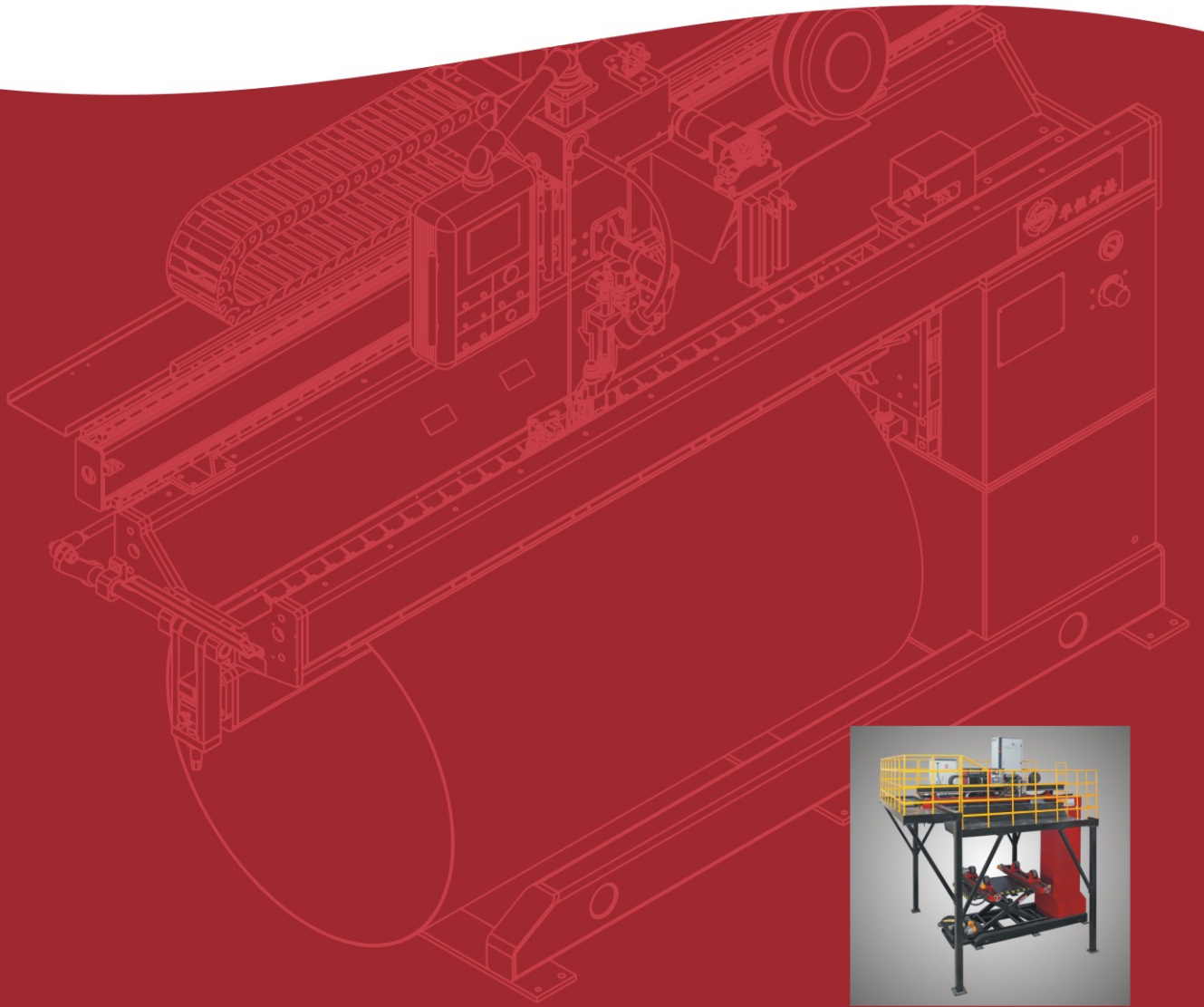


HUAHENG



**AUTOMATION
Welding System**

HUAHENG WELDING CO., LTD.



Longitudinal Seam Welding System Series

Brief Introduction

Longitudinal seam welding system is used to weld inside and outside seams for middle wall thickness tank, it could use PAW, TIG, MIG/MAG welding process. The material could be carbon steel, stainless steel, aluminum alloy, titanium and other material. It is widely applied to weld food machinery, dyeing and finishing equipment, tank of power switch bus bar, medical instrument, special material pressure vessels for the chemical industry, pipeline for electric power, the shell of air condition and so on. The fixture could be added with height blocks and protection devices. The system is reliable with high efficiency.



Features

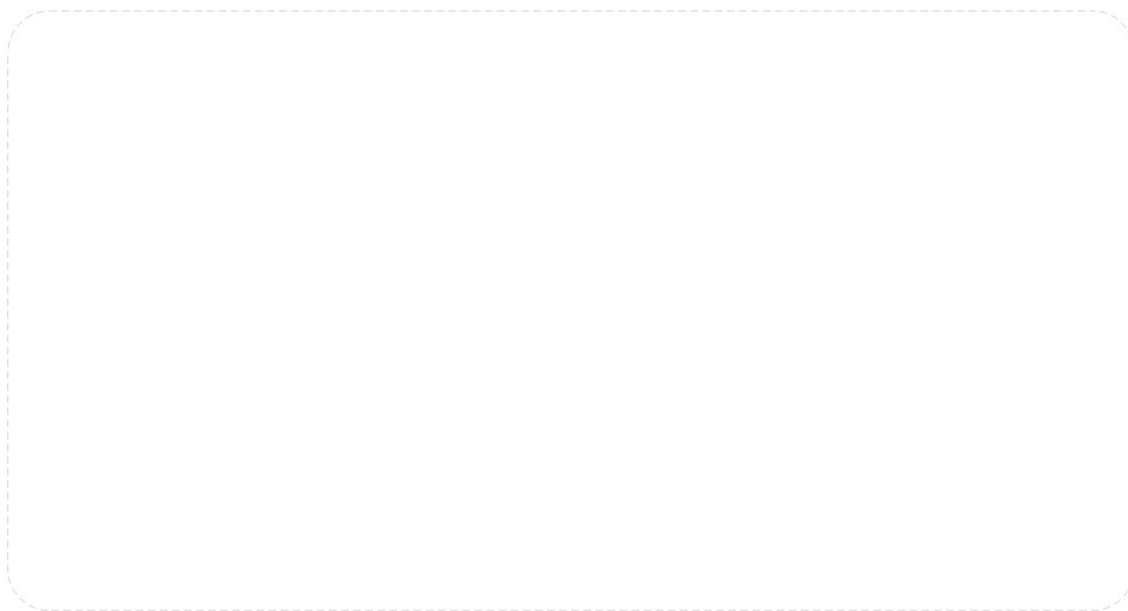
- Use cooper made finger clamp for small welding distortion and high welding quality
- Suitable for 0.4mm–12mm wall thickness tank and plate welding longitudinal seam
- Suitable for TIG, MIG/MAG, PAW welding process
- Suitable for various materials, such as carbon steel, stainless steel, titanium alloy and aluminum alloy etc.
- According to work piece size, optional to choose standard or customized mechanism

Technical Specification

Model	HL small size outside seam		HL middle size outside seam		HLN inside seam	
	HL1500	HL2000	HL3000	HLN4000	HLN6000	HLN7500
Maximum welding length for single torch (mm)		2000	3000	4200	6900	8400
Maximum welding length for double torch (mm)	1500	1600	2600	3800	6100	7600
Maximum clamping length (mm)	1590	2100	3075	4200	6900	8400
Maximum clamping diameter for outside welding (mm)	Φ850	Φ1100	Φ1200			
Minimum clamping diameter for outside welding (mm)	Circular mandrel Φ110	Φ180	Φ180			
	Quadrate mandrel	Φ330	Φ330			
Minimum clamping diameter for inside welding (mm)		Φ2000	Φ2000	Φ1600	Φ1600	Φ1600
Minimum clamping wall thickness (mm)	0.4	1.0	1.0	1.5	1.5	1.5
Maximum clamping wall thickness (mm)	3.0	12	12	12	12	12
Adjustable fingers distance (mm)	7 ~ 33	5 ~ 40	5 ~ 40	10 ~ 40	10 ~ 40	10 ~ 40
Maximum single side pressure (kgf/cm)	15	30	30	30	30	30
Mandrel vertical traverse (mm)	15	30	30	60	60	60
Supporter adjustment (mm)	10	20	20	30	30	30
Centralizing adjustment (mm)	10	10	10	10	10	10
Welding trolley speed (mm/min)	60 ~ 1200	60 ~ 1200	60 ~ 1200	60 ~ 1200	60 ~ 1200	60 ~ 1200
Maximum trolley traverse (mm)	1600	3000	4000	6300	9000	10750
Dimension (LxMxH) (mm)	2530*820*1600	3500*1150*2300	4900*1200*2400	7100*1200*1800	9100*1200*1800	11050*1200*2000



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HUAHENG WELDING CO., LTD.

Add : No.1588 Boshi Road,Kunshan,Jiangsu,P.R.China. PC: 215347
Tel : +86(0)512-81866666 Fax : +86(0)512-57328188
www.huahengweld.com E-mail : info@huahengweld.com