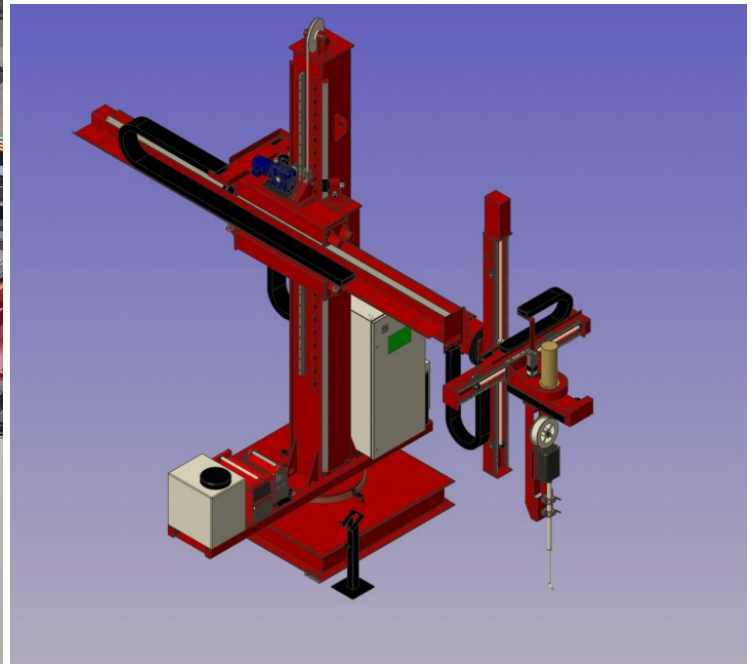


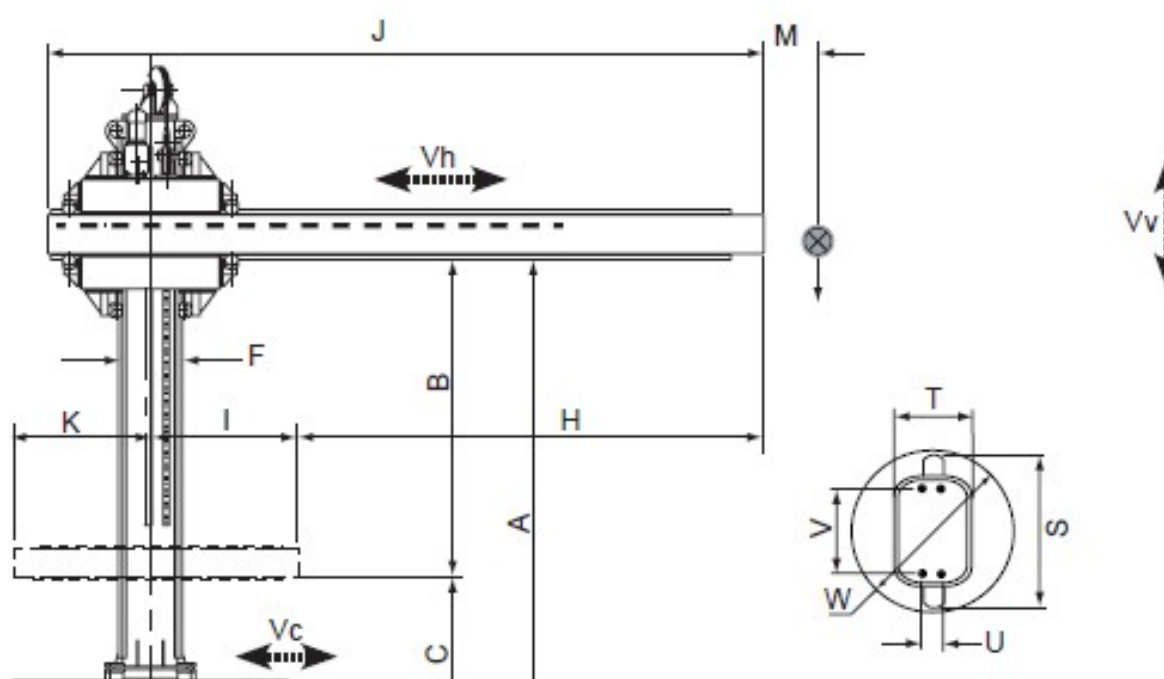
TIG-HOTWIRE WELDING EQUIPMENT ETR Vertical – Automated Cladding System (EC-18000)



Description of application

In general:	Internal Cladding of Valves, Elbow, Tee, Bore ,BOP etc
Base material:	Mild steel
Filler material:	Inconel 625
Filler wire diameter:	1.2mm Wire speed Max:11m/min
Welding process:	TIG Hotwire
Shielding gas:	Argon
Welding positions:	1G&2G
Cross-slider system	Travel distance 2000mm/1000mm/1500mm Z-/X/Y-axis
Wall thickness	Information not transferred
Dimensional limit:	Min.40mmID-max.4000mmID;3000mm in height Max Rotation speed:4rpm
Weight of workpiece:	Not limit

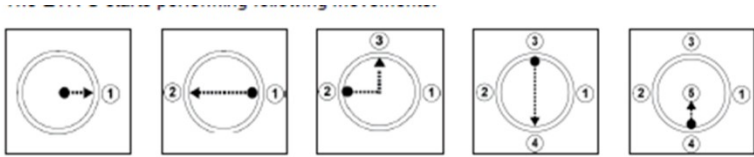
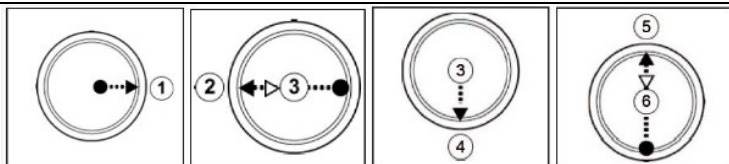
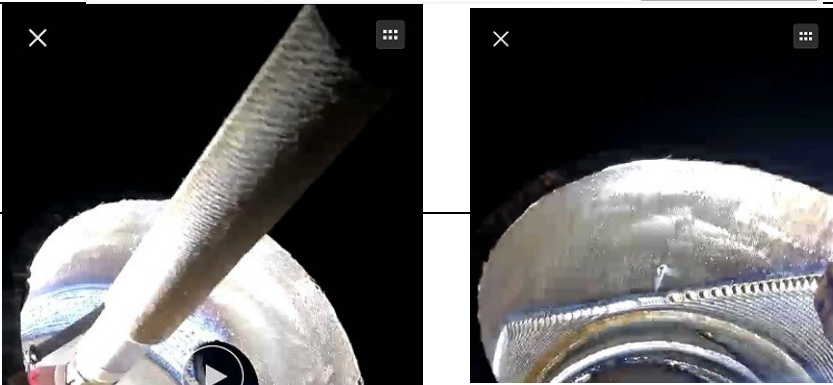
Special requirement:	Customer is responsible for foundation and primary electrical installation including, if required, a step transformer.
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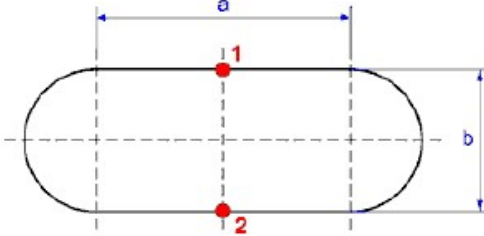
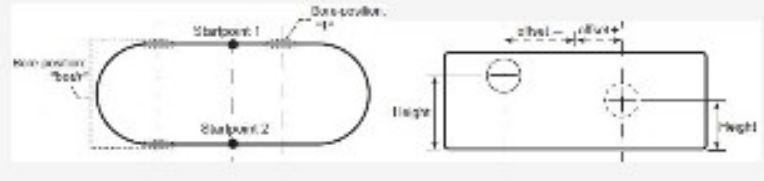
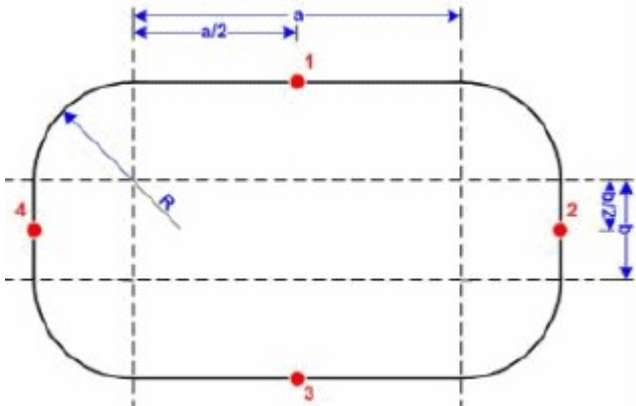


Technical data	FCB3000-4000
Max. load capacity (at end boom)	420kg
Deflection	5.42mm
Mains voltage/frequency	3x415v/60Hz
Unladen weight	5600kg
● A+C (min/max. height under boom)	1000mm/4000mm
● B (vertical traversing path)	3000mm
● D (overall height)	5500mm
● E (min, height to tip)	1500mm
● F (width of mast)	540mm
● G (depth of mast)	412mm
● H (horizontal traversing path)	4000mm
● I (minimum length of boom)	1100mm
● J (overall length of boom)	5950mm

● K (min/max. length rear)	855mm/4855mm		
● L (distance of boom from centre)	415mm		
● M (load distance)	300mm		
● Vh(horizontal speed)	10-200cm/min		
● Vv(vertical speed)	200cm/min		
Static/motorized base unit		BOOM	
N Height	317mm/365mm	S Height	390mm
O width	1816mm/1816mm	D Width	220mm
P Length	1816mm/1990mm	U Hole spacing	51mm
Q Track width	1435mm	V Hole spacing	241mm
R Wheelbase	1360mm	W Diameter	450mm
Vc Travel speed	10-200cm/min		

Description	Quant	Remarks
Welding power source set TT5000 complete	1	Fronius
Welding power source set TT2200 complete	1	Fronius
hotwire feeder	1	Berger
HF-Box external	1	Fronius
Cooling unit FK 4000 Rob	1	Fronius
Turntable OD2000mm/10 Tons	1	
Welding Torch ● TTHW3000M Ø 35 /600mm ● TTHW3000M Ø 45 /1500mm ● TTHW4000M Ø 75 /1800mm 	1 1 1	

Remote control unit ■ Torch- positioning ■ Loading,start,stop of welding programs/sequence ■ Welding parameter adjustment during welding sequence ■ Actual valve indication	1	EASYCLAD
EC-18000 Control system ■ Control terminal with 12.1" Colour-Touch Display ■ Control one welding power source ■ Control of turntable (welding speed) ■ Control two linear axes (cross-slider FCS) ■ Control Arc Voltage Control (TIG DC) ■ Control Column & boom (FCB)-inching function ■ Control of hotwire power source ■ Control of wire feed systems ■ Welding data/-parameter input: ■ Weld start position ■ Welding stop position ■ Welding of tapered bores ■ Welding of Tee intersecting bores ■ Welding of Coaxial cross bores with equal bores on both sides ■ Welding of angled intersecting bores ■ User administration ■ Language selection	1	EASYCLAD
		Automatic centering function
		Ring groove centering
		BORE-TO-BORE FUNCTION

	Race track function
	Race track bore function
	Rectangle function

Documentation:

- Operator manual - English language
- Spare and ware parts list - English language
- Wiring scheme
- Maintenance guideline