



# *A6 Mastertrac SAW*

## *For efficient submerged-arc welding*

**The A6 Mastertrac is a self-propelled, fourwheel drive automatic welding machine. Fully mobile, the Mastertrac is easily moved from one welding station to another and it can be quickly set-up for different workpieces.**

**The Mastertrac has ample capacity for heavy production welding and can take up to 6 mm wire using 1500 A direct or alternating current. It is designed to be used together with LAF or TAF power sources.**

The Mastertrac can be delivered in three different designs: Single, Twin or Tandem. The Single and Twin designs are available with standard or high-speed motors. To be able to increase the profitability there are a number of accessories:

- strip cladding kit
- arc-air gouging kit
- flux funnel for any type of butt joint
- pilot lamp which projects a light spot onto the joint
- extra idler rollers
- flux recovery unit OPC
- extra guide wheels
- guide rail with magnetic fasteners when there is no guiding edge available.

Tandem - multi-electrode system

With a multi-electrode system, you can increase productivity considerably - thanks to the high deposition rate. By selecting different combinations of direct and alternating currents, the A6 Tandem Mastertrac can handle any type of welding work with increased profitability as a result.

The highly productive Twin-arc process  
With a simple Twin-arc add-on for the extra wire, you can convert an A6 Single Mastertrac into a highly productive automatic Twin-arc welder for fillet and butt welds without needing to use an extra machine or power source.



Welding with cored wire - a modern weld process

The A6 can also make use of the full range of Gas Metal Arc Welding of steel and aluminium using solid and tubular wires. The Single Mastertrac for Submerged-Arc Welding can be modified by means of a conversion kit.

Programmed precision with ESAB's A2-A6 Process Controller

The electronic control equipment with digital display makes fast programming and control of all welding parameters possible. No running-in period is necessary as the welding parameters are digitally pre-set and the carriage travel speed is supervised by a tachometer. Adjustments can be made during welding.

## Technical data

	Single		Twin	Tandem
	SAW	GMAW	SAW	SAW
Permissible load 100% (A)	1500	600	1500	2x1500
Wire diameter (mm)	3.0-6.0	1.0-3.2	2x2.0-3.0	2x3.0-6.0
Wire feed speed (m/min)	0.2-4.0	0.8-16.6	0.2-4.0	0.2-4.0
Wire feed speed high (m/min)	0.4-8.0	-	0.4-8.0	-
Travel speed (m/min)	0.1-2.0	0.1-2.0	0.1-2.0	0.1-2.0
Control voltage (V)	42	42	42	42
Wire reel (kg)	30	30	2x30	2x30
Flux capacity (l)	10	-	10	10
Weight excl. wire and flux (kg)	110	100	110	158

## Accessories

	Single		Twin	Tandem
	SAW	GMAW	SAW	SAW
<b>Contact nozzle Ø</b>				
<b>M6 *)</b>				
1.0 mm	0153 501 004		X	
1.2 mm	0153 501 005		X	
1.6 mm	0153 501 007		X	
<b>M10</b>				
1.6 mm	0258 000 909		X	
2.0 mm	0258 000 910		X	
2.4 mm	0258 000 911		X	
3.2 mm	0258 000 915		X	
*) Adapter M6/M10	0147 333 001		X	
<b>Contact jaw D35, Ø</b>				
3.0 mm	0265 900 880	X		X
4.0 mm	0265 900 882	X		X
5.0 mm	0265 900 883	X		X
6.0 mm	0265 900 884	X		X
<b>Contact jaw Heavy Twin, Ø</b>				
2x2.0 mm	0265 902 881		X	
2x2.5-3.0 mm	0265 902 880		X	
<b>Feed rollers Ø</b>				
1.0 mm	0145 538 882		X	
1.2 mm	0145 538 883		X	
1.6 mm	0218 510 281		X	
2.0 mm	0218 510 282		X	
2.4-2.5 mm	0218 510 283		X	
3.0-3.2 mm	0218 510 298	X	X	
4.0 mm	0218 510 286	X		
5.0 mm	0218 510 287	X		
6.0 mm	0218 510 288	X		
<b>Knurled feed rollers tubular wire Ø</b>				
1.2-1.6 mm	0146 024 880		X	
2.0-4.0 mm	0146 024 881	X	X	X
<b>Knurled pressure rollers tubular wire Ø</b>				
1.2-1.6 mm	0146 025 880		X	
2.0-4.0 mm	0146 025 881	X	X	X
<b>Shaft for knurled pressure rollers</b>				
	0212 901 101	X	X	
<b>Feed rollers for Twin Ø</b>				
2 x 1.2 mm	0218 522 486			
2 x 1.6 mm	0218 522 488			
2 x 2.0 mm	0218 522 484		X	
2 x 2.5 mm	0218 522 480		X	
2 x 3.0 mm	0218 522 481		X	

## Ordering information

A6 Single Mastertrac, standard	0449 260 880
A6 Twin Mastertrac, standard	0449 260 881
A6 Single Mastertrac, high speed	0449 260 890
A6 Twin Mastertrac, high speed	0449 260 891
A6 Tandem Mastertrac, complete	0334 191 882

## Option

Contact equipment heavy Twin Arc, complete	0334 291 889
Wire reel, plastic, 30 kg	0153 872 880
Wire reel, steel, 30 kg	0416 492 880
Wire reel steel, flexible width	0449 125 880
Brake hub extra	0146 967 880
Rebuilding kit GMAW	0334 299 890
Strip cladding kit	0155 972 880
Flux hopper holder for strip cladding	0148 107 003
Wire reel, steel, for strip cladding, 30-100 mm	0671 161 880
Flux recovery nozzle, strip	0156 025 001
Flux funnel	0254 900 880
Insert, extended	0254 900 301
Angular slide	0671 171 580
Pilot lamp, light-bulb	0153 143 885
Pilot lamp, laser diode	0457 788 884
Flux recovery unit OPC	0148 140 880
Bracket suction	0332 947 880
Idler rollers (2 per automat)	0333 164 880
Guide wheel, fillet	0671 125 780
Magnetic guide rail, 3 m	0154 203 880

## Carbon arc gouging

Rebuilding kit carbon arc gouging (use with carbon electrodes Ø 8.9-12.7)	0153 592 880
VEC-motor, 312:1 to be used for carbon arc gouging	0145 063 905



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