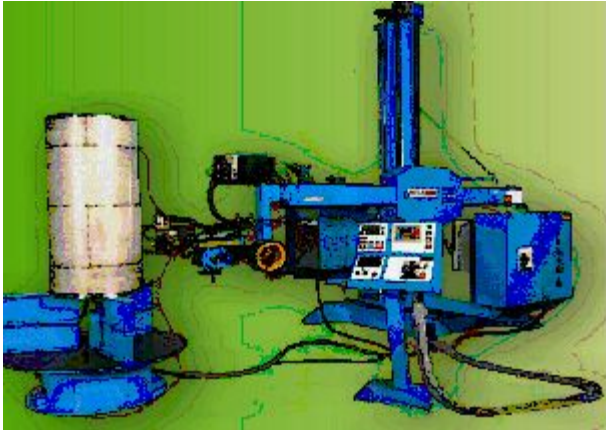


Plasma welding with vertical work pieces 等离子立焊



等离子立焊:

Strake fabrication (longitudinal welding)

筒体装配 (纵缝焊接)

The work piece which is tack welded is fixed on the turntable and the longitudinal welding is performed vertically:

工件经定位焊接后,被装配到转台上,纵缝可以通过垂直立焊来完成.

- 1 pass butt joint weld performed vertical down up to 5mm in standard
- 第一道垂直立由下向上焊接可以焊透5mm .
- A 2nd pass can be done according to level of quality required.
- 第二道可以根据需要来获得表面成型.

Building up the tank (circular welding)

组装大的罐体(环缝焊接)

The piece is rotated on the turntable and the weld is performed with the torch at the horizontal position:

工件在旋转台上旋转,焊枪在垂直位置上进行焊接.

- 1 pass butt joint weld up to 6 mm in standard
- 一道可以焊透对接接头达6 mm
- 2 passes butt joint weld up to 8 mm in standard (only 1 run if bicathode Plasma+TIG is using)
- 二道对接接头可以达到8 mm,(如果使用Plasma+TIG焊接方法,一道就可焊透8 mm)
- Over 8 mm, necessary to have a preparation (chamfer opening 75°, root face 5 mm)
- 超过8 mm,需要开75°坡口,根部钝边为5 mm;

This method allows to manufacture pieces with large sizes without any special tooling.
这种方法可以制造大尺寸的工件,而不需要特殊的加工.

Machines advantages 机器设备的优点

- Easiest work pieces handling 最容易处理的工件;
- No needs of special tools to keep the shell round.不需要特殊的加工,就可保持筒体的圆度
- Only one welding installation for all plasma jobs (circular and longitudinal)
仅一套设备就可完成所有的等离子焊接工作;
- Welding heads multi-positions: cornice, vertical up and down, flat position and fillet.

焊头适合多个焊接位置,角焊/垂直立向上或向下,平焊,角焊接.

- **Remote control panel desk including video screen for joint tracking**
- 远控面板,可以通过视频系统来进行焊缝跟踪;
- **Circular welding with the turntable which is a numerical axis**
- 使用旋转台可以进行环缝焊接;
- **Longitudinal welding with column and boom up and down which is a numerical axis**
- 十字操作架可以上下移动,进行纵缝焊接
- **A third outside axis (start and stop) can be piloted by the PLC**
- 外面的第三轴可以通过PLC来控制.