

COREWIRE







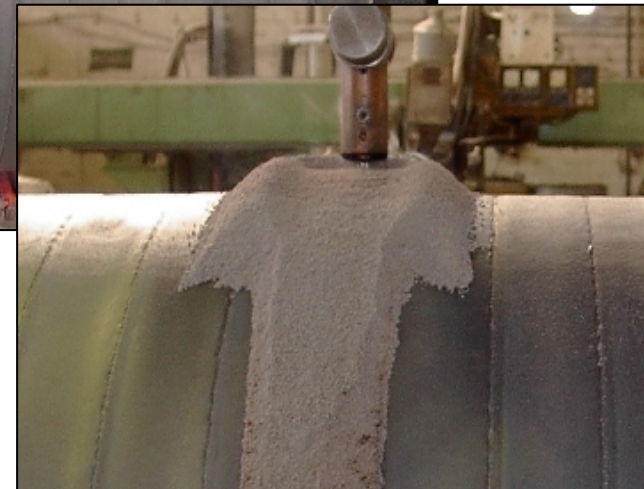
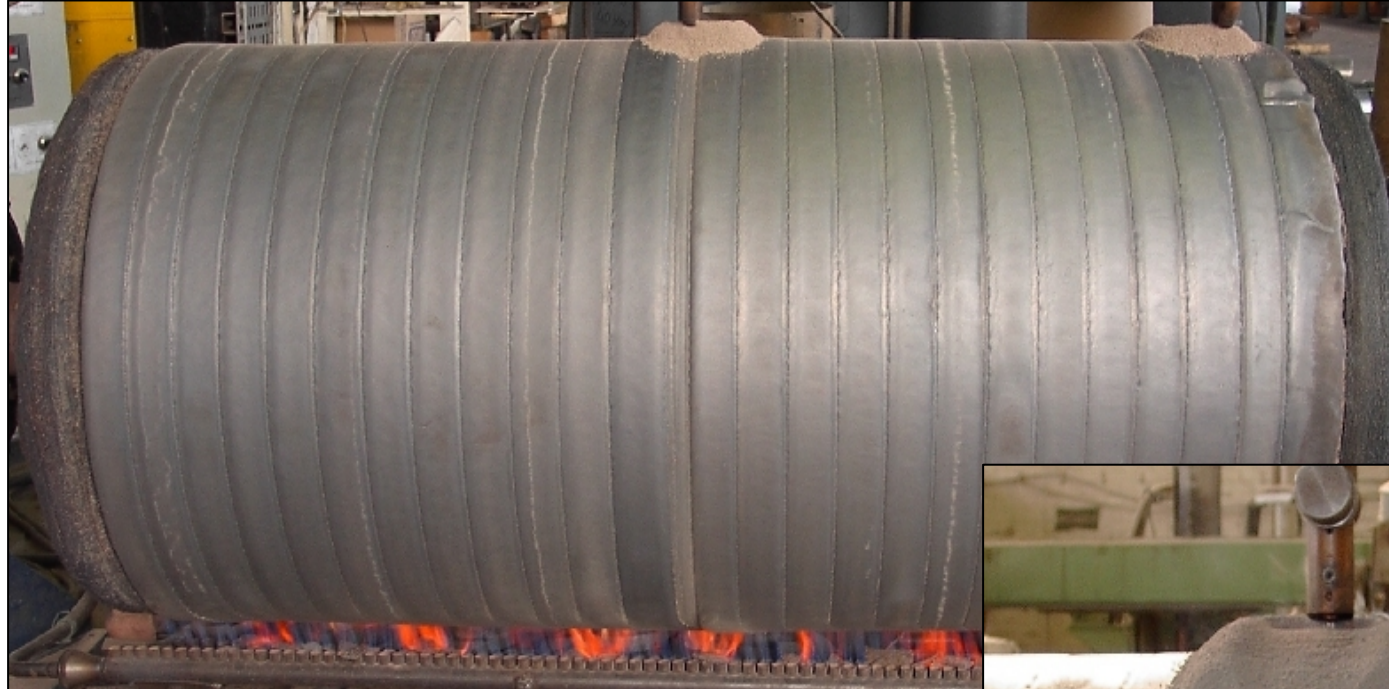




Top Pinch Roller Before Welding

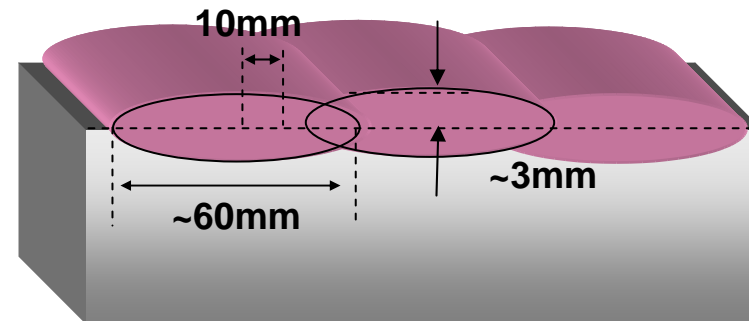
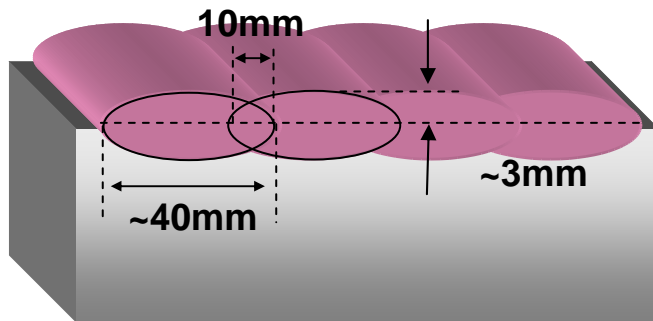
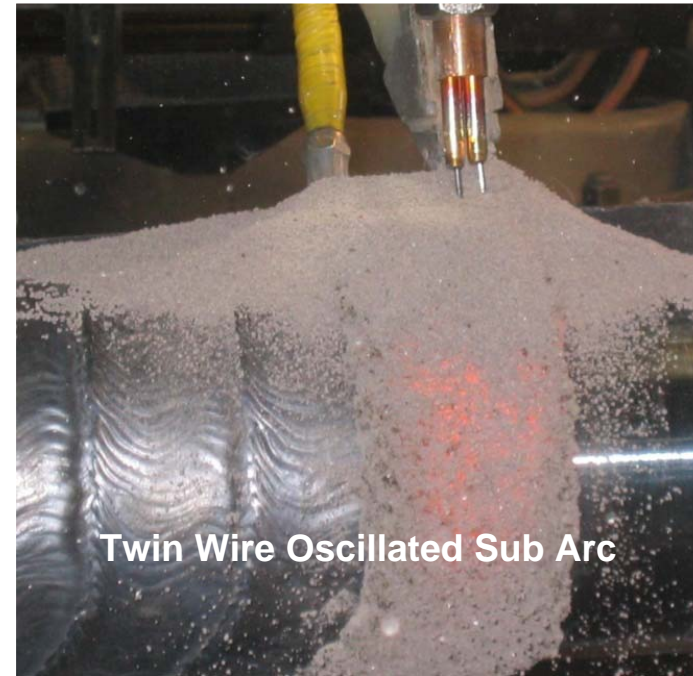


Top Pinch Roller During Welding

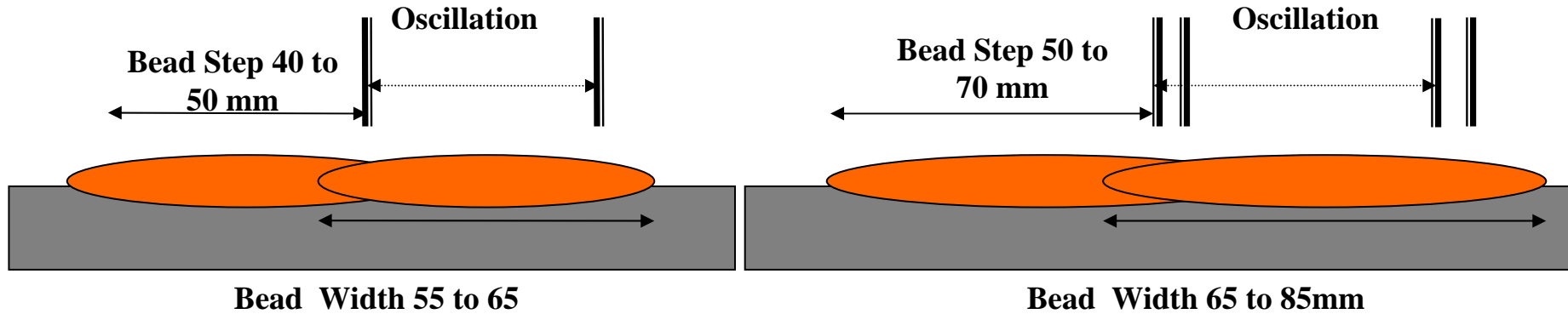


Two torches Weld
deposition 36 Kg/hr

Submerged Arc Welding – overview



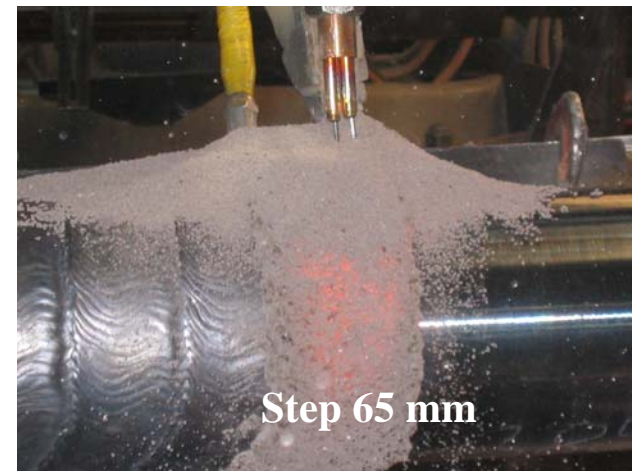
Caster Roll Welding Techniques



Single Wire Oscillated Sub Arc



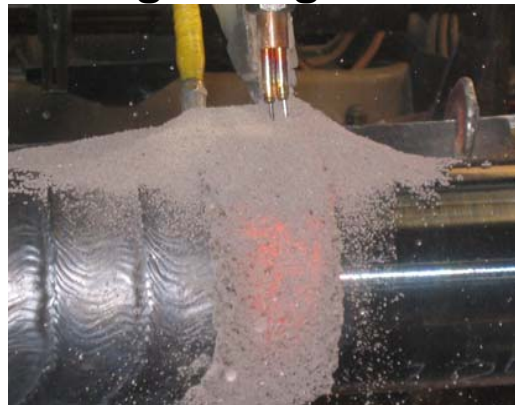
Twin Wire Oscillated Sub Arc



Submerged Arc Welding

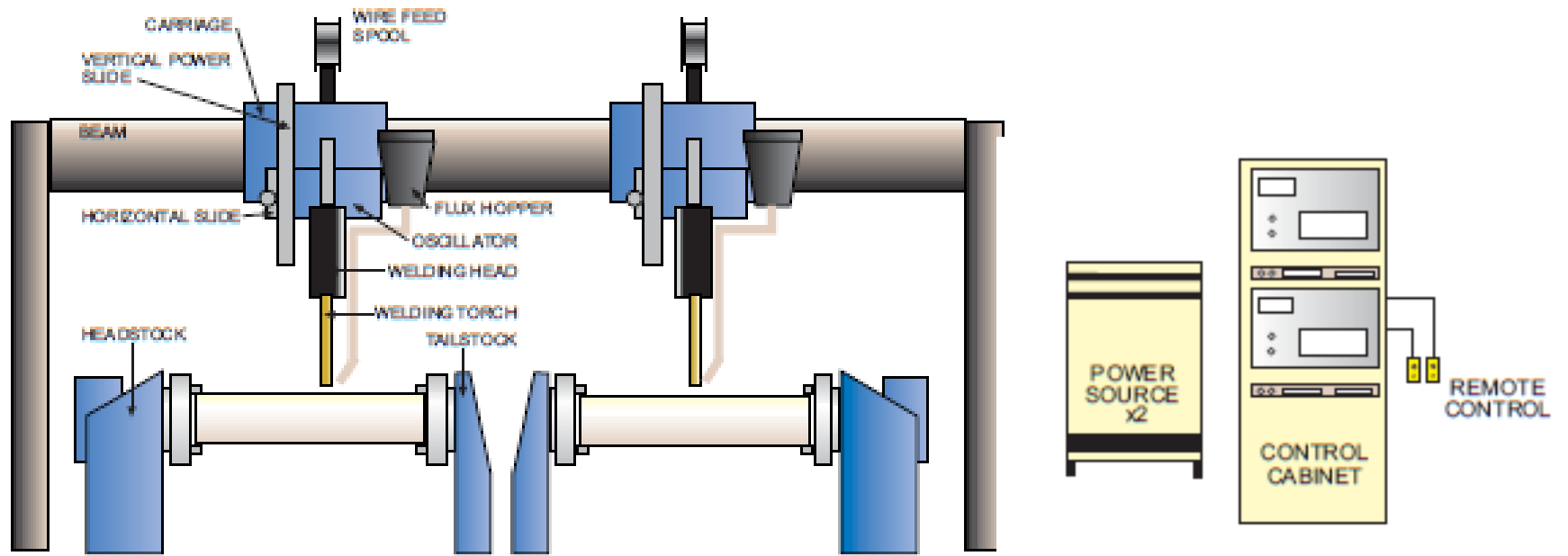


Welding a range of roll sizes



Single or twin wire welding for maximum welding speed 140 mm
diameter 13 Kg/Hr

Flux to Wire consumption < 0.85:1





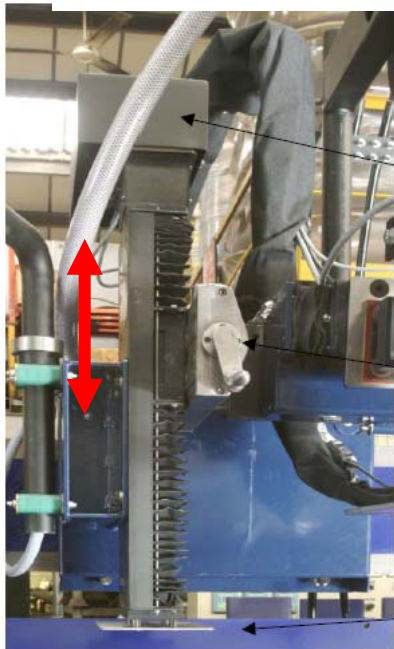
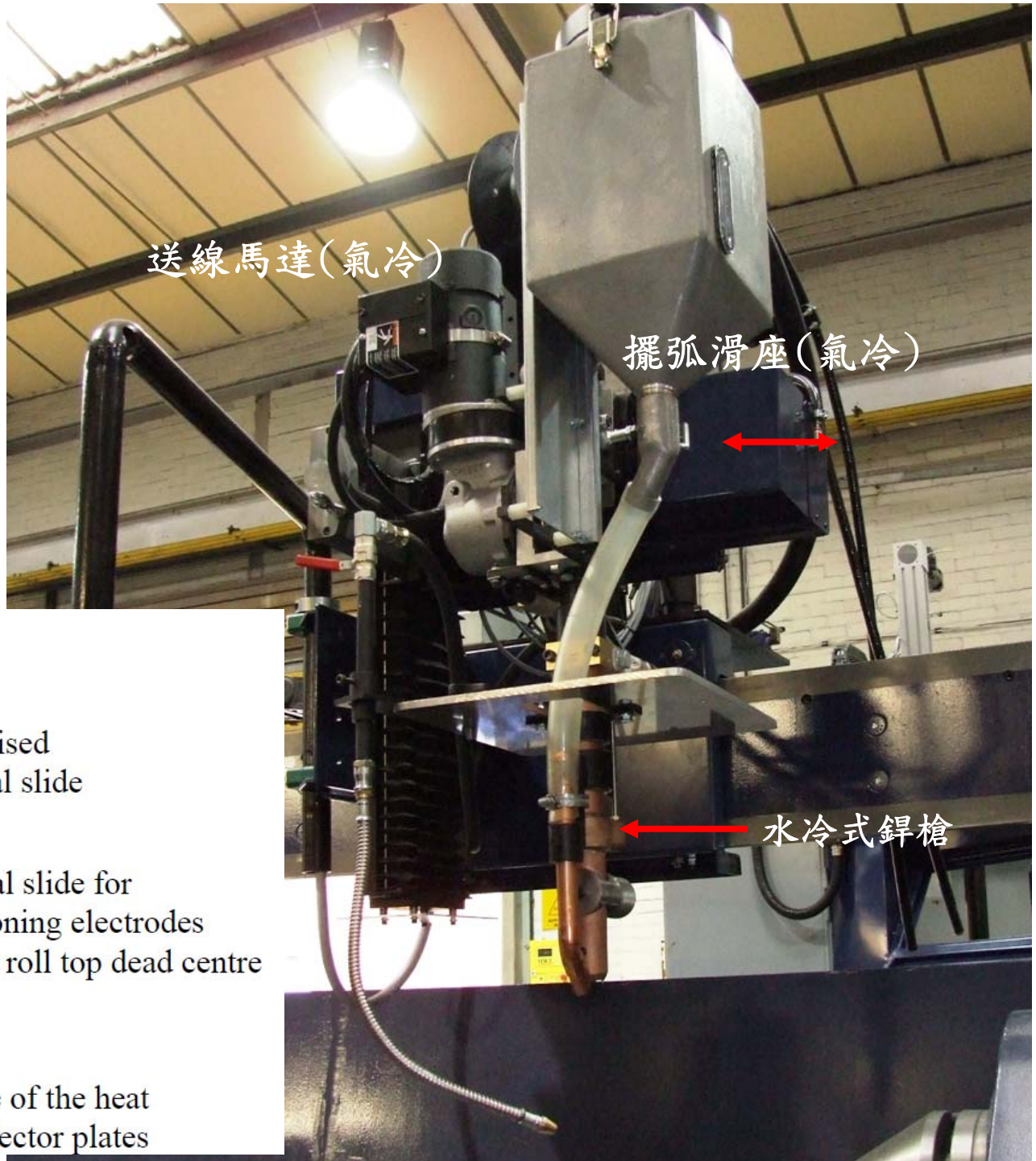
Two wire guides

Flux feed tank

Water cooled welding torch

Manipulator welding and flux control



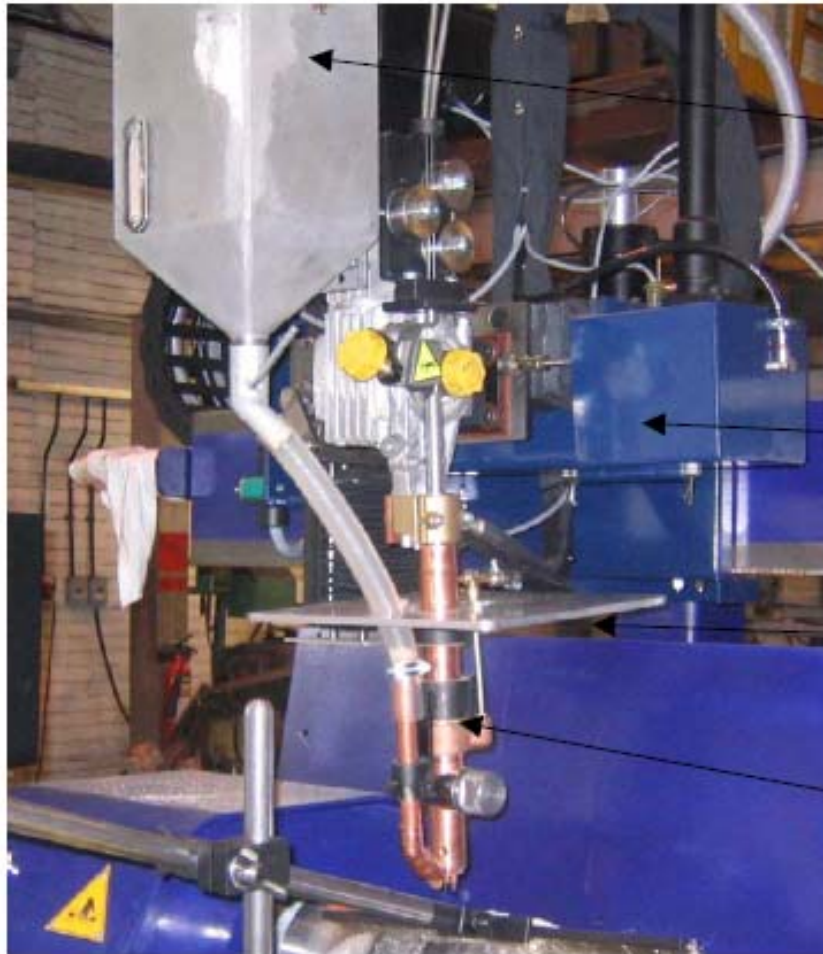


Motorised vertical slide

Manual slide for positioning electrodes before roll top dead centre

One of the heat deflector plates

水冷式鋸槍



Flux hopper automatically filled

Welding head oscillator

Heat deflector plates

Water cooled welding torch single or twin wire



Motorised
vertical slide

Manual slide for
positioning electrodes
before roll top dead centre

One of the heat
deflector plates



Air Cooling system for
high deposition rate
welding on small rolls

150 mm Ø twin wire
650-700 Amps



Closed circuit water
cooling system for the
welding torches



Intermediate flux
storage hopper

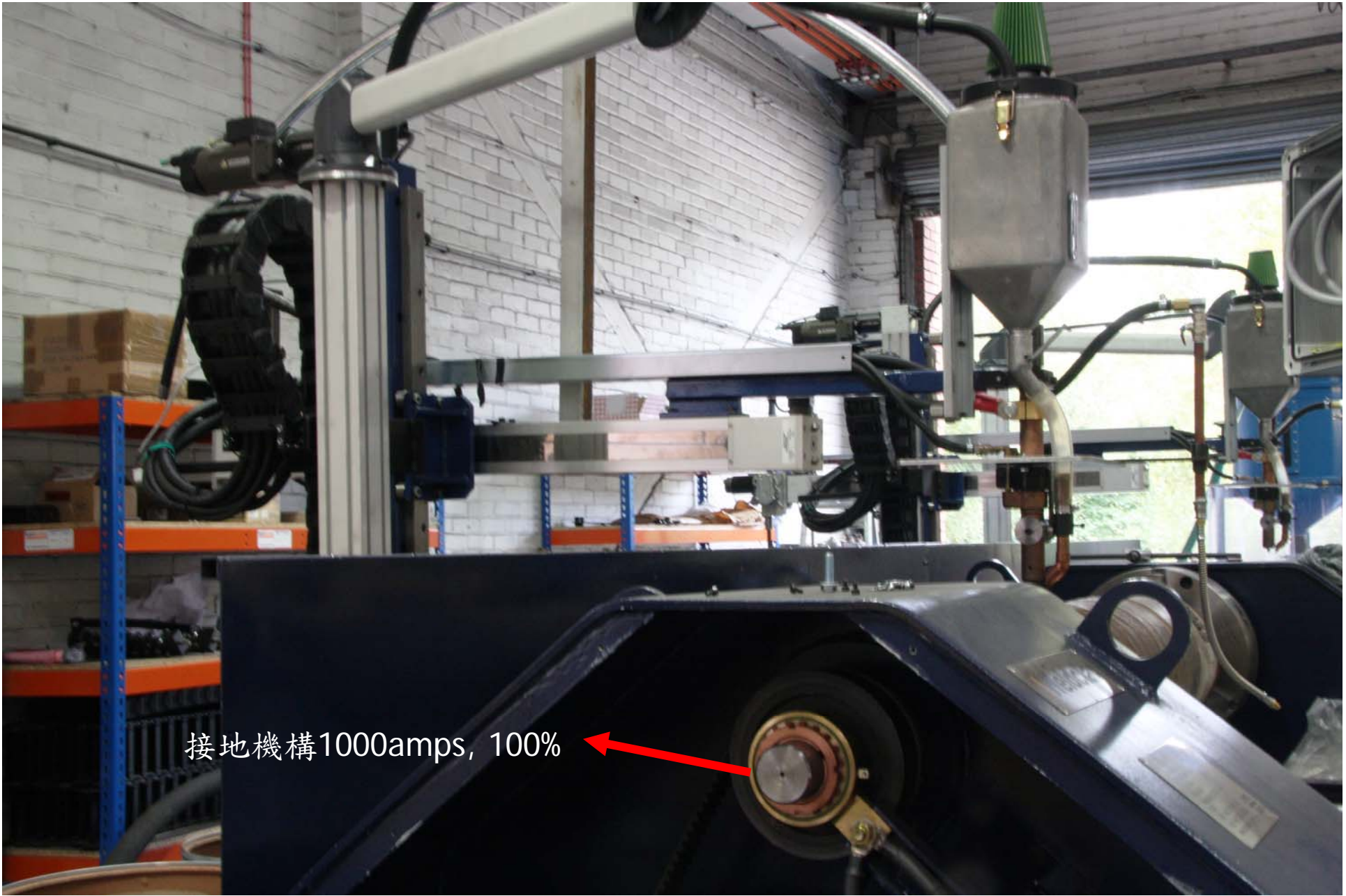
Flux delivery
pressure vessel

Dust
Collector

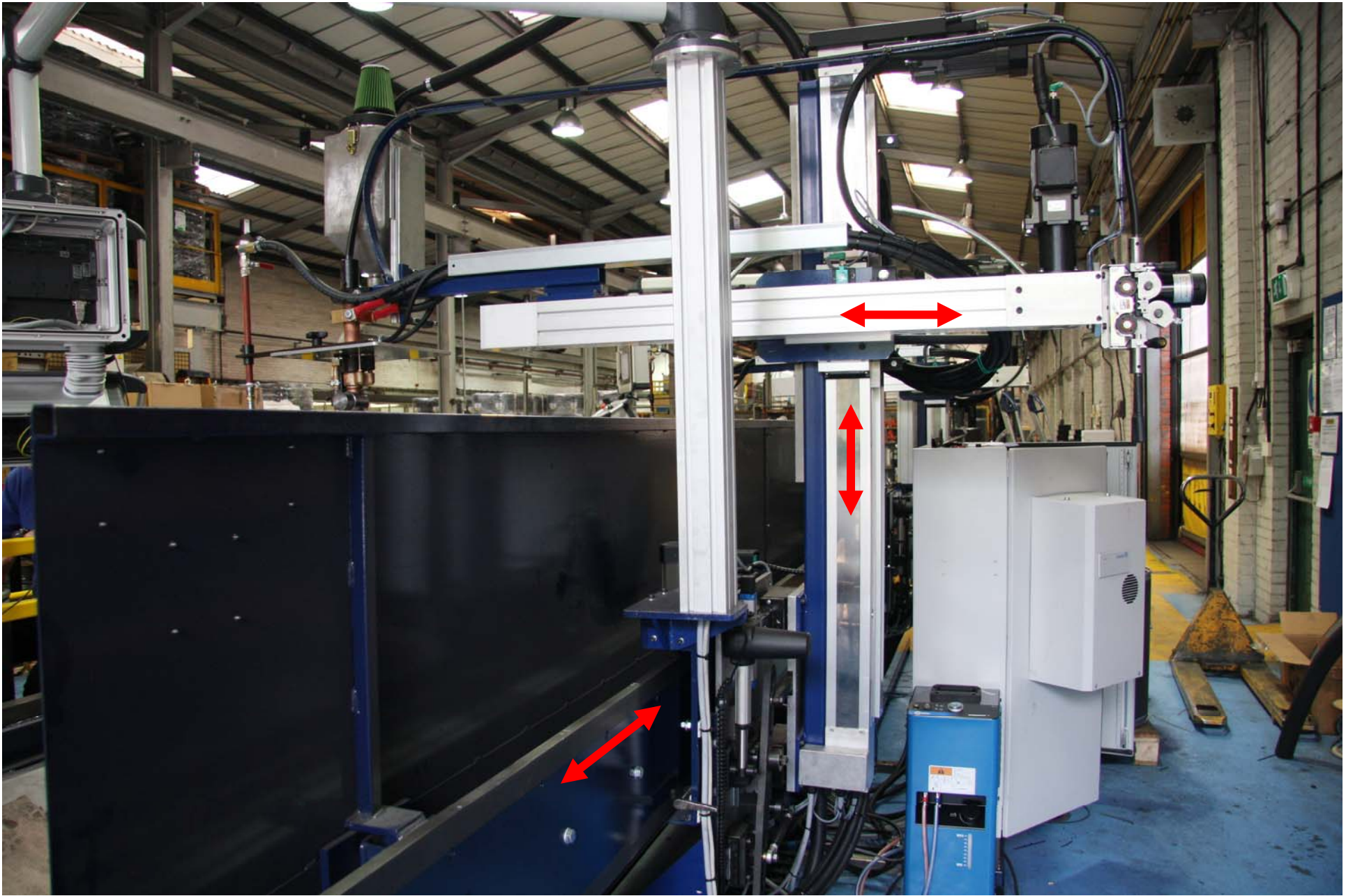
Initial loading
hopper

2011 年組裝新機台照片

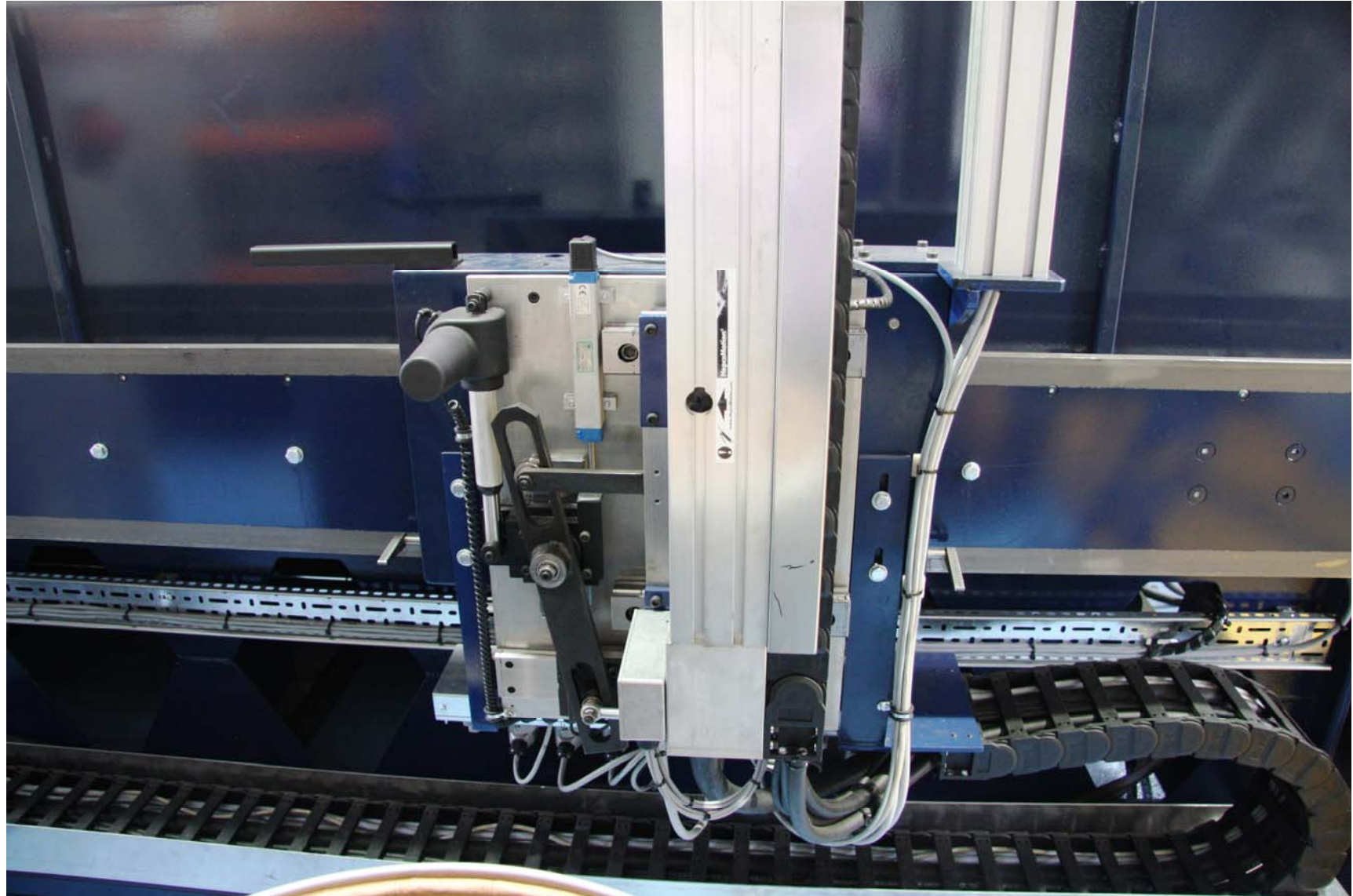




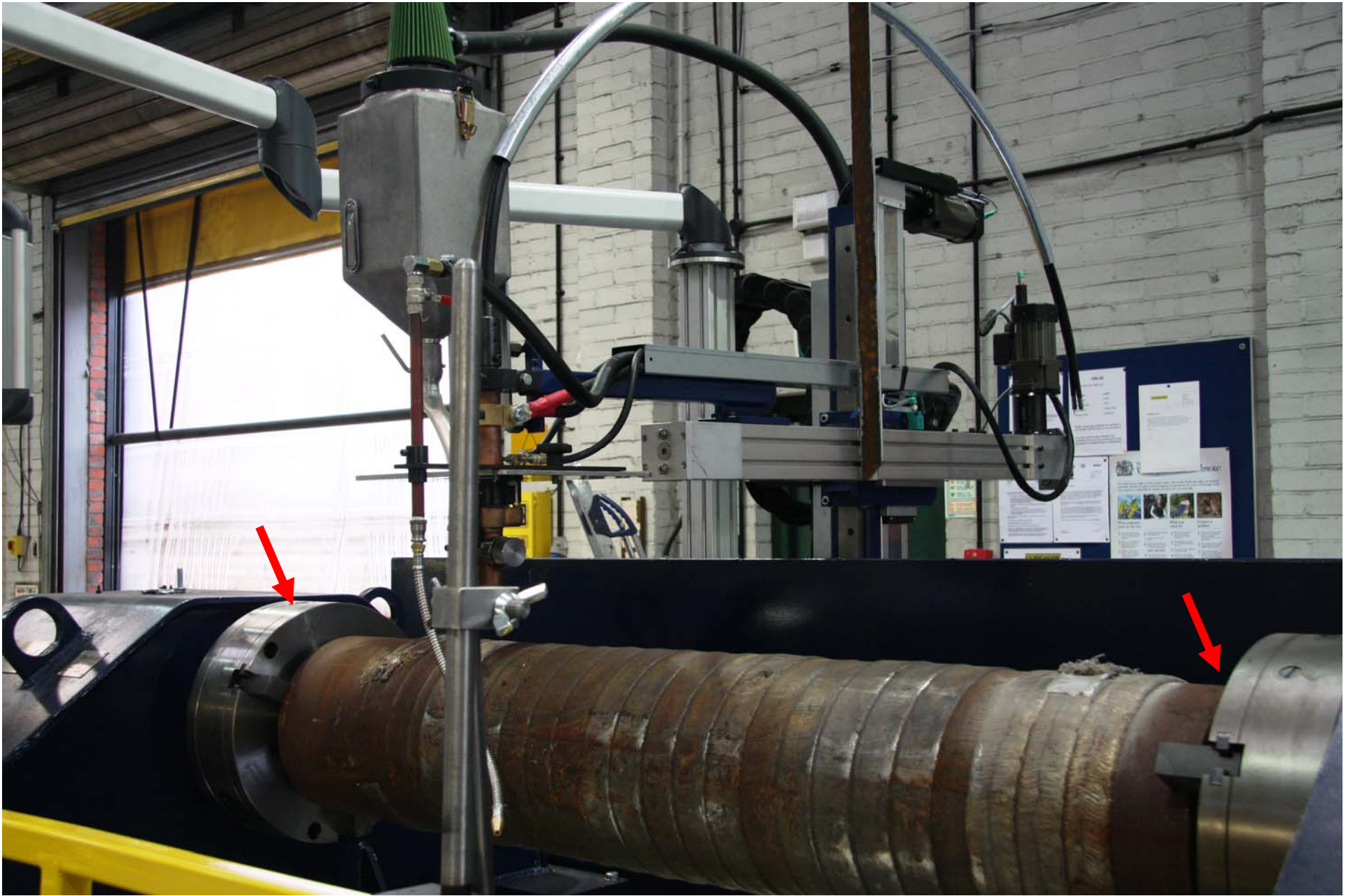
接地機構1000amps, 100%



擺弧機構：













Weldclad HMI Controller

2011/01/09



Weldclad

銲接參數設定

Welding

Data Log

銲接參數記錄

其他設定

Other
Settings

Alarm
History

銲粉系統設定

Flux System

Help

MITSUBISHI

程式號碼

工號

The image shows a Mitsubishi GOT1000 control panel screen with the following content:

- Top left: Programme 0
- Top middle: Job Wire 銲線
- Top right: 20:40 Weldclad™
- Below Programme: Autostart (with a blue circle button)
- Below Wire: MANUAL
- Center: Volts 29 (with a blue double-headed arrow)
- Below Volts: WFS cm/min 339 (with a blue double-headed arrow)
- Bottom left: Rotator (with a green right arrow button)
- Right side parameters:
 - Angle 45
 - Width 45
 - Roll Dia mm 299
 - S Speed mm/min 14
 - Stick Out, mm -1.1
 - Off-set, mm 30
 - Oscillator Width, mm 42
 - Frequency Hz 39
 - Volts 29
 - WFS cm/min 339

啟動按鈕

擺弧開關

步進/螺旋方式

旋轉方向

mitsubishi
GOT1000

程式號碼

工號

20:40 Weldclad™
MANUAL

Autostart
Oscillator
Step/Spiral
Rotator

Volts
29 電壓

WFS cm/min
339 送線速度

Amps
0 250 500 750 1000

Angle 45
Width 45

Roll Dia mm 299
S Speed mm/min
Stick Out, mm -1.1
Off-set, mm 30

Oscillator
Width, mm 42
Frequency Hz 39

Volts 29
WFS cm/min 339

啟動按鈕

擺弧開關

步進/螺旋方式

旋轉方向

電流指示錶

警告: 本機は高圧電圧を発生します。感電の恐れがあります。感電防止のため、作業中は必ず安全装置を確実に作動させてください。

GRAPHIC OPERATION TERMINAL GOT1000

Programme 0 Job Wire 20:40 **Weldclad**
 MANUAL

Autostart
 Oscillator
 Step/Spiral
 Rotator

Offset mm 30 ZERO Stick out mm 11 ZERO

Angle 45
 Width 45

Roll Dia mm 299
 S.Speed mm/min 149
 Stick Out, mm -11
 Off-set, mm 30

Surface speed 149 mm/min Roll diameter mm 299

Oscillator
 Width, mm 42
 Frequency Hz 39

Volts 29
 WFS cm/min 339

軋輓直徑
 表面速度
 鋸線伸出長度
 偏移距離

MITSUBISHI

Programme 0 Job Wire 20:40 Weldclad
MANUAL

Autostart
Oscillator
Step/Spiral
Rotator

39 Per min
42 mm

Angle 45
Width 45

Roll Dia mm 299
S.Speed mm/min 149
Stick Out, mm -11
Off-set, mm 30

Oscillator
Width, mm 42
Frequency Hz 39

Volts 29
WFS cm/min 339

擺弧寬度
擺弧頻率

警告
このパネルは、電圧がかかっている可能性があります。
電源が切れていることを確認してください。
Caution
This panel may be energized. Do not touch it until you are sure that the power is off.

GRAPHIC OPERATION TERMINAL GOT1000

Programme 0 Job Wire 20:41 **Weldclad™**

MANUAL

Autostart

Oscillator

Step/Spiral

Rotator

Weld Direction

Pitch mm 15

Pitch 15

Roll Dia mm	299
S. Speed mm/min	149
Stick Out, mm	-11
Off-set, mm	30

Oscillator	
Width, mm	42
Frequency Hz	39

Volts	29
WFS cm/min	339

MITSUBISHI

Programme 0 Job Wire 20:40 **Weldclad**
MANUAL

Autostart
Oscillator
Step/Spiral
Rotator

Distance, mm 45

Angle 45

Width 45

Roll Dia mm 299
S.Speed mm/min 149
Stick Out, mm -11
Off-set, mm 30

Oscillator
Width, mm 42
Frequency Hz 39

Volts 29
WFS cm/min 339

Angle 45
Width 45

Weldclad™



Start
Amps %

80



Max
Amps

1000



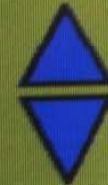
Start
Time

1



Carriage
Inch
Speed

350



Burn
Back

1



Inch
Speed

20



Crater Fill
Amps %

80



Crater Fill
Time

1

MITSUBISHI