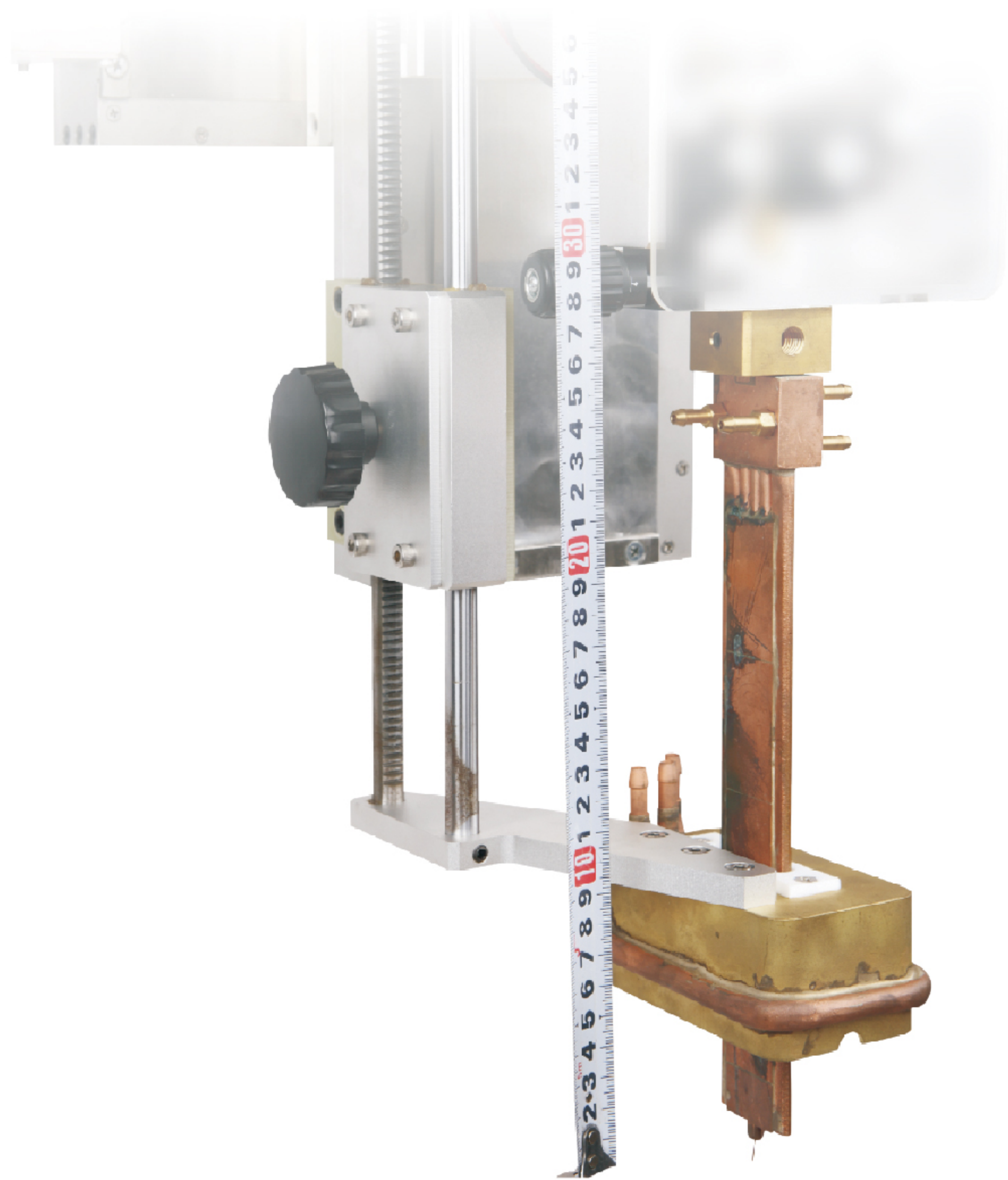
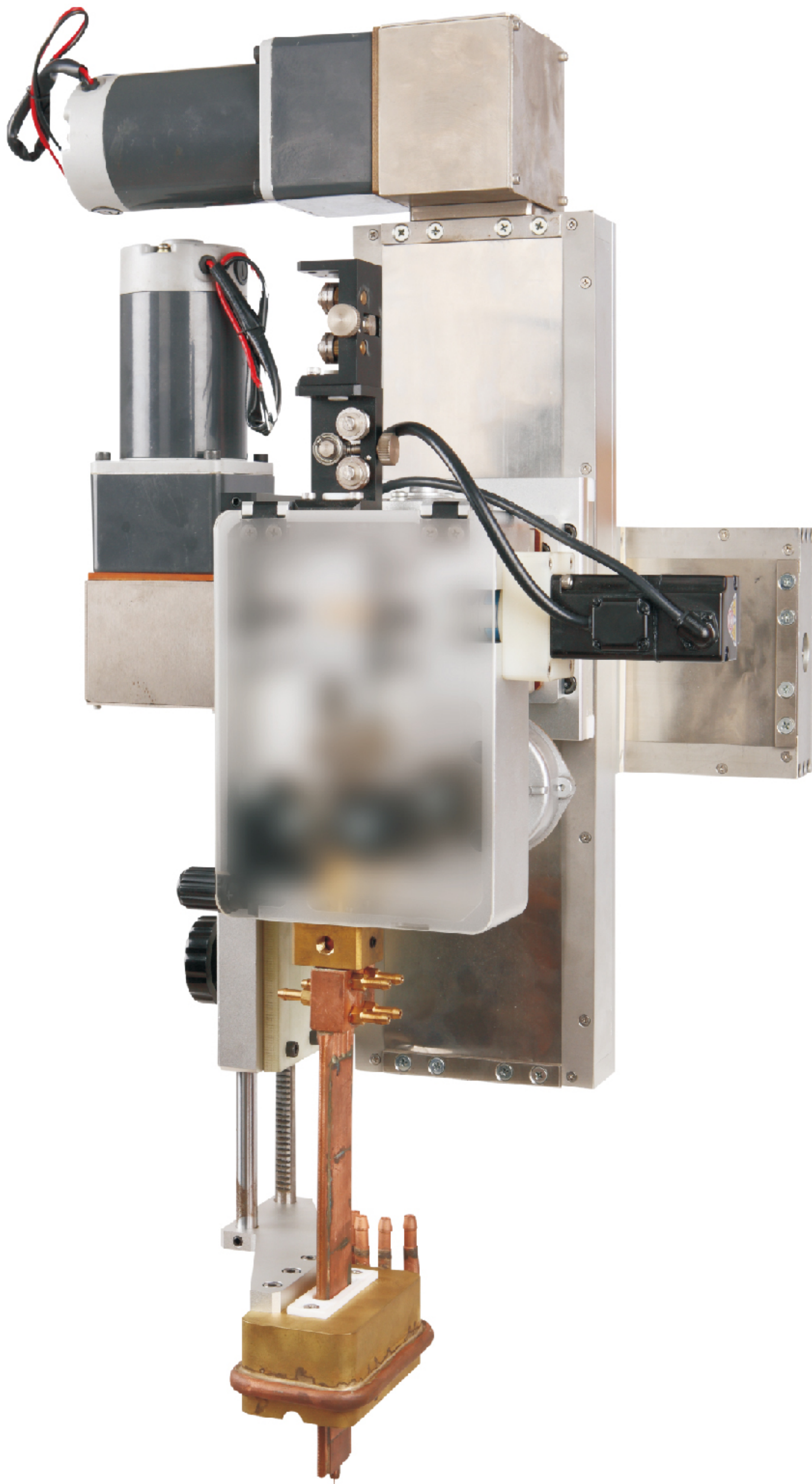


Steam Turbine Industry

Narrow Groove Welding System For Grating Baffle



Summary

The system consists of a narrow slot MIG welding torch, manipulator, positioner and MIG digital welding power supply. It has a PLC control center to control all sectors working together to finish narrow groove continuous or discontinuous welding. This system is suitable for narrow groove with welding depth of 250 mm (9-12 mm in width and 1/100-2/100-1 groove in inclination). By endowing the welding wire with bending characteristics and using its waveform formed by the welding wire, the two walls can be fully penetrated at the groove, thus obtaining a high-quality welded joint that passes through one layer at a time. It is used in power industry, valve industry, coal mine machinery industry, construction machinery, boiler industry, etc.

Performance characteristics

- It is suitable for applications with wall thickness greater than 9mm;
- Wire vibration technology is adopted to ensure double-sided penetration at groove;
- High deposition rate and low energy input;
- Suitable for horizontal welding, vertical welding in longitudinal seam and girth seam;
- High duty ratio with water cooling torch;
- Dual-shielding gas design;
- OD range: $\Phi 19$ - $\Phi 101$;
- Applicable to carbon steel, stainless steel and other materials.

Technical data

Bevel type	U Type, J Type
Suitable wall thickness(mm)	30~250
Suitable bevel width(mm)	9~20
Max.welding current(A)	350
Max.wire feeding speed(mm/min)	24000
Wire diameter(mm)	$\Phi 1.0$, $\Phi 1.2$
Shielding gas	Mixed gas
Cooling type	Water cooling
Weight(kg)	5
Dimension(mm)	320x200x600