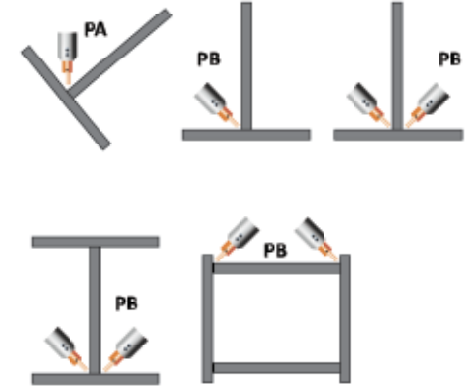


WELDING EQUIPMENT SELECTION GUIDE

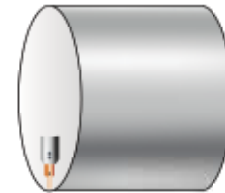
For Beams and Cylinders



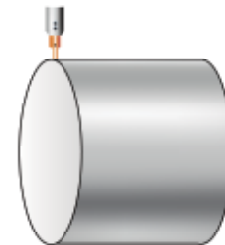
Application	Weld Object Size				Production volume	Position	Process	Weld heads	Wire set-up	Equipment
	Thickness	Length	Height	Min diameter						
Beam I, T, H, Box	<10 mm	<10 m	N/A	N/A	Low	PA, PB	GMAW	One	Single	Miggytrac
	<10 mm	<10 m	N/A	N/A	Low	All	GMAW	One	Single	Railtrac
	<15 mm	<15 m	N/A	N/A	Low	PB	SAW/GMAW	One	Single, Twin	A2 Multitrac
	<15 mm	<15 m	N/A	N/A	Low	PA, PB	SAW/GMAW	One	Single, Twin	Versotrac
	<20 mm	<25 m	N/A	N/A	Low	PB	SAW	One	Single, Twin, Tandem, ICE	A6 Mastertrac
	<20 mm	<25 m	<800 mm	N/A	Medium	PB	SAW	Two	Single, Twin	A6 DK
	<15 mm	<20 m	<800 mm	N/A	Medium	PA, PB	SAW/GMAW	Two	Single, Twin	Mechtrac
	<35 mm	<24 m	<2500 mm	N/A	Medium	PB	SAW	Two	Single, Twin, Tandem, ICE	Column and Boom (BS 3 or 4)
	<50 mm	<24 m	<3200 mm	N/A	High	PB	SAW	Two	Single, Twin, Tandem, ICE	Pull-through (e.g. IT-258 or IT-3200)



Circular objects ID welding Possible to rotate PV, Tanks, WT, Monopiles	<10 mm	N/A	N/A	>1150 mm	Low	PA, PB	SAW/GMAW	One	Single, Twin	A2 Multitrac
	<10 mm	N/A	N/A	>1100 mm	Low	PA, PB	SAW/GMAW	One	Single, Twin	Versotrac
	<20 mm	N/A	N/A	>1650 mm	Medium	PA, PB	SAW	One	Single, Twin, Tandem, ICE	A6 Mastertrac
	<400 mm	N/A	N/A	>500 mm	High	PA, PB	SAW	One	Single, Twin, Tandem, ICE, Multi, NG	Column and Boom (BS 1)



Circular objects OD welding Possible to rotate PV, Tanks, WT, Monopiles	<400 mm	N/A	N/A	<12 m	High	PA, PB	SAW	One	Single, Twin, Tandem, ICE, Multi, NG	Column and Boom (BS 1)
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Circular objects ID/OD welding Not possible to rotate Tanks	<20 mm	N/A	N/A	>203 mm	Medium	All	GMAW	One	Single	Orbiter
	<10 mm	N/A	N/A	>508 mm	Low	All	GMAW	One	Single	Railtrac
	<35 mm	N/A	N/A	>4 m	High	PC	SAW/GMAW	Two	Single, Twin	Circotech

