



Unique Centering Jaw Chuck

Full Function in Place Orbital Pipe Welding Heads

FFIP

- Fully compatible with P300 and Gold Track welding power supplies.
- Direct clamping and centering on pipe.
- Minimal radial and axial clearances for restricted space conditions.
- Quick set-up and ease-of-operation.
- Full functions include; automatic arch voltage control, oscillation and wire feed.
- Vertical height and cross-seam wire manipulator adjustments.
- Electronic touch-start and center-of-weld adjustment.
- Liquid cooled torch body and cables, rated at 300 amperes.
- Pulsed oscillation and wire feed, synchronized with pulsed weld current.
- Operation up to 200 feet away from power supply via optional extension cables.
- Uses standard 4" (2 lb.) wire spools mounted in a separate enclosure.
- Patented friction motor drive mechanism.
- Remote operator pendant provides all jog functions and ON/OFF controls.
- E-FFIP version is also available without oscillation.



Weld Quality Starts in the Arc

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Specifications	Model 3080-A	Model 3081-A	Model 3082-A
Pipe Size Range:	1/2 to 1-1/2"	1-1/2 to 3"	3-1/2 to 6"
Maximum Pipe/Tube O.S.:	.840" to 2.00" (Ø 20 - 50 mm)	1.90" to 3.50" (Ø 48 - 90 mm)	4.00" to 6.63" (Ø 100 - 170 mm)
Rotor Speed:	0.2 to 2.0 RPM	0.2 to 2.0 RPM	0.2 to 2.0 RPM
Wire Size:	.035" to .040" (Ø 0.9 - 1.0 mm)	.035" to .040" (Ø 0.9 - 1.0 mm)	.035" to .040" (Ø 0.9 - 1.0 mm)
Wire Feed Rate:	10 to 120 IPM (25 - 300 cm/min.)	10 to 120 IPM (25 - 300 cm/min.)	10 to 120 IPM (25 - 300 cm/min.)
Spool Holder:	4", 2 lb. (Ø 100 mm, 1 kg) 25 lb option	4", 2 lb. (Ø 100 mm, 1 kg) 25 lb option	4", 2 lb. (Ø 100 mm, 1 kg) 25 lb option
Oscillator Travel:	0 to 1.00" (0 - 25 mm)	0 - 1.00" (0 - 25 mm)	0 - 1.00" (0 - 25mm)
Oscillator Rate:	50 IPM	50 IPM	50 IPM
AVC Travel:	.650" (16.5 mm)	1.00" (25 mm)	1.00" (25 mm)
Axial Clearances			
Total Depth (osc. out):	9.00" (228.5 mm)	9.00" (228.5 mm)	9.00" (228.5 mm)
Rear Face to Tungsten:	6.0"/7.0" (152.5/178 mm)	6.0" /7.0" (152.5/178 mm)	6.0" /7.0" (152.5/178 mm)
Forward Face to Tungsten:	1.00" (25 mm)	1.00" (25mm)	1.00" (25 mm)
Radial Clearance			
Center of Work to O.D.:	3.35" (85 mm)	3.95" (100 mm)	5.50" (140 mm)
Overall Length:	13.70"	15.25"	18.25"

*CE Compliant Version Available

