

UPSET BUTT WELDING MACHINE

APPLICATIONS - include upset butt welding of all profiles of wires and flats of iron, steel, alloy and carbon steel, copper, Aluminium, brass and other light metals and their alloys.

USERS INCLUDE - but are not limited to wire and strip and rod drawing mills transformer motor and switch gear manufacturers band saw and hacksaw blade users, small tool makers such as for welding mild steel shanks to the alloy steel portion of taps, drills, bits, screw drivers chisels, etc.; hoop and ring makers; wire forming industries; cable industries; automobile industries air-conditioner and refrigerator makers; office equipment makers, etc.

The machines are aesthetically designed as portable models mounted as standard on a moveable stand fitted with four wheels. They are constructed with particular for quick, easy and fool-proof operation by unskilled workmen, the welding process being automatic. The settings are simple, finely adjustable and reproducible for all variables. Uniform welds of high strength capable of withstanding subsequent drawing are ensured.

WELDING PROCESS - Fix the 4 simple settling, Clamp-job end to end. Return spacing lever to 'Weld' position. The welding then takes place automatically. Unclamp job. To anneal, put spacing lever to max. position. Clamp job centrally in annealing Clamps. Hold down current switch till annealing temperature is reached.

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

UPSET BUTT WELDING MACHINE

TYPE - Automatic Upset But Welding machine type UBW-415, designed as a portable model for heavy duty operation.

CONSTRUCTION - Machine housed in a sturdy light alloy housing well ventilated and provided with covers for accessibility to internal parts. All high voltage components housed within the body.

UPSET TRAVEL - Moveable platen travel on parallel guides of precision design and construction ensuring accurate and frictionless travel and perfect alignment of the weld.

UPSET PRESSURE - Provided by a precision spring, acting on the moveable platen and micro metrically adjustable by means of a knob, the setting being readable on a scale.

CLAMPS - Lever operated, adjustable "floating" steel clamps of precision quick acting design, ensure firm preset clamping pressure. Release is quick and easy.

ELECTRODES - Special wear resisting copper alloy electrodes provided with precision V-grooves for different wire sizes, permit rapid and accurate alignment of wires.

WELDING CURRENT ADJUSTMENT - By means of a 8 step rotary switch, the knob of which is located on the Left hand side, enabling current adjustment from 501.to 100/'

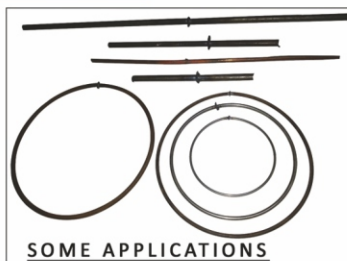
ELECTRODE SPACING - Obtained with ease by a lever set against an indexing plate, providing adjustment in 10steps between minimum and maximum.

WELDCURRENTINITIATION - Return of the lever after clamping the job to weld position simply starts the automatic welding cycle.

CURRENT CUT OFF - Adjustable over a wide range by means of a micrometric thimble the setting of which is read on a graduated scale.

ANNEALING FACILITY - Separate annealing electrodes with screw type clamps are provided for easy and quick annealing of the welded job ensuring a flexible zone at both sides of the weld.

PORTABILITY - The machine is mounted on a four-wheeled trolley type stand for easy portability.



WELDING RANGE	H.C.	M.S.	Cu.	Brass	Alu.
Wire DIA in m/m	4-10	4-15	4-8	4-10	5-10
Cross Section m/m ²	12-80	12-150	12-50	12-80	20-80
No. of thermally permissible welds per hour	75	75	30	75	100

TECHNICAL SPECIFICATIONS:

Model:	SUBW-20	SUBW-25	SUBW-30	SUBW-40	SUBW-50	MUBW-60
Max. Rating (KVA):	20	25	30	40	50	60
WELDABLE MATERIAL						
Mild Steel (diameter mm):	4-14	5-16	6-17	8-18	10-20	16-22
High Carbon Steel (diameter mm):	4-11	5-12	6-13	7-14	8-15	10-16
Copper (diameter mm):	4-8	5-9	6-10	7-11	8-12	10-14
Brass (diameter mm):	5-10	6-11	7-12	8-13	8-14	10-16
Aluminium (diameter mm):	5-10	6-11	7-12	8-13	8-14	10-16
Carbon Steel Blade (width mm):	30-50	30-60	35-75	--	--	--
Bimetal Blade (width mm):	20-37	25-41	30-45	35-50	35-60	40-65
Fuse (Amps):	40	50	75	100	125	150
Machine Duty Cycle:	10%	10%	10%	10%	10%	10%
Dimensions (mm):	710 x 675 x 1340					



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