

Submerged Arc Welding (SAW)



Features

> MET-WELD makes welding equipments with advance technology. Submerged Arc Welding (SAW) machines are mostly used in heavy pipelines, tanks, vessels and cylinders manufacturing industries. SAW arc welding provides more operator comfort than any other arc welding process. The granular flux almost completely covers the arcs, which minimize blush, glare, heat, smoke and fumes. This process is typically some three to ten times faster than stick electrodes welding. The ripple free, no spatter submerged arc welds need machining or grinding. Slag peels off little or no chipping. Easy cleaning minimizes labour costs and speeds production. Submerged arc deposits are low in hydrogen, feature excellent crack resistance and generally superior weld quality and consistency.

Equipment Consists Of

> Thyristorised Power Source, Carriage mounted/Boom mounted Welding Head, Control Panel and Inter connection.

Power Source

> Constant voltage / Current Power Source, Thyristorised Controlled, Fitted with Amps & Volt meter on control panel, Remote control facility provided, due to built-in voltage stabilizing facility no effect of input supply fluctuation on wire feed motor speed & output voltage.

Welding Head(Wire feeder)

> Four alloy steel rolls driven hardened case, Quick changeover of spool, Thyristorised D.C Drive permanent magnet motor to maintain constant speed of trolley as well as wire feeder.All control of power Source voltage setting, wire feeder motor speed, Carriage Motor speed and Reverse/Forward operations provides on control panel for easy access.

PARAMETERS	MSW-600	MSW-800	MSW-1000	MSW-1200
Supply Voltage	380-440V	380-440V	380-440V	380-440V
Phase	3	3	3	3
Frequency	50 Hz	50 Hz	50 Hz	50 Hz
Open Circuit Voltage	16-52 V	16-52 V	16-52 V	16-52 V
Primary Current at Max. Output	40 A	55 A	70 A	83 A
Welding Current 60% Duty Cycle	600 A	800 A	1000 A	1200 A
KVA Rating	31	42	52	64
Welding Cable Section Cu (mm ²)	95	110	120	120
Insulation Class	F	F	F	F
Type of Cooling	Forced Air	Forced Air	Forced Air	Forced Air
Type of Winding	Copper	Copper	Copper	Copper