Kjellberg Finsterwalde
Schweißtechnik und
Verschleißschutzsysteme GmbH

Submerged Arc Welding **Parallel Wire**	**Welding Automat** **Wire Diameter up to 2 x 2.5 mm**	**KA 7-UPP**

Welding automat for SAW-parallel wire welding with wires up to 2 x 2.5 mm, on plane plates or on guiding rails and for inside welding of tubes as well. 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 transported 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 (cv-characteristic required)
- Start and crater filler parameters separate to adjust
- Start and Stop circuit for optimising the welding process
- The tractor runs directly on the workpiece or rails
- Precise wire-to-seam adjustment ensures optimal geometry of the welding seam
- Inside welding of tubes and boilers with min. 1,500 mm diameter
- Easy adaptations to other technologies if demanded

Main features:

- Tachogenerator controlled tractor with all-wheel drive; 160 mm wheels, with rubber rims; dust protected manual operated drive coupling; axle extensions for track gauge increase from 330 mm to 395 mm
- Sturdy wire feed gear for wires 2 x 1.6 mm up to 2 x 2.5 mm, with 2-roll drive for smooth transportation of both the wires
- Suitable for max. 1,200 A welding current
- Reel holders capable for two wire reels with max. 25 kg each
- Height and cross slide for manual positioning of the welding head in two planes, each 100 mm
- Active control parameters arranged in the first service level of the control board (welding current, arc voltage, travel speed); passive elements in a second service level, accessible to operator after opening the cover plate
- Steplessly adjustable guide rollers for conducting the tractor along construction members, web plates, profiles, etc.

EN ISO 9001:2008 DNV Certified Company

Ein Unternehmen der
Kjellberg-Stiftung
Südanlage 5
35390 Gießen

Geschäftsführer:
Heiko Schröder

USt.-Id. Nr. DE 258614963
Amtsgericht Bochum HRB 11721

Tel.: +49 3531 500-319
Fax: +49 3531 500 357
schweissen@kjellberg.de
www.kjellberg.de
WEEE Nr. DE 39866380

Commerzbank AG Cottbus
Konto: 1556083 BLZ: 18040000
IBAN: DE20180400000155608300
BIC: COBADEFFXXX

Sparkasse Elbe-Elster
Konto: 3100301489 BLZ: 18051000
IBAN: DE23180510003100301489
BIC: WELADED1EES

- Flux hopper with 10 l capacity, provided with sight glass and adapter for a pneumatic flux recovery unit
- Laser pointer for visual wire-to-seam control
- Recommended power sources: GTH 1402 (also GTH 1002)

Technical Data:

Technology		**SAW-parallel wire welding**
Welding current	(A)	max 1400
Control voltage	(V/Hz)	42 AC/50
Track gauge	(mm)	330 or optional 395
Wire diameter	(mm)	2 x 1.6 up to 2 x 2.5
Wire feed speed	(m/min)	0.1 - 6.1
Travel speed	(m/min)	0.1 – 1.6
Cross/Height adjustment	(mm)	100/100
Traverse rotation	(degree)	360
Swivel angle torch head	(degree)	45 (to both sides)
Tube diameter for inside welding	(mm)	1,500
Weight automat	(kg)	61
Weight wire reel max	(kg)	2 x 25
Dimensions automat L x B 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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