

M 34

Weld Head For Low Radial Clearance Applications

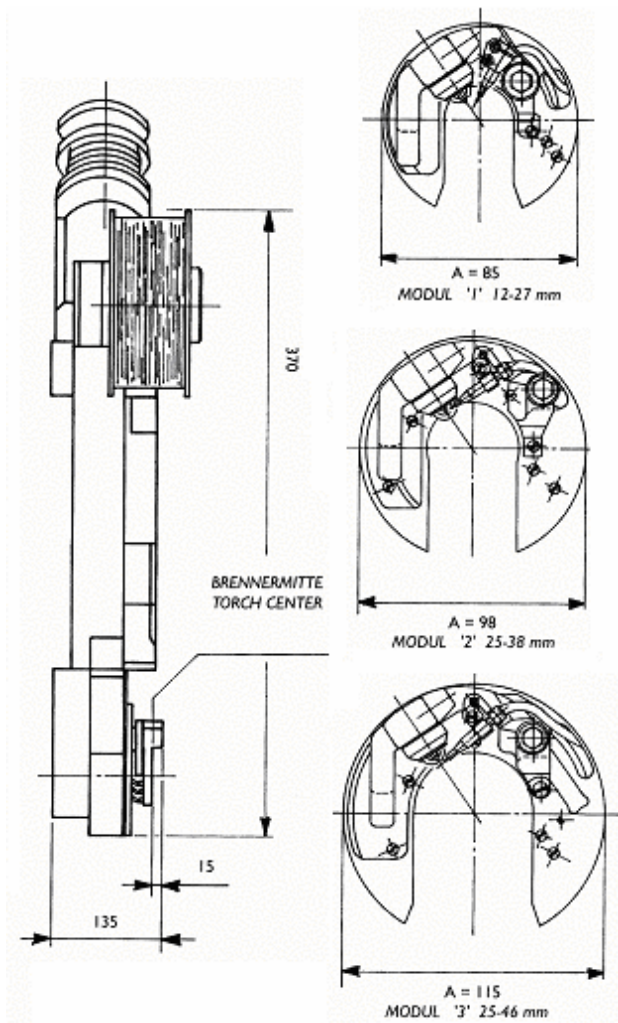


The M34 weld head has been designed to enable the welding of boiler tubes in heat exchangers.

This head allows this task to be carried out using a precision Orbital Welding Power Supply, such as the ORBIMAT C range. This means that not only is the rotation of the torch consistent and the delivery of the welding current is also kept constant and can be varied around the circumference of the tube.

The M 34

- ✚ Weld Boiler Stacks
- ✚ Minimal Straight on One Side Only
- ✚ Eliminate Mundane Welding Tasks
- ✚ Achieve Guaranteed Results Every Time
- ✚ Increase Operator Efficiency



Minimum clearance between the tubes can be calculated using the following simple formula.

$$\begin{aligned} \text{MODULE '1' TUBE 12-27 mm} &= \frac{85 - D}{2} + 2 \\ \text{MODULE '2' TUBE 25-38 mm} &= \frac{98 - D}{2} + 2 \quad (D = \text{External tube diameter}) \\ \text{MODULE '3' TUBE 25-46 mm} &= \frac{115 - D}{2} + 2 \end{aligned}$$

Technical Specification

Welding Position – Horizontal, Vertical, Inclined

Welding Process – TIG with or without filler

Welding Current – Maximum 200Amps

Tube Diameter Range – 12 to 46mm OD

Head Body – Water Cooled

Weld Torch – Water Cooled

Clamps – Water Cooled

Torch and Wire Nozzle – Adjustable on 3-axis

Supply of Gas, Water And Current is via a self wrapping multiple hose of Viton.

Rotation & Wire Motor – 18v DC

Rotation Speed – 0.3 to 2 rpm

Wire Speed – 0.15 to 1.5 m/min

Wire Spool – 1 kg mini spool 100mm

Filler Wire Diameter – 0.6mm or 0.8mm

Electrode Diameter – 1.6 to 2.4mm

Weight – 5.5 kg (Excluding Cables)

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