum
60	19/20/0.45	11.6	2.8	17.0	735	0.311 / 0.329	200 m drum
80	19/27/0.45	13.5	3.0	19.2	965	0.230 / 0.243	200 m drum

TECHNICAL DATA

Construction, size, weight and electrical characteristics. Manufacturer-specific markings have been omitted.

Dimensions and Electrical Characteristics (2)							
Size mm2	Composition	Conductor OD mm	Sheath mm	Overall OD mm	Approx. mass kg/km	Conductor resistance ohm/km	Packing
100	19/34/0.45	15.2	3.2	21.3	1,200	0.183 / 0.193	200 m drum
125	19/42/0.45	16.8	3.3	23.6	1,490	0.148 / 0.156	200 m drum
150	27/34/0.45	18.7	3.5	25.4	1,690	0.129 / 0.136	200 m drum
200	37/34/0.45	21.2	3.8	28.4	2,285	0.0939 / 0.0993	200 m drum
250	37/42/0.45	23.6	4.0	31.4	2,810	0.0760 / 0.0803	200 m drum
325	37/55/0.45	27.0	4.3	35.7	3,660	0.0581 / 0.0614	200 m drum

Resistance values: upper value for annealed copper wire; lower value for tinned annealed copper wire.

CERTIFICATIONS



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