

TANDEM SAW (WELDING) SYSTEM

Tandem Welding System is a SAW process in which both AC and DC power sources are used to increase the deposition efficiency. In this Tandem Welding System both the DC and AC/DC power Source is transformer based with thyristor controlled system. The trolley used can handle two wire spools and has individual wire feed units and a combined unit to control the voltage and current of both the power source.

Basic Outfits

- 1250 Amps thyristor controlled DC power source
- 1250 Amps thyristor controlled AC/DC power source
- Tractor with Twin Head
- 15 meters control and welding cable set for each power source
- 5 meters earthing cable for each power source

Features

- High speed welding can be done easily to achieve higher deposition efficiency
- The power sources can be used independently to weld either in DC mode or AC mode if required.
- High open circuit voltage for better arc strike
- CC/CV mode for SAW as well as SMAW application under manual mode
- Wire feed will stop when wire touches job.
- Accurate burn back feature.
- Good Dynamic characteristics for better welding results.



Technical Specifications

Sr. No.	Parameters	AUTOWELD-1250 TDC	AUTOWELD-1250 TADC
1	Input Supply	3 Wire 3 Phase 380 ~ 440 Volts, 50 Hz Supply	2 Wire 3 Phase 380 ~ 440 Volts, 50 Hz Supply
2	Input Power (KVA)	83	125
3	Max. Input Current at Full Load (Amps)	115	175
4	Open Circuit Voltage	75 DC	80 DC / 85 DC
5	Rated Welding Voltage (V)	44	44
6	Rated Welding Current (A)	1250	1250
7	Voltage Adjusting Range (V)	27 ~ 44	25 ~ 60
8	Current Adjusting Range (A)	100 ~ 1250	250 ~ 1250
9	Rated Duty Cycle	1250A @ 60% Duty Cycle	1250A @ 60% Duty Cycle
		968A @ 100% Duty Cycle	968A @ 100% Duty Cycle
10	Insulation Grade	F	F
11	Adjustable Frequency Range	Not Applicable	8 ~ 13.5 Hz
12	AC Balancing	Not Applicable	Can be set at 36, 50 OR 54%
13	Dimensions (LxWxH in mm)	950 x 640 x 810	780 x 665 x 1370
14	Weight (kg)	370	610

Technical Specifications

Sr. No.	Parameter Description	Specification
1	Input Supply	Taken from the main Power Source
2	Suitable Wire Diameter (mm)	3, 4, 5 & 6
3	Wire Feeding Speed (mm / min)	80 ~ 1700
4	Trolley Speed (mm / min)	150 ~ 2250
5	Vertical Adjusting Range (mm)	95
6	Horizontal adjusting Range (mm)	60
7	Distance between Two Arc (mm)	30 ~ 70
8	Angle of Two Arc (Degree)	0 ~ 15
9	Capacity of the Flux Hopper (Ltrs)	10
10	Dimensions (LxWxH in mm)	1100 x 660 x 900
11	Weight without Spool and Flux (kg)	90

Specifications may subject to change without notice.