

SAW WELDING



Submerged arc welding (SAW) is a semi-automatic or fully automatic consumable electrode arc process in which the arc is protected by a granular, fusible flux which blankets the weld puddle and surrounds the base metal to protect it from the atmosphere.

Powder alloys can be added with the flux to utilize the existing heat produced by SAW to melt powders and thereby increase deposition rates.

The flux stabilizes the arc, provides slag coverage, and also controls the properties of the deposit.

Consumables are in the form of wire or strips.

High deposition rates using current upto 1800Amps in DC mode allows,

Deep penetration,
Easy slag removal
Smooth and excellent quality welds

are common with this process. SAW is a highly productive process for surfacing large areas.

Fully automatic systems are used for heavy depositions in various areas such as

Surfacing continuous casting rolls,
Blast furnace bells,
Forging die block,
Inside of ball mill shell
Welding of pressure / chemical vessels

Aircraft has introduced very high quality of IGBT based inverterized power sources suitable with advantages like
Highly stable arc,
Precision output control,
Ease of operation,
Thermal protection from overheating,
Sturdy Tractor unit



Specifications:

POWER SOURCE

Parameters	SAW600	SAW1000	SAW1200	SAW1500
Mains Input	415Vac \pm 10%	415Vac \pm 10%	415Vac \pm 10%	415Vac \pm 10%
Phase/Frequency	3-Ø /50-60Hz	3-Ø /50-60Hz	3-Ø /50-60Hz	3-Ø /50-60Hz
Output Current Range (A)	40 – 600	120 – 1000	150 – 1200	200 – 1500
Output Voltage Range (V)	15 – 45	16 – 46	18 – 50	20 – 60
Input Current Max. (A)	52	96	182	184
Duty Cycle (%)	100	96	100	100
Insulation class	F	F	F	F
Type of cooling	Forced Air	Forced Air	Forced Air	Forced Air
Dimensions W x H x L (mm)	340 x 710 x 680	550 x 710 x 680	650 x 710 x 680	650 x 1450 x 680
Weight (Kg)	90	120	160	250

HEAD / TRACTOR

Parameters	SAW600	SAW1000	SAW1200	SAW1500
Wire diameter range (mm)	2.4 – 4.0	2.4 - 5.0	2.4 – 5.5	2.4 - 6.3
Wire feed speed (cm/min)	50 – 500	50 – 500	50 – 500	50 – 500
Vertical adjustment (mm)	100	100	100	100
Horizontal adjustment (mm)	100	100	100	100
Swivel arrangement (Deg)	360°	360°	360°	360°
Torch tilt (Deg)	\pm 45°	\pm 45°	\pm 45°	\pm 45°
Tractor Speed (cm/min)	15 – 150	15 – 150	15 – 150	15 – 150
Hopper capacity (Kg)	15	15	15	15
Wheel center (cm)	300	300	300	300
Dimension W x H x L (mm)	375 x 775 x 1100	375 x 775 x 1100	375 x 775 x 1100	375 x 775 x 1100

Standard Supply Includes

Power Sources

Welding Tractor with control box, Welding head, Flux copper, Wire reel holder

Single track - 2 mtr length

Interconnecting cable 5 mtr length

Earthing cable 5 mtr length

Specifications subject to change without notice

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