



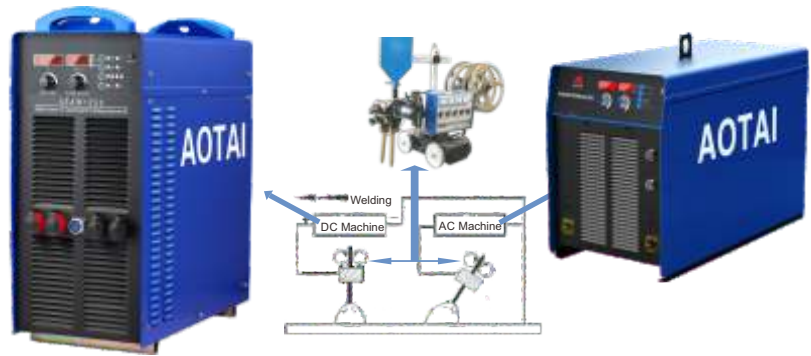
Tandem /1000A~1250A

TANDEM1000 /1250

Tandem Series provides you power sources for high productivity welding using SAW welding process. This power sources can be used to solve different technical problems. TANDEM system can be used with special tandem tractor or welding head, that was placed on column or etc. Cooperation of AC and DC power sources provide us the best welding quality and very high performance of welding process.

Features and Benefits

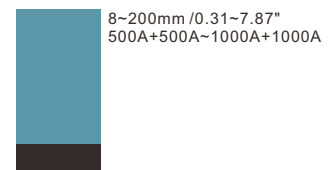
- High speed and efficient work could be done easily, and the welding speed and efficiency are over two times than single wire SAW
- Anterior DC works with posterior AC simultaneously, and separate work is also available
- The tractor head can be hung on the auxiliary machines, such as gantry, manipulator, etc.
- Applicable to the wire with the diameter more than 3mm, suitable for three welding modes: DC welding /AC welding /Tandem welding
- More adjustable parameters to guarantee the melting penetration and width, improve the welding quality



Mild Steel Welding Capability



Stainless Steel Welding Capability



Technical Specification

	TANDEM1000 /1250	
	ASAW1000 II	ASAW1000AC/DC
Rated input voltage /frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)	55.0	
Rated input current (A)	83.0	
Duty cycle (40°C)	100%@1000A	100%@1000A
OCV (V)	Around 89	Around 90
Output current range (A)	60-1000	50-1010
Output voltage range (V)	20-50	
Wire size (mm)	3.0-6.0	
Protection class	IP23S	
Insulation class	H	
Dimension (mm)	788*366*815	1040*500*720
Weight (kg /lb)	95 /209.8	165 /364.7

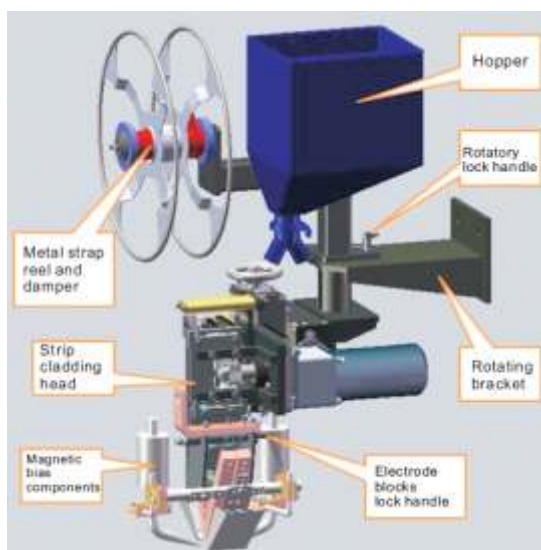


Strip cladding uses metal strip instead of wire as electrode, processes SAW welding under flux layer. It enjoys high efficiency, low dilution rate, is widely used in wear-resisting, anti-corrosion layer such as stainless steel lining, end plate of chemical and atomic energy pressure vessel, and metallurgy roller size repair strip cladding work.

Equipment in petrochemical industry like hydrogenation equipment, nuclear vessel and urea equipment, inner wall always need overlay stainless steel, but SMAW and wire cladding welding have low efficient, bad quality of overlaying, also fault may occur on joint surface between cladding metal and work piece, so strip cladding welding emerges. It enjoys high efficiency, uniform internal quality of welding cladding, flat and smooth surface of welding cladding. Because of low dilution rate, joint surface between cladding metal and work piece is less likely to have welding default. Use Aotai SAW power source, strip cladding head and auxiliary equipment can realize SAW auto cladding welding.

Introduction

Strip cladding includes strip cladding head, rotating bracket, cross tray, hopper, metal strip reel, etc. (refer to picture). This equipment chooses integral structural design, assembly is flexible and convenient, strip cladding head can realize 90° rotation, meets needs of circular seam welding and longitudinal seam welding.



Technical data (DJ-60 type strip cladding head)	
Strip width	30~60mm
Strip thickness	0.3~1.0mm
Cross tray adjustment range	100mm×100mm
Strip feeding motor	DC 90V, 1800r /min
Hopper capacity	11L

Technical data (DJC60 strip cladding tractor)	
Travelling voltage	DC110V
Travelling speed	0.2-1.5mm /min
Cross beam lifting	100mm
Cross beam circles tractor rotation angle	±90°
Tractor head adjustment range (up-down, left-right, front-back)	100×100×70



Strip Cladding Work Piece



End Cover



Manipulator + Rotation Platform



Manipulator + Positioner