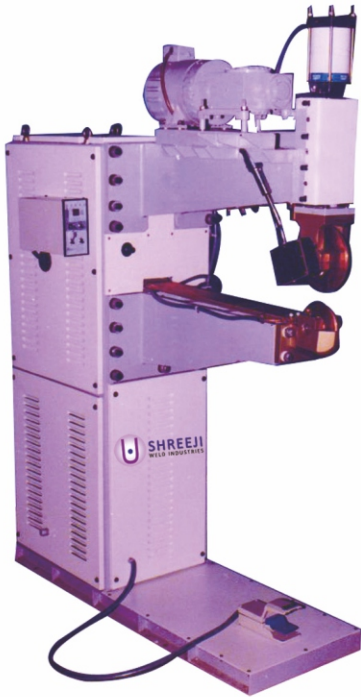




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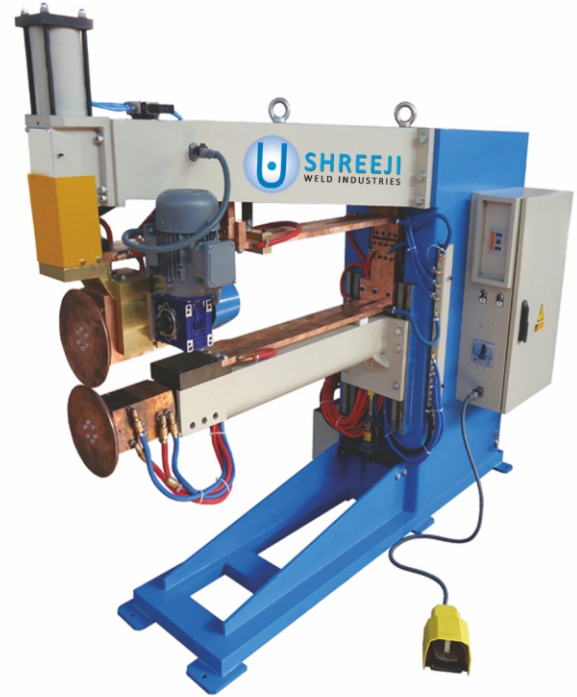
WELD INDUSTRIES



LONGITUDINAL



CIRCUMFERENTIAL



UNIVERSAL

SEAM WELDING MACHINES

INTRODUCTION : Offered in 50 to 200 KVA capacity, available in longitudinal / circumferential and universal versions. Precision built, sturdy design and robust construction suitable for high production and uninterrupted service in the manufacturing of drums, barrels, silencers, fuel tanks, transformer radiator, water heater & auto rims, etc.

These machines are always made to specific customer requirement with highly sophisticated & leak proof joints.

STANDARD RATING : 50,75,100,150 and 200 KVA

CONSTRUCTION : The main frame of the machine is of heavy rigidly reinforced & robust welded steel construction. It combines a compact streamlined appearance with maximum resistance to mechanical deflection. The welding transformer is enclosed in the main frame and is easily accessible, for inspection.

STANDARD THROAT DEPTHS (MM) : 280, 460 & 600 (other throat available on request)

NORMAL WORKING HEIGHT : 900 (mm)

WELDING TRANSFORMER : Transformer of a special type, water cooled, having core of high grade electrical steel, primary and secondary coils of solid electrolytic copper of ample section, heavy duty class & insulated, impregnated and tropicalised suitable for withstanding continuous temperature of 140° C.

CURRENT CONTROL : Transformer primary coils provided with taps brought out to tap change links for adjustment for welding current in a 6 step from 50 to 100%. Tap change links are enclosed behind machine door and are easily accessible for variation of welding heat.

COOLING SYSTEM : Transformer, secondary connections, arms and electrode wheels are water cooled. Internet water cooling piping with flow adjusting valves for each circuit and discharge to an open drain pot for visual observation of flow are provided in the machine.

We Also Manufacture : Arc Welders, Spot Welders, Butt Welders, Argon Arc Welders, Seam Welders, Pneumatic, Pedal Operated, Table Mounted, Portable and Resistance Heating Equipments.

SEAM WELDING MACHINES

ELECTRODE : Circular disc type top and bottom welding Electrodes.

ELECTRODE CONTROL SYSTEM : Upper electrode is actuated by hand lever to provide electrode force.

ELECTRONIC CONTROLS : Seam welders are provided with solid-state electronic controls housed in a well-designed sheet steel cabinet. The standard design of the cabinet is suitable for mounting it on the sidewall of the machine; floor mounting shall also be provided a request. The control knobs and panel are elegantly arranged, provided maximum convenience to the operator. The front panel is protected from misuse by providing a transparent guard door. All internal wiring is easily accessible for servicing. The circuit design is versatile enough for almost all type of requirements and consists of the following facilities. A squeeze time control to select the delay between initiation of the foot switch and the start of the weld. Timing is adjustable from 2-25 cycles, continuous Heat control circuit based on phase shifted firing of thyristors which enable continuous adjustment of current between 10% to 100% of then value available from welding transformer.

WELD INITIATION : By means of operators foot switch connected to a low voltage safe initiating circuit.

MOTOR DRIVE SYSTEM : Machine can be supplied with either A.C. or D.C. motor drive system as per customers choice. D.C. Motor driven system consists of an infinitely variable speed, reversible D.C. Motor, variac, rectifier & protective fuses system with reduction gear unit to provide stepless speed variation. A.C. Motor driven system consists 3-phase induction motor speed as constant.

Note : Machine shall be supplied with A.C. MOTOR DRIVE SYSTEM AS STANDARD UNLESS SPECIFIED otherwise by the customer.

SERVICE REQUIREMENTS : Customer to provide the following service facilities :

POWER SUPPLY : For Transformer : 415 V, Single phase, 50 cycles (suitable for connection to 2 lines of 3 phase supply). Main supply cable for transformer connection. Disconnect switch with fuses of recommended rating.

For Motor : 415 V, 3 phase, 50 cycles or 230 V, single phase, 50 cycles or 230 V, single phase, 50 cycles for D.C. motor drive, depending on the drive system selected supply cable 1.5 sq. MM 4 core, TPIC switch fuse unit 500 V, 15 Amps, with fuses of 5 Amps for D.C. motor Drive system.

COMPRESSED AIR : Supply of air recommended flow volume at minimum pressure of 5.6 kg/cm² (80 psi) by the customer.

TECHNICAL SPECIFICATIONS:

MODEL	UNIT	SW - 50	SW - 75	SW - 100	SW - 150
Normal Rating at 50% Duty Cycles	KVA	50	75	100	150
Continuous Rating Of Transformer	KVA	35	55	70	110
Supply Voltage 2 Phase 50 Hz.	V	451	451	451	451
Switch Fuse	A	100	150	200	250
Current Taps	Nos.	6	6	6	6
Throat Depth Std.	mm	280	460	610	610
Normal Working Heights	mm	900	900	900	900
Welding Capacity Mild Steel	mm	1+1	1.25 + 1.25	1.6 + 1.6	2 + 2
Water Supply Required	LPM	15	20	25	30
Drive Motor A.C.	HP	1	1	1.5	1.5
Dimension Overall :					
Heights	mm	1900	1900	1900	1900
Width	mm	900	900	900	900
Depth	mm	1050	1050	1200	1200
Weight Approx.	kgs	700	850	1100	1250



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