Kjellberg Finsterwalde
Schweißtechnik und
Verschleißschutzsysteme GmbH

Submerged Arc Welding	Welding Automat Single Wire up to 3 mm	KA 1-UP

Welding automat for SAW with wires up to 3 mm diameter on even plates with or without guide rails (butt and fillet seams) and for inside welding of tubes. In connection with Kjellberg Welding Rectifiers various technological solutions for an effective application in different industries are given.



Advantages for Application:

- Mobile, self-propelled welding automat, which easily can be moved to any working place
- Flexible application because of modular principle
- Pre-set controls for welding current, arc voltage and travel speed in connection with Kjellberg power sources
- Start and stop circuit for optimising the welding process
- Start and crater filler parameters separate to adjust
- The tractor runs directly on the workpiece or on rails
- Easy adaptation to other welding technologies
- Versatile welding head positioning ensures optimal seam geometry
- Inside welding of tubes and boilers with min. 1,500 mm diameter

Main Features:

- Tachogenerator controlled tractor with all-wheel drive; 160 mm diameter wheels, with rubber or grooved rims (optional); dust protected manual drive coupling; axle extensions for increasing the track gauge from 265 mm to 330 or 395 mm
- Tachogenerator controlled wire feed gear with four-roller drive for wire diameters 1.6 to 3.0 mm
- Cross slides for manual head adjustment of max. 100 mm in horizontal and vertical direction
- Controls with parameter pre-setting for welding current, arc voltage and travel speed in the first service level and start and stop parameters in the second service level
- Side rollers to guide the tractor along bars, profiles, etc.
- Reel holder
- Flux hopper with 6 l capacity, with sight glass, prepared for connection of a pneumatic flux recovery (optional)
- Laser pointer for visual wire-to-seam control

EN ISO 9001:2008
DNV Certified Company

Ein Unternehmen der
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Technical data:

Technology		**SAW - single wire**
Welding current	(A)	800
Control voltage	(V/Hz)	42 AC/50
Travel gauge	(mm)	265/optional 330 or 395
Wire diameter	(mm)	1.6 – 3.0
Wire feed speed	(m/min)	0.1 – 10
Travel speed	(m/min)	0.1 – 1.6
Cross/height adjustment	(mm)	100/100
Column swivel range	(degree)	360
Welding head inclination	(degree)	45 (to both sides)
Tube inside welding	(mm)	1500
Weight	(kg)	51
Wire reel capacity	(kg)	30
Dimensions L x W x H	(mm)	≈ 1,050 x 600 x ≈ 900

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

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