



LHF 405/615 PIPEWELD

Heavy duty rectifiers

Robust and powerful

The LHF 405 PIPEWELD and LHF615 PIPEWELD are sturdy and robust thyristor-controlled units intended for manual heavy duty MMA welding with coated electrodes, TIG welding and arc-air gouging.

The LHF 405/615 PIPEWELD are made with a strong galvanised metal housing. The large wheels make them easy to move. Thus this range of units is recommended especially for the highest requirements and toughest areas of applications.

Well proven technology provides high reliability and outstanding welding performance.

Easy to use

The wide current range make it easy to optimise settings for a wide variety of filler materials.

It is possible to adjust parameters during welding process.

The LHF units are equipped with such functions as hot start, arc force and anti stick.

Flexibility

The units have vertical static characteristics which means that regardless of cable length and arc voltage, the current is constant.

The dynamic characteristics of the LHF range ensures stable, spatterfree arc and easily controlled molten pool.

Due to high power factor energy consumption is low as well as installation costs.



Welding properties of these units are configured to fulfil the requirements of welding with celluloid electrodes. The arc is very flexible starting from the lowest currents.

When the arc is shortened arc force makes weld penetration easier, especially when electrode is pressed against the welded material.

The LHF 405/615 PIPEWELD are machines with the meter, that allow current settings or voltage to be read from the front of the rectifier.

As an option the LHF range can be equipped with remote control units.

The units are switched off automatically in case of overheating. They conform to EN 60974-1.

Applications

- General fabrication and civil construction
- Repair and maintenance
- Power generation
- Pipelines
- Shipbuilding and offshore
- Process industry

- Best for cellulose electrodes
- Outstanding welding characteristics- high efficiency and high quality welding.
- Wide current and voltage range- multiple purpose applications.
- Mains voltage compensation - stable welding controls
- Stepless current control - exact settings and giving remote control facilities
- Hot start, arc force and anti stick
- Digital instrument

Technical data

	LHF 405 PIPEWELD	LHF 615 PIPEWELD
Mains voltage	230/400/415/500 V, 3~50 Hz 230/440-460/550 V, 3~60 Hz	230/400/415/500 V, 3~50 Hz 230/440-460/550 V, 3~60 Hz
Permitted load at		
35% duty cycle	400 A	610 A
60% duty cycle	310 A	450 A
100% duty cycle	240 A	345 A
Setting range (DC)	10A/20V - 400 A/36V	10A/20V - 630 A/44(49)V
Open circuit voltage	75 V	81 V
Open circuit power	330W	500W
Power factor at maximum current	0,80	0,89
Efficiency at maximum current	70%	74%
Inductance outlets	2	2
Dimensions lxxwxh	1310x 765 x 705 mm	1310x 765 x 705 mm
Weight	215 kg	303 kg
Operating temperature	-10 till +40°C	-10 till +40°C
Enclosure class	IP 23	IP 23
Application classification	S	S



Ordering information

LHF 405 PIPEWELD	0349 307 046
LHF 615 PIPEWELD	0349 307 055

Accessories

N02 Remote control unit wireless	0349 304 617
MMA 1 Remote control, 10 m	0349 501 024
MMA 2 Remote control, 10 m	0349 501 025
AT1 Remote control	0459 491 896
AT1 CoarseFine Remote control	0459 491 897
Connection cable 5 m analogue 12 pole	0459 552 880
Connection cable 10 m analogue 12 pole	0459 552 881
Connection cable 15 m analogue 12 pole	0459 552 882
Connection cable 25 m analogue 12 pole	0459 552 883

Quality accessories for the quality welder

ESAB offers a wide range of accessories. The complete range, along with product information, is available at our local web-sites, look at www.esab.com or contact your local ESAB dealer.

Unrivalled service and support

Our commitment and ability to deliver the expected service and support starts immediately after the order is confirmed. We endeavour to offer our customers an After Sales service, which is second to none. A strong and skilful service organisation is prepared to offer service and maintenance, calibration, validation and upgrading of equipment and software.

The service organisation will offer standardised solutions for the reconditioning or modification of existing products.

Spare and wear parts are manufactured according to ESAB's quality plan. Exchange Printed Circuit Board (PCB), exchange modules and components are available for all our products in order to reduce downtime to an absolute minimum. ESAB is continuously upgrading authorised service partners for local service support. Customers who have their own service and maintenance personnel will always be offered a service-training package as part of a total ESAB offering. However, product and process training for end-users will form an additional part of the ESAB offering. Always ask your ESAB sales representative or distributor for a complete ESAB solution.

*ESAB reserves the right to alter specifications without prior notice
ESAB is approved according to ISO 9001:2000*



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