High Heat Input Submerged arc Welding Equipment

High Efficiency and High Quality Welding of Box Column Corner Joint

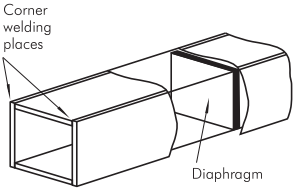
The size of box columns became larger as steel structures became taller and larger and this welding equipment was designed to carry out the welding of the corner joints of box columns with efficiency and stable quality. The mechanism to provide especially stable welding is built into the equipment since there are connection joints which require full penetration and long welding lines in the corner welding of thick plates. Adoption of the twin-tandem process using high current assures good operational efficiency and welding joints without defects.

CHARACTERISTICS

1. Stable bead with deep penetration and little distortion is obtained since corners of both sides of column are welded at the same time with high current.
2. A built-in preset type welding current adjustment unit makes observation of multiple eletrodes easy.
3. Proper amount of flux is supplied to the proper place by the combined mechanism of automatic flux supply and recovery unit and a unique flux hold mechanism.
4. It is equipped with a high performance tracking device to detect groove position accurately.
5. It can be used for the welding a wide range of box columns from 400mm to 1600mm.

■ RECOMMENDED WELDING MATERIALS

Base metal	Wire	Flux	Remarks
Mild steel and 490MPa high tensile strength steel	Y-DL (4.8, 6.4mm)	NSH-60S	Single-layer welding of plates up to about 65mm thickness.



<External Appearance of BOX WELDER>