Kjellberg Finsterwalde
Schweißtechnik und
Verschleißschutzsysteme GmbH

Submerged Arc Welding	Welding Automat, steerable Single Wire up to 5 mm	KA 1-UP



Steerable welding automat for SAW with wires up to 5 mm diameter for inside welding of tubes and tanks (butt and fillet seams). 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 automate, which can easily be moved to any workplace
- 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
- Easy adaptation to other welding technologies
- Versatile welding head positioning by steering unit 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 rims (optional); dust protected manual drive coupling; track gauge 395 mm
- Wire feed gear with two-roller drive for wire diameters 2.5 to 5.0 mm for SAW single-wire welding
- Cross slides for manual head adjustment of max. 100 mm in horizontal and vertical direction
- Manual cross (electrically on request) slide with steering unit
- 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.
- High stability by double steering wheels
- Reel holder
- Flux hopper with 10 l capacity, with sight glass, prepared for connection of a pneumatic flux recovery (optional)
- Two local lightings for dark work stations
- Laser pointer for visual wire-to-seam control
- Water-level for optimum positioning in the tank

EN ISO 9001:2008 DNV Certified Company

Ein Unternehmen der
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Technical Data:

Application		**SAW single-wire**
Welding current	(A)	1400
Control voltage	(V/Hz)	42 AC/50
Travel gauge	(mm)	395
Wire diameter	(mm)	2.5 – 5.0
Wire feed speed	(m/min)	0.1 – 6.1
Travel speed	(m/min)	0.1 – 1.6
Cross/height adjustment	(mm)	100/100
Column swivel range	(degree)	360
Welding head inclination	(degree)	45 (both sides)
Tube inside welding from diameter	(mm)	1500
Weight automat	(kg)	61
Wire reel capacity	(kg)	30
Dimensions automat L x W x H	(mm)	≈ 1050 x 600 x ≈ 900

EN 60974-1, VDE 0544, VBG 15 (UVV 26.0) 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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