

Art. no. .11.300.104

Fillet Welding Automat

UPK

Welding automat for single wire SAW with wires up to 4 mm diameter for fillet welding on level plates.

Due to its specialisation in fillet welding and little weight, this automat is a low-priced alternative to conventional automats. It is particularly suitable for steel construction, bridge and ship building.



Application Advantages

- Specialised in fillet welding
- Simple guiding on the work-piece along the web plate by means of supporting wheel
- Smooth run over tacks due to slot in supporting wheel
- Mobile and easily transportable
- Pre-set values for welding current, arc voltage and travel speed in connection with Kjellberg power sources
- Automatic start and stop circuit for optimisation of welding process
- Separately adjustable start-up phase and end crater filling phase
- Exact positioning of the welding head ensures optimal seam geometry

Main Features

- Model with three wheels
- Tachometer-controlled carriage, temperature-resistant driving wheels \varnothing 160 mm, supporting wheel in steel version with V-slot
- Robust wire feeding unit with four-roller drive
- Maximum wire diameter 4 mm
- Swivel unit for manual positioning of the welding head, swivel range 15 – 45°
- Adjustment along the nozzle stock (stick-out) 50 mm
- Operation with pre-set values for welding current, arc voltage and travel speed as well as two separate control levels for active and passive control elements
- Stepless adjustable supporting wheel guides the carriage along profiles, webs and flanges
- Wire feeding head for K435 basket coil
- Flux hopper with 6 l capacity, with sight glass for filling level control

Options

- A pneumatic flux recovery unit working on the basis of injection principle can be connected to the flux hopper.
- The standard package contains the welding rectifier GTH 802. Additionally, the Kjellberg power sources GTH 522, GTH 1002 and GTH 1402 can be used.

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Technical Data:

Application		SAW single wire
Welding current max.	(A)	800
Control voltage	(V/Hz)	42 AC / 50
Travel gauge	(mm)	360
Wire diameter	(mm)	1.6 – 3.0 (4.0)
Wire feed speed	(m/min)	0.1 – 10
Travel speed	(m/min)	0.1 – 2
Adjustment along the nozzle block	(mm)	50
Welding head inclination	(degree)	15 – 45 (one-sided)
Weight	(kg)	42
Wire coil capacity max.	(kg)	30
Dimensions L x W x H	(mm)	≈ 650 x 500 x max. 850

- EN 60974-1 (VDE 0544), BGV D1 (VBG 15, UVV 26.0) and CE sign, produced according to DIN EN ISO 9001
- S sign, applicable for welding jobs at work places with increased electrical endangerment

Art. no.	Description	EUR/piece
.11.300.104	Fillet welding automat UPK for single wire SAW up to 4 mm wire diameter, consisting of: carriage, wire feeding head (4mm), control unit, wire feeding support, flux hopper (6 litres), equipped for wire-Ø 3.0 mm (without flux recovery)	Please see current price list
.11.300.104.S1	In combination with welding rectifier GTH 802: <ul style="list-style-type: none"> • With 2 pieces work-piece cable 95 mm²/length 10 m (.11.500.700.446) • With cable set KA1-UP, length 10 m (.11.500.710.010) • With welding rectifier GTH 802 (.11.705.902.S4) 	Please see current price list