



5553-B

# 5553-B IGNITRON

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

*For resistance-welding control*

## GENERAL DATA

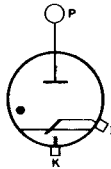
### Electrical:

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 $\mu$ sec
Tube Voltage Drop:	
At peak anode current of 13600 amperes. . . . .	36 volts
At peak anode current of 1115 amperes . . . . .	17 volts

### Mechanical:

Operating Position. . . . .	Vertical, flexible lead up
Maximum Overall Length (Including flexible lead). . . . .	31-3/8"
Maximum Radius (Including water connections). . . . .	4-11/16"
Weight. . . . .	21 lbs
Terminal Connections ( <i>See Dimensional Outline</i> ):	

P - Anode Terminal (Flexible lead)  
 K - Cathode Terminal (Bar opposite 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. . . . .	40 $^{\circ}$ C
Minimum water flow. . . . .	3 gpm
Maximum water-temperature rise. . . . .	9 $^{\circ}$ C
Maximum pressure drop . . . . .	5.1 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 . . . . .	600 max.	600 max. volts
Inverse . . . . .	600 max.	600 max. volts

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**ANODE CURRENT:**

Peak . . . . .	1140 max.	4000 max.	amp
Average (Averaged over any interval of 6.25 seconds maximum) . . . . .	190 max.	54 max.	amp
Average (Averaged over any interval of 0.2 second maximum) . . . . .	190 max.	666 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	50000 max.	50000 max.	amp

**RATING II**

**PEAK ANODE VOLTAGE:**

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

**ANODE CURRENT:**

Peak . . . . .	840 max.	3000 max.	amp
Average (Averaged over any interval of 6.25 seconds maximum) . . . . .	140 max.	40 max.	amp
Average (Averaged over any interval of 0.2 second maximum) . . . . .	140 max.	500 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	37500 max.	37500 max.	amp

**RATING III**

**PEAK ANODE VOLTAGE:**

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

**ANODE CURRENT:**

Peak . . . . .	672 max.	2400 max.	amp
Average (Averaged over any interval of 6.25 seconds maximum) . . . . .	112 max.	32 max.	amp
Average (Averaged over any interval of 0.2 second maximum) . . . . .	112 max.	400 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	30000 max.	30000 max.	amp

**RESISTANCE-WELDING-CONTROL SERVICE®**

*Two Tubes in Inverse-Parallel Circuit*

**Maximum Ratings, Absolute-Maximum Values:**

*For frequencies from 25 to 60 cps*

Ratings I-A and I-B Apply to Operation Either (1) Without Water-Saving Thermostat, or (2) With Water-Saving Thermostat Shunted by Auxiliary Contactor

**RATING I-A**

	Column 1*	Column 2*	
SUPPLY VOLTAGE (RMS) . . . . .	250 max.	250 max.	volts



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	Column 1*	Column 2*	
DEMAND POWER (During conduction) . . . . .	800 max.	2400 max.	kva
DUTY† . . . . .	24.6 max.	4.4 max.	%
ANODE CURRENT (Per tube):			
Peak . . . . .	4530 max.	13600 max.	amp
Demand (RMS, during conduction)* . . . . .	3200 max.	9600 max.	amp
Average (Averaged over any interval of 11 seconds maximum)* . . . . .	355 max.	192 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	27000 max.	27000 max.	amp

RATING I-B

	Column 1*	Column 2*	
SUPPLY VOLTAGE (RMS) . . . . .	600 max.	600 max.	volts
DEMAND POWER (During conduction) . . . . .	800 max.	2400 max.	kva
DUTY† . . . . .	59 max.	10.7 max.	%
ANODE CURRENT (Per tube):			
Peak . . . . .	1890 max.	5660 max.	amp
Demand (RMS, during conduction)* . . . . .	1330 max.	4000 max.	amp
Average (Averaged over any interval of 4.6 seconds maximum)* . . . . .	355 max.	192 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	11200 max.	11200 max.	amp

Ratings II-A and II-B Apply to Operation with Water-Saving Thermostat Not Shunted by Auxiliary Contactor

RATING II-A

	Column 1*	Column 2*	
SUPPLY VOLTAGE (RMS) . . . . .	250 max.	250 max.	volts
DEMAND POWER (During conduction) . . . . .	800 max.	2400 max.	kva
DUTY† . . . . .	12.2 max.	2.2 max.	%
ANODE CURRENT (Per tube):			
Peak . . . . .	4530 max.	13600 max.	amp
Demand (RMS, during conduction)* . . . . .	3200 max.	9600 max.	amp
Average (Averaged over any interval of 22.4 seconds maximum)* . . . . .	175 max.	96 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	27000 max.	27000 max.	amp

•, †, \*, #: See next page.

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## RATING II-B

	Column 1*	Column 2*	
SUPPLY VOLTAGE (RMS) . . . . .	600 max.	600 max.	volts
DEMAND POWER (During conduction) . . . . .	800 max.	2400 max.	kva
DUTY† . . . . .	29 max.	5.3 max.	%
ANODE CURRENT (Per tube):			
Peak . . . . .	1890 max.	5660 max.	amp
Demand (RMS, during conduction)* . . . . .	1330 max.	4000 max.	amp
Average (Averaged over any interval of 9.4 sec- onds maximum)* . . . . .	175 max.	96 max.	amp
Fault, for duration of 0.15 second maximum . . . . .	11200 max.	11200 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

\* RMS voltage, current, and demand kva are on the basis of full-cycle conduction (no phase delay) regardless of whether or not phase control is used.

† Defined as (cycles "on")/(cycles "on" + cycles "off") during the specified averaging time.

‡ For supply voltages between 250 volts and 600 volts, duty is proportional to supply voltage. For supply voltages lower than 250 volts, the values for 250 volts apply.

\* Column 1 represents operation at maximum average anode current; Column 2 represents operation at maximum demand power.

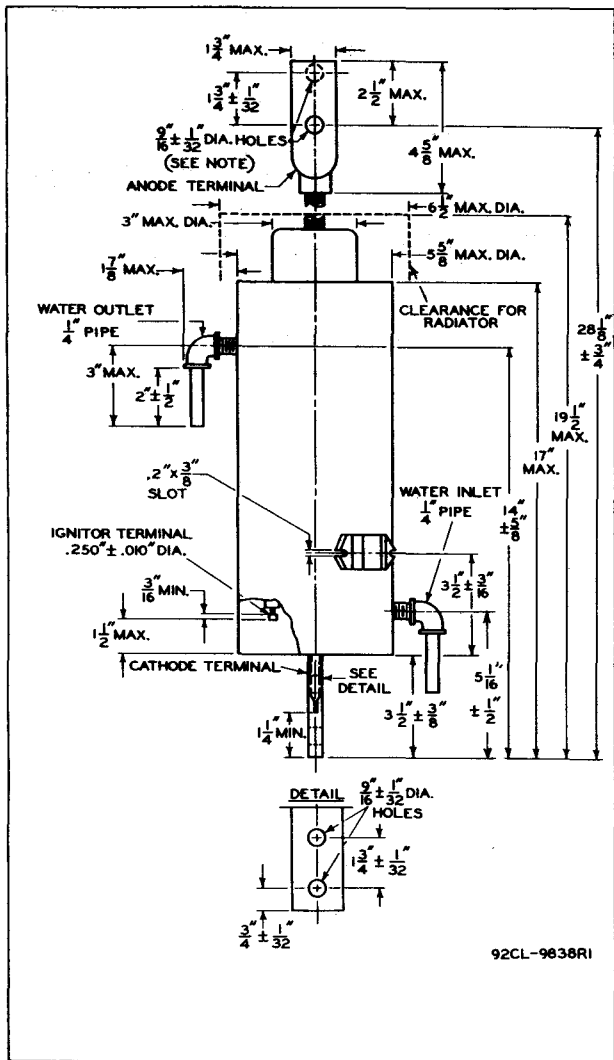
\* For supply voltages between 250 volts and 600 volts, demand anode current and averaging time are each inversely proportional to supply voltage. For supply voltages lower than 250 volts, the values for 250 volts apply.

**OPERATING CONSIDERATIONS**  
for the 5553-B are the same as  
those shown for Type 5551-A



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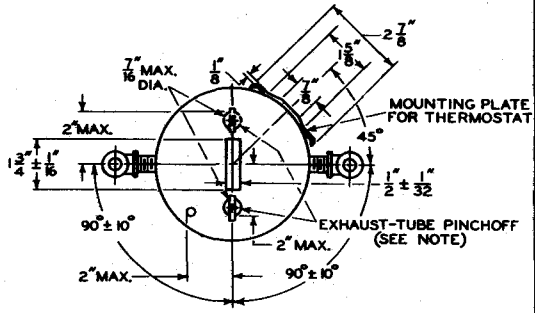
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# 5553-B IGNITRON

BOTTOM VIEW



NOTE: DASHED POSITION AT MANUFACTURER'S OPTION.

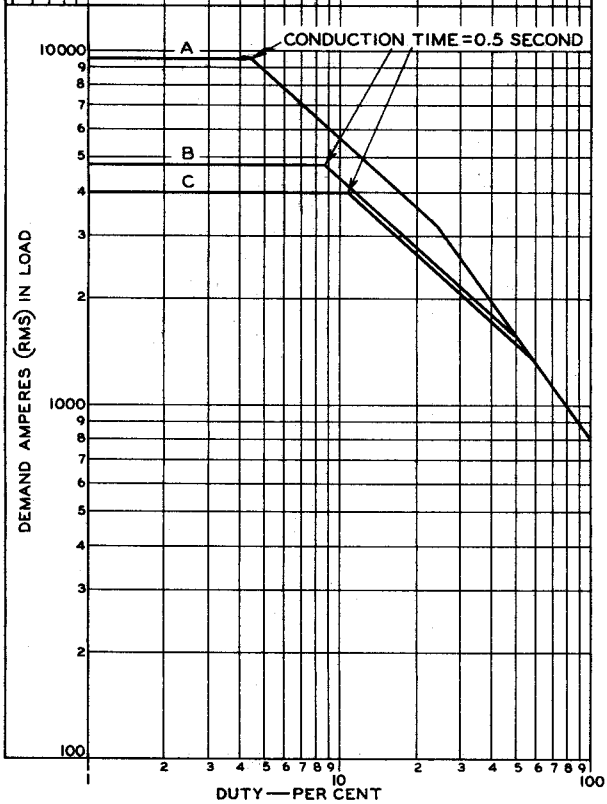


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# 5553-B RATING CHART RESISTANCE-WELDING-CONTROL SERVICE

TWO TUBES CONNECTED IN INVERSE PARALLEL.  
NO WATER-SAVING THERMOSTAT, OR WATER-SAVING THERMOSTAT SHUNTED BY AUXILIARY CONTACTOR.  
PROTECTIVE THERMOSTAT OPTIONAL.

CURVE	RMS ANODE-SUPPLY VOLTS	MAXIMUM AVERAGING TIME—SECONDS
A	250	11
B	500	9.2
C	600	4.6



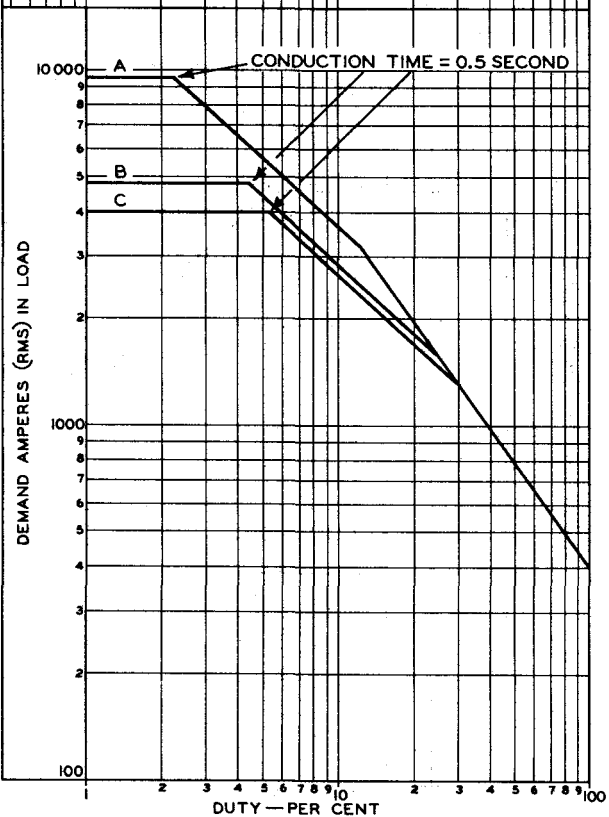
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**5553-B**  
**RATING CHART**  
**RESISTANCE-WELDING-CONTROL SERVICE**

TWO TUBES CONNECTED IN INVERSE PARALLEL.  
 WATER-SAVING THERMOSTAT WITHOUT  
 AUXILIARY CONTACTOR.  
 PROTECTIVE THERMOSTAT OPTIONAL.

CURVE	RMS ANODE-SUPPLY VOLTS	MAXIMUM AVERAGING TIME—SECONDS
A	250	22.4
B	500	18.8
C	600	9.4





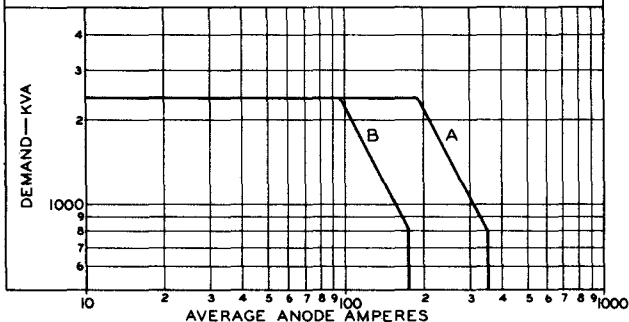


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### RATING CHARTS RESISTANCE-WELDING-CONTROL SERVICE

TWO TUBES CONNECTED IN INVERSE PARALLEL.  
RMS ANODE-SUPPLY VOLTS = 250 TO 600  
CURVE A: NO WATER-SAVING THERMOSTAT, OR WATER-SAVING THERMOSTAT SHUNTED BY AUXILIARY CONTACTOR.  
CURVE B: WATER-SAVING THERMOSTAT WITHOUT AUXILIARY CONTACTOR.



92CS-9825

### FREQUENCY-CHANGER WELDER SERVICE

