

**SAV 246.60**

**PERMANENT MAGNET WELDING BRACKETS**

Magnetic aid for welding and assembly with 90°

**APPLICATION**

For efficient holding of welding parts at a 90° angle. Used for small, lightweight parts to heavy sheets, depending in size. To avoid overloading the welding brackets thermally, we recommend using the magnetic aids only for the tack welds and then removing it.

**DESIGN**

Sturdy design, both faces are magnetic, easily released by applying pressure from the side. The normal version (N) is intended for workpieces with bright surfaces. The amplified version (V) is also suitable for workpieces with scaled or dirty surfaces. The tube version (R) welding brackets are equipped with prism-shaped pole shoes and are therefore particularly suitable for processing round materials and tubes. The 2-pole (2) magnetic brackets with 2 protruding magnetic bars are designed for the construction of large machinery, steel construction, shipyards, crane construction, etc. A stake attached to both sides facilitates alignment using a hammer. The welding brackets – starting with SAV 246.60 - 116 – are suitable for small, lightweight parts to applications in the construction of large machinery, shipyards, crane construction, etc. – finishing with SAV 246.60 - 450.



Design		Dimensions							
N (normal)	Side length	in mm	116/116	145/145	175/175	260/175	230/230	330/240	320/320
	Width	in mm	38	45	48	48	60	60	60
	Rated holding force*	in daN	32	38	58	88/95	-	-	-
	Displacement force*	in daN	14	16	26	42/44	-	-	-
	Weight	in kg	0.7	1.1	1.6	2.1	3.1	4.3	5.0
V (reinforced)	Side length	in mm	116/116	145/145	175/175	260/175	230/230	330/240	320/320
	Width	in mm	38	45	48	48	60	60	60
	Rated holding force*	in daN	48	52	79	132/142	-	-	-
	Displacement force*	in daN	21	24	35	63	-	-	-
	Weight	in kg	0.75	1.15	1.7	2.2	3.3	4.5	5.15
R (tube)	Side length	in mm	120/120	150/150	180/180	265/180	235/235	-	-
	Width	in mm	38	45	48	48	60	-	-
	Rated holding force*	in daN	-	38	50	88/95	-	-	-
	Displacement force*	in daN	-	16	22	42	-	-	-
	Weight	in kg	0.85	1.25	1.8	2.45	3.05	-	-
2-pole	Side length	in mm	350/350	450/450	-	-	-	-	-
	Width	in mm	60	60	-	-	-	-	-
	Rated holding force*	in daN	-	-	-	-	-	-	-
	Displacement force*	in daN	-	-	-	-	-	-	-
	Weight	in kg	8.4	11.5	-	-	-	-	-

\* The rated holding force and displacement force stated refer to a sheet metal thickness of 4 mm. More detailed influencing parameters can be found in the technical information (chapter 1.4).

**ORDERING EXAMPLE**

Designation SAV no. - max. side length - version  
 Permanent magnet welding bracket SAV 246.60 - 450 - 2