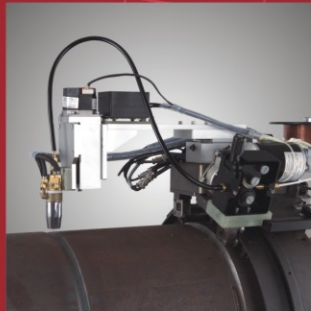
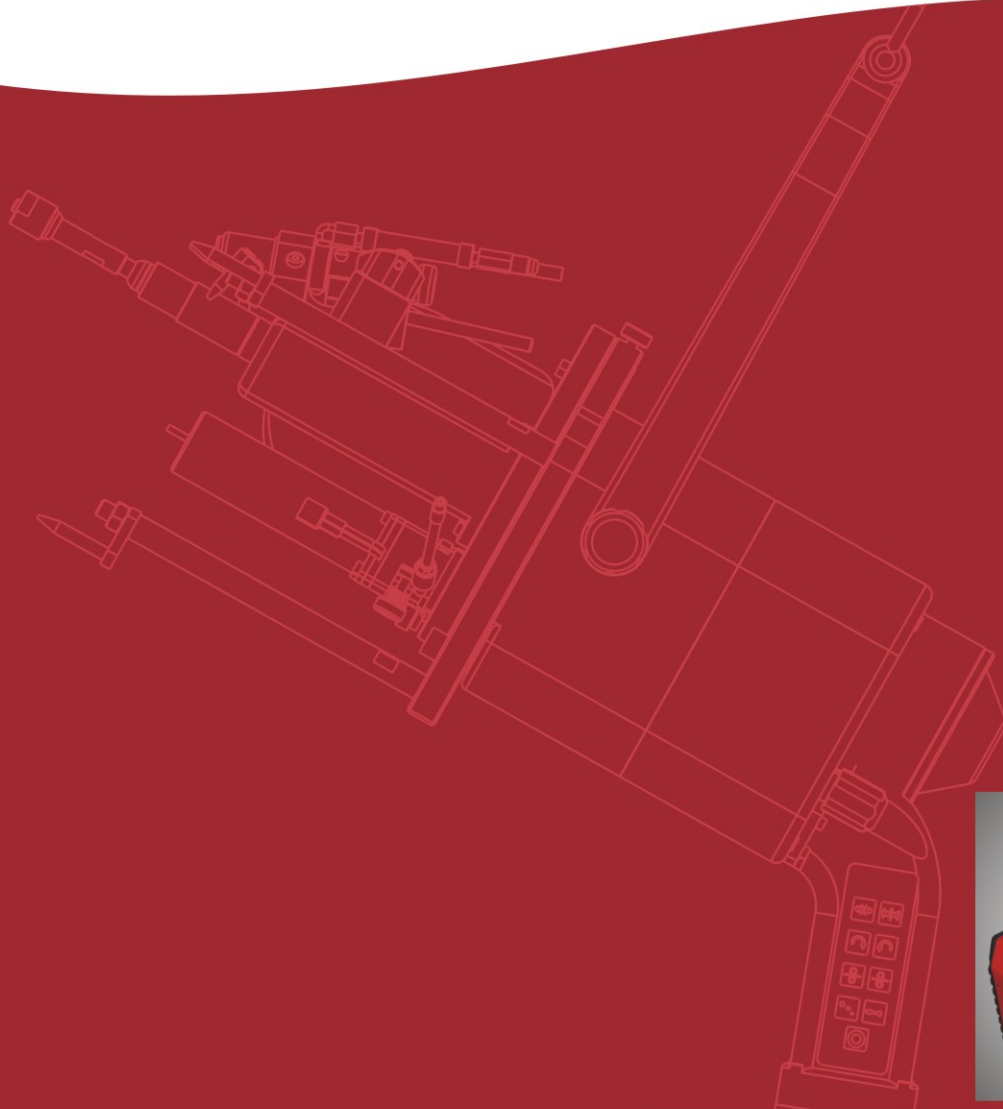


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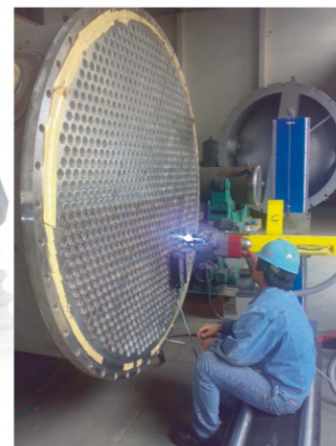
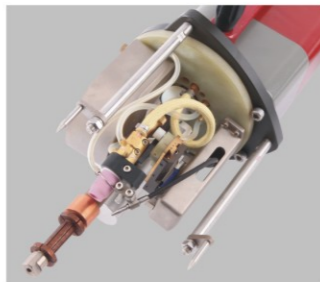
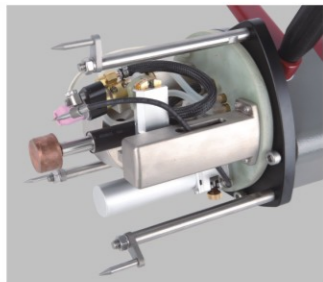


ORBITAL Welding System

HUAHENG WELDING CO., LTD.

TP060

Tube to Tube-Sheet Welding Head

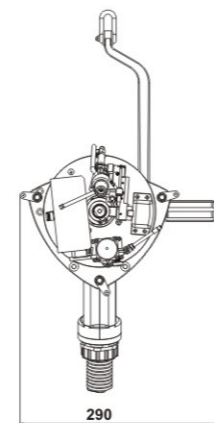
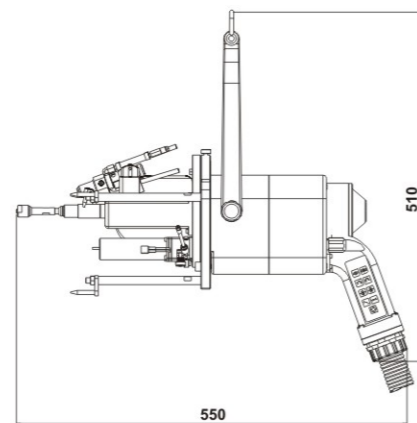


Brief Introduction

This welding head is one special designed TIG welding head for tube to tube-sheet, which is used for carbon steel, stainless steel, mainly for protrusion tube and flush tube connection, without wire feeding or with wire feeding. The standard one is small torch; it could weld high protection requirement material such as Titanium alloy with tow cover. $OD \leq 32\text{mm}$, use localizer and manipulator to fix; $OD \geq 32\text{mm}$, use mandrel to fix.

Support equipment: i-Arc400 Programmable Orbital Welding Power Source.

Application: chemical, food, medicine, heat exchanger, power plant, military, nuclear and so on.



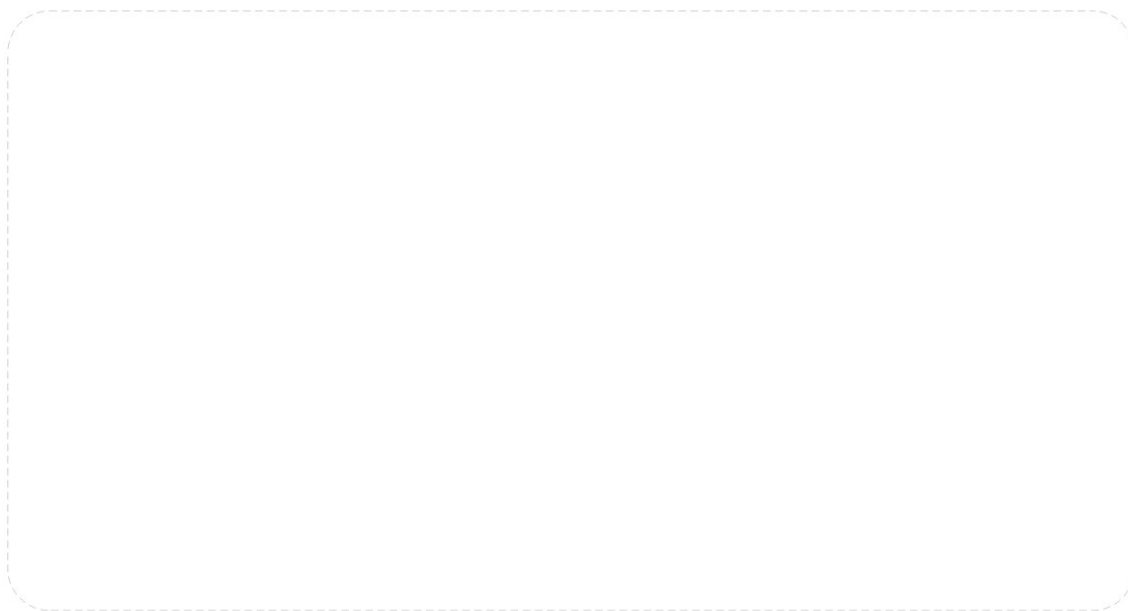
Features

- With/without wire feeding TIG DC/Pulse welding;
- No wire twist design and special wire feeding design to achieved complex single-layer welding or multi-layer welding requirements;
- Durable welding torch design, suitable for tungsten electrode up to $\Phi 3.2\text{mm}$, improve duty cycle significantly;
- Pneumatic expandable mandrel for positioning, connecting to the balancer accurately and reliable, which is suitable for tube to tube-sheet structure welding in boiler industry;
- Compatible with manipulator and suitable for heat exchanger industry;
- Suitable for materials of carbon steel, stainless steel, zirconium alloy flush tube and protrusion tube;
- Unique arc length control (AVC) design.

Technical Specification

Material	Carbon steel, stainless steel, titanium alloy (with cover)
Tube OD (mm)	$\Phi 16 - \Phi 60$ ($5/8" - 2 1/2"$) (extendable to $\Phi 89$)
Connection	Protrusion tube, flush tube
Tungsten OD (mm)	$\Phi 2.4$ (standard) 、 $\Phi 3.2$
Wire Diameter (mm)	$\Phi 0.8$ 、 $\Phi 1.0$
Rotation speed (rpm)	0.37 - 7.39
Welding angle	$0^\circ - 30^\circ$ option
Arc adjusting distance (mm)	18
Max wire feeding speed (mm)	1800
Protective gas	Ar
Cooling	Water
Cooling flow (ml/min)	≥ 600
Duty cycle	300A 60%
Weight (kg)	12 (no cable)
Dimension (mm)	$550 \times 290 \times 510$

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