

IGNITRON

SPECIAL DESIGN FEATURES

1. Stainless-steel, seam-welded construction
2. Uniform water cooling
3. Strong, compact design
4. Easy to install
5. Copper terminals
6. Flexible anode lead
7. Mercury-pool cathode allows extremely high instantaneous currents to be passed through the tube without damage.

DESCRIPTION

The ability of this tube to carry very high peak currents for short periods makes it especially suited to welder-control service. It may also be used for conversion in low-power circuits and for intermittent rectifier service.

Ease of installation, economical use of space, and reliability of operation are assured by design features inherent in the steel-jacketed construction.

The FG-271 is similar to the FG-235-A and the FG-258-A. All of these tubes can be used for a wide

range of applications where welds are made infrequently or in rapid succession.

The current range required for the welding operation determines which tube to use. Another factor, of course, is the nature of the material to be welded. Low-resistance materials, such as aluminum alloys, require more current than such high-resistance metals as stainless steel.

The FG-271 ignitron is equivalent to a 300-ampere magnetic contactor.

TECHNICAL INFORMATION

These data are for reference only. For design information, refer to specifications.

GENERAL CHARACTERISTICS

Peak voltage drop, approx.	12	volts
Net weight, approx.	4	pounds
Shipping weight, approx.	12	pounds
Type of cooling.		Water
Maximum outlet water temperature.	40	centigrade
Minimum flow.	1	gallon per minute
Minimum inlet water temperature.	10	centigrade
Pressure drop per tube at minimum flow.	1.6	pounds per square inch
Temperature rise at minimum flow, approx. (Average current 40 amperes per anode)	2	centigrade

MAXIMUM RATINGS

A-C Welder-Control Service-Frequencies from 25 to 60 Cycles; Ratings are for any Voltage from 250-600 Volts, Rms*†

Maximum demand.	600	kva
Corresponding average anode current.	30.2	amperes
Maximum average anode current.	56	amperes
Corresponding demand.	200	kva
Maximum time of averaging anode current*		
At 500 volts, rms.	9	seconds
At 250 volts, rms.	18	seconds
Maximum surge current, peak amperes.	280	per cent of maximum rms demand cur- rent

Intermittent Rectifier Service‡. Frequencies from 25 to 60 Cycles

Maximum peak anode voltage		
Inverse.	500	volts
Forward.	500	volts
Maximum anode current		
Instantaneous.	700	amperes
Average, per tube.	40	amperes
Averaging time.3	seconds
Surge, peak amperes, averaging time 0.15 second.	8000	amperes
Ignitor ratings same as for welder-control service		

Ignition Requirements (same for both classes of service)

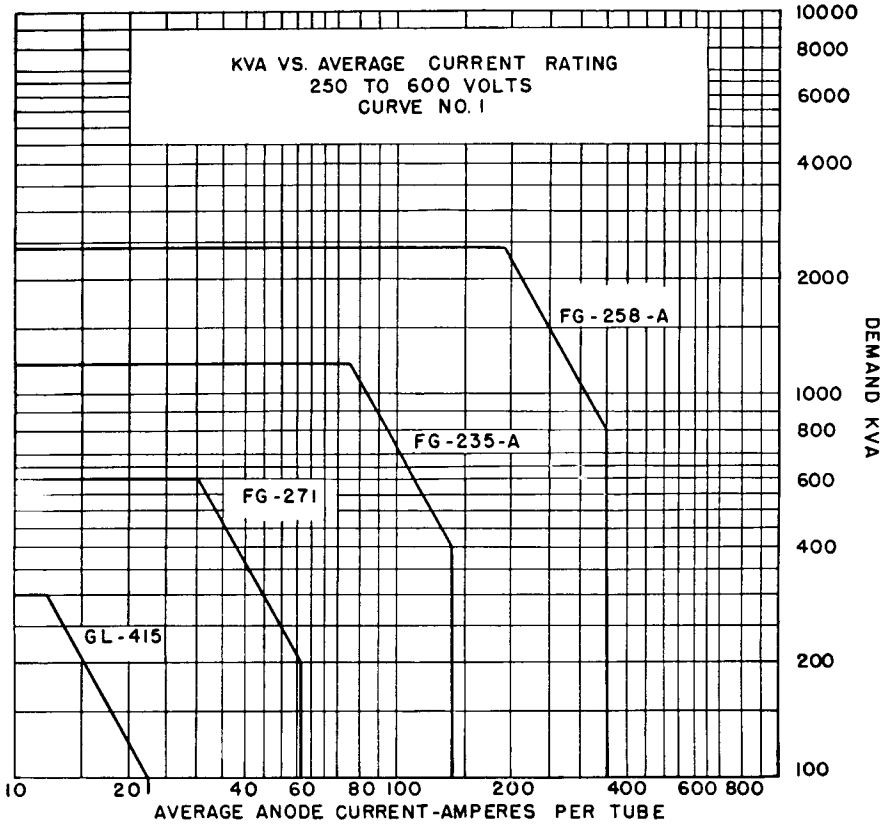
Ignitor voltage		
Maximum instantaneous allowed, ignitor positive.	900	volts
Maximum instantaneous required, ignitor positive§.	200	volts
Maximum instantaneous allowed, ignitor negative.5	volts
Ignitor current		
Maximum instantaneous allowed.	100	amperes
Maximum instantaneous required§.	30	amperes
Maximum average allowed.1	ampere
Ignitor ignition time, maximum§.	100	microseconds
Ignitor current, averaging time.5	seconds

* With the use of log-log paper, straight line interpolation between the two points tabulated may be used to determine other detailed ratings.

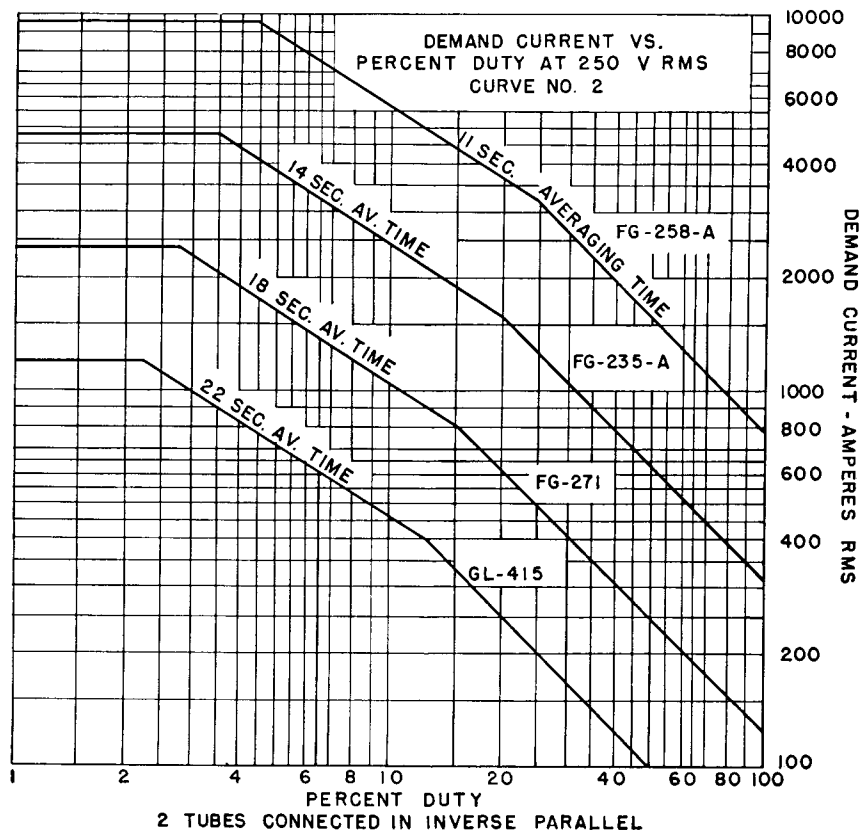
† Rms demand voltage, current, and kva are all on the basis of full-cycle conduction (no phase delay) regardless of whether or not phase control is used. For voltages below 250 volts, use the 250-volt rating.

§ Ignition will occur if either maximum required instantaneous positive potential is applied, or maximum required instantaneous current flows for the rated maximum ignitor ignition time.

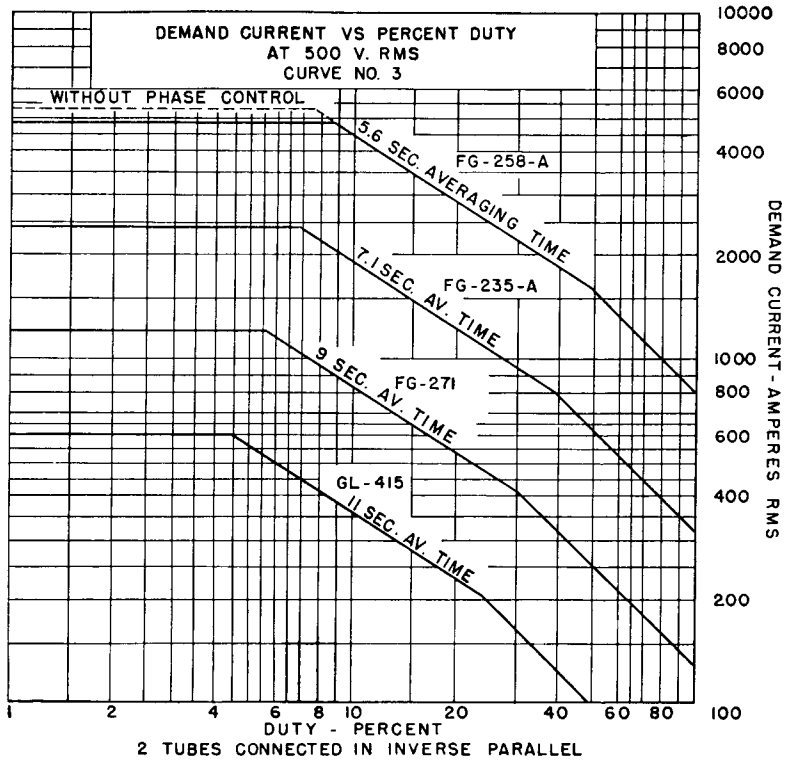
‡ The curves K-6966431, K-6966432 and K-6966433 (Figs. 1, 2, and 3) must not be used for intermittent rectifier service.



K-6966431 Fig. 1 7-1-44



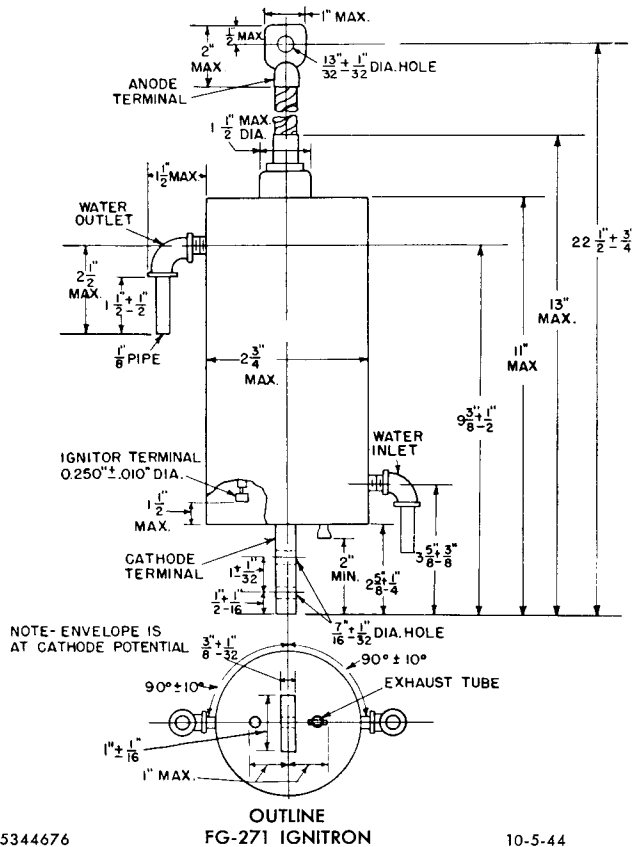
K-6966432 Fig. 2 7-1-44



K-6966433

FIG. 3

8-25-44



K-5344676

10-5-44

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