

INVERTER BASED TANDEM SAW SYSTEM

Tandem SAW system is two wire one arc SAW process in which both DC and AC power is used for the two wires. Two independent power sources capable of delivering DC and AC is used in the system. The system offers high deposition efficiency when compared to single wire SAW system. We use inverter based power source for both DC and AC. The AC power source is capable of delivering either DC or square wave AC out put.

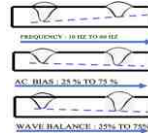
Features

- Both DC and AC/DC power sources are IGBT inverter based with latest soft switching technology
- Both Power sources are microprocessor based for precise control
- High Energy efficiency and low volume compared to conventional system
- Higher power factor and precise out put and hence better weld quality
- Both power sources have CC/CV function
- Square wave out put in AC/DC power source with adjustable AC frequency, Wave Balance and AC Bias
- Digital control panel with digital display for Voltage, Current and trolley speed
- Wire Selection for different wire sizes
- Memory channel to store the data

Basic Outfits

	Trolley Type	C&B Type
DC Power Supply Model Autoweld 1250 IDC	✓	✓
AC DC Power Supply Model Autoweld 1200 IADC	✓	✓
2 Numbers of 16 mtrs control cable	✓	✓
Wire Cutter	✓	✓
4 Wheels Tractor Trolley	✓	X
Wire Feeder Head Assembly & Control Box with Swivel Mechanism	X	✓

Effect of frequency, AC Bias & Wave Balance on penetration



Technical Specifications

Trolley/ C & B Head Specifications

Model	DC AUTOWELD-1250 IDC		AC/DC AUTOWELD-1200 IADC		Model	Trolley		C & B Type	
Input Supply	380~440 Volts 3 Phase 50 Hz Supply				Wire Diameter	2.5,3,15,4,5&6			
Duty Cycle	100%				Wire Feed Range	300~3000 MM/MIN			
Insulation Grade	H				Trolley Speed	100~1400 mm/min	Not Applicable		
Welding current Range	100~1250 Amps	100~1200 Amps			Welding Head Vertical adjustment range	100mm	100mm for each torch		
Voltage setting Range	25~44 Volts	20~44 Volts			Welding Head horizontal adjustment range	60mm	100mm for each torch		
Open Circuit Voltage	90 Volts				Column Lifting range	100mm	Not applicable		
Input Power	66 KVA	64KVA			Wheel Base	300mm	Not applicable		
Power factor	0.93	0.9			Adjustable distance between arc	25~75 mm	25~75 mm		
AC Frequency Range	NA	10~60 Hz			Swivel Mechanism to suit for LS & CS	Not Applicable	Provided		
AC Bias	NA	25~75 %			Dimensions	1150x850x850			
Wave Balance	NA	25~75 %			Weight	71kg			
Dimensions of Power Source (DxWxH mm)	795x410x835	930x470x1250							
Weight	96 Kg	180 Kg							

Specifications may be subjected to change without notice.



C & B TYPE



TRACTOR TROLLEY