

High-production automatic welding with strip electrodes - a standard application for the A6 automatics.

SA welding with strip electrodes is a mechanized welding method for surfacing of low-alloy steel in constructions, exposed to corrosion and wear.

At repair welding, or welding of new items, the A6 strip cladding accessories form a complete range of equipment for all standard automatics in the A6 series.

- * High deposition rate and great surface coverage per welded joint result in high productivity.
- * Low penetration gives a clean weld and a minimum of intermixing of the base material.
- * Simple and sure method for continuous welding with high and uniform quality

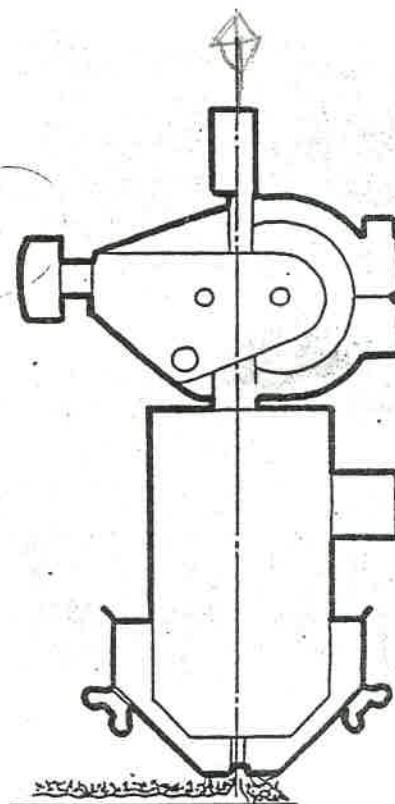
The A6 auxiliary strip cladding equipment, complete: Ordering no.
155 972-880 :

Accessories: Ordering no.:

- Suction nozzle 156 025-001
- Wire reel, 30 kg, 6711 618-80
for strips 30-100 mm

TECHNICAL DATA:

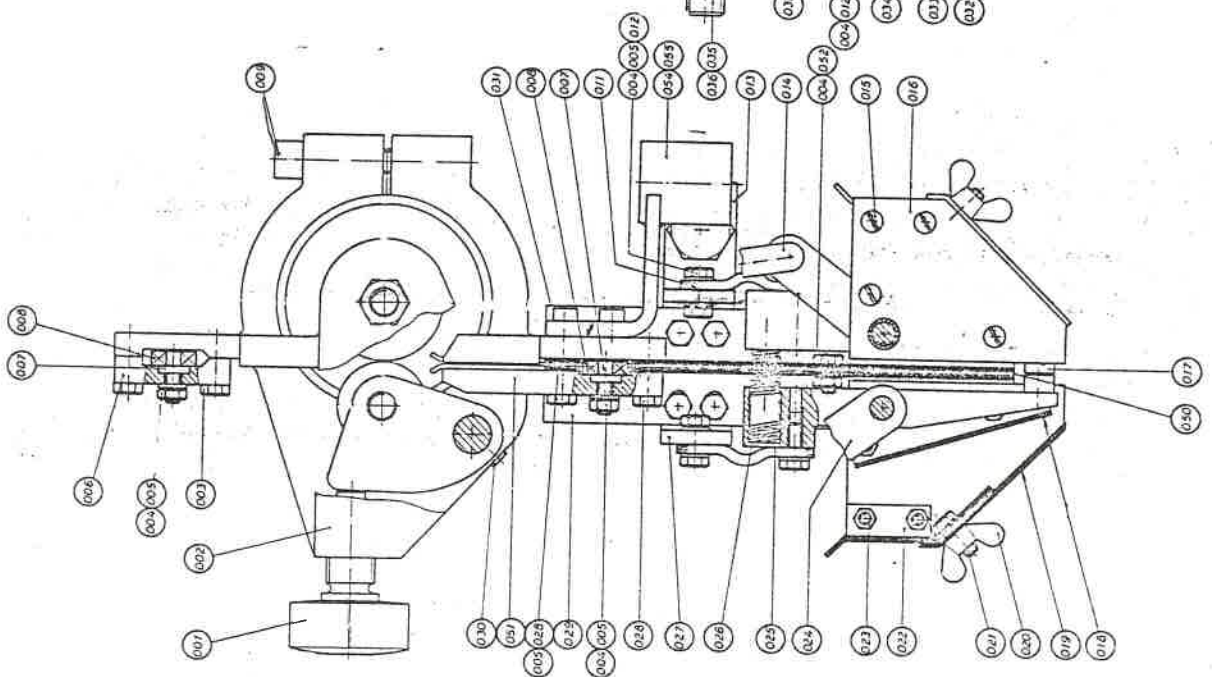
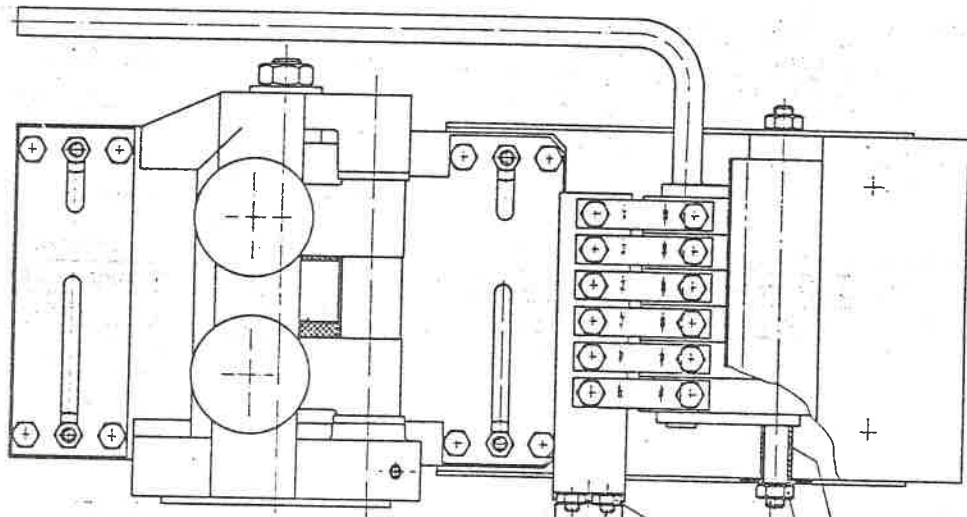
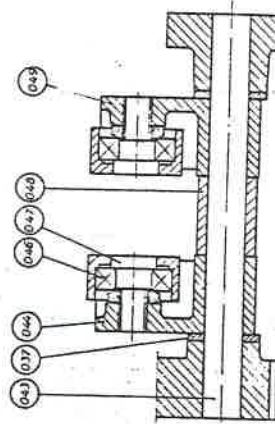
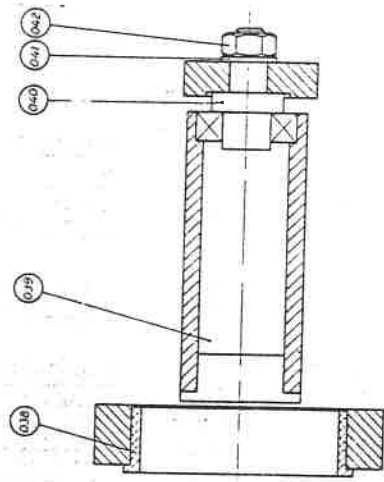
Width of strip: 30-100 mm
Thickness of strip: 0,4-0,7 mm
Max welding current : 1500A, cont.
Weight: 17 kg



Recommended min. plate thicknesses and diameters for strip cladding

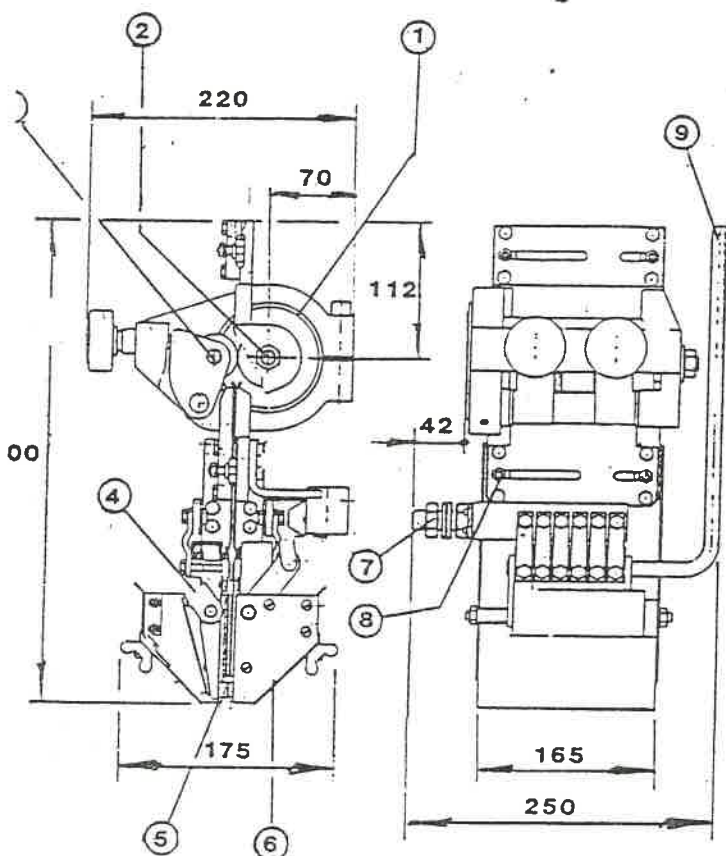
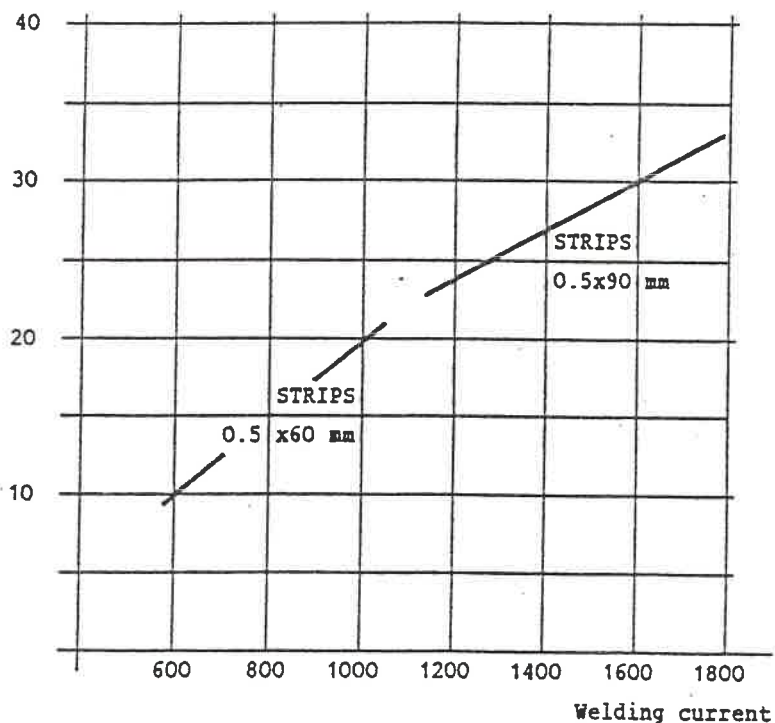
Strip electrode mm	Min. wall thickness mm	Min. diameter circular object External welding mm	Internal welding mm
0.5x30	15	125	350 ¹⁾
0.5x60	40	350	900 ²⁾
0.5x90	80	800	1500

- 1) ESAB A6 compact welding head for internal welding
- 2) A6 standard welding head with wire reels fitted at the back



Art no. s. Nr. o. de réf.	Ant Qty. Anz. Qté	Best nr Ordering no. Bestellnr. No. de commande	Benämning	Denomination	Bezeichnung	Désignation	Anm Remarks Anm. Remarque
		155 972-880	Bandpåsvefstill- sats kompl	Strip cladding set, compl.	Bandauftrag- schweisszusatz, kpl.	Équipement supplémentaire pour soudage par feuillard de re- chargement, compl.	A6 S UP
001	2	2188 101-81	Handratt	Handwheel	Handrad	Volant de cde.	SKF 626- 2Z
002	1	155 951-001	Klamma	Clamp	Klemme	Bride	
006	1	156 008-001	Styrning	Guide	Führung	Guide	
007	4	148 326-001	Tapp	Journal	Zapfen	Taraud	
008	4	2213 018-12	Kullager	Ball bearing	Kugellager	Roulement à billes	SKF 626- 2Z
010	2	332 413-001	Vägg	Wall	Wand	Paroi	
011	480	148 342-001	Bladkoppar	Sheet copper foil	Blattkupfer	Feuille de cuivre	
013	1	156 000-001	Skena	Bar	Schiene	Barre	
014	1	156 001-880	Hävarm, höger	Lever arm, r.h.	Hebelarm, rechts	Bras de levier, droite	SKF 626- 2Z
016	4	156 018-001	Gavel	Side plate	Seitenwand	Plaque latérale	
017	12	148 325-001	Kontaktback	Contact jaw	Kontaktbacke	Mâchoire de contact	
018	2	156 010-001	Skyddsplåt	Guard plate	Schutzblech	Plaque protective	
019	2	156 011-001	Justeringsplåt	Adjusting plate	Justierplatte	Plaque de réglage	SKF 626- 2Z
022	2	156 006-001	Distans	Spacer	Distanz	Entretoise	
024	1	156 001-881	Hävarm, vänster	Lever arm, l.h.	Hebelarm, links	Bras de levier, gauche	
025	12	148 324-001	Finger	Finger	Finger	Doigt	
026	12	192 190-035	Tryckfjäder	Compression spring	Druckfeder	Ressort de pression	SKF 626- 2Z
027	1	156 003-001	Skena	Bar	Schiene	Barre	
029	1	155 999-002	Skena	Bar	Schiene	Barre	
031	1	155 999-001	Skena	Bar	Schiene	Barre	
032	4	156 013-001	Distans	Spacer	Distanz	Entretoise	SKF 626- 2Z
034	2	156 016-001	Axel	Shaft	Welle	Arbre	
038	1	2155 036-01	Isolerhylsa	Insulating sleeve	Isolierhülse	Douille isolante	
039	1	148 335-881	Matarrulle	Feed roller	Vorschubrolle	Galet d'alimentation	
040	1	148 332-001	Tapp	Journal	Zapfen	Taraud	SKF 626- 2Z
043	1	156 012-001	Axel	Shaft	Welle	Arbre	
044	1	156 528-001	Huv till tryck- rulle	Thrust roller cap	Haube für Druckrolle	Capot de galet de pression	
046	2	153 148-880	Rulle	Roller	Rolle	Galet	
047	2	332 411-880	Axeltapp med bricka	Stub shaft with washer	Wellenstumpf mit Scheibe	Tourillon d'arbre avec rondelle	SKF 626- 2Z
048	1	156 015-001	Distans	Spacer	Distanz	Entretoise	
049	1	156 529-001	Huv till tryck- rulle	Thrust roller cap	Haube für Druckrolle	Capot de galet de pression	
050	2	156 014-002	Mellanlägg	Shim	Zwischenstück	Cale	
051	1	156 009-001	Styrning	Guide	Führung	Guide	SKF 626- 2Z
054	1	156 022-880	Hållare	Holder	Halterung	Support	
056	1	153 491-001	Förgreningsrör	Manifold pipe	Verzweigungsrohr	Tube d'embranchement	
057	2	145 064-001	Pulverslang	Flux hose	Pulverschlauch	Tuyau d'amenée de flux	
058	1	2529 004-07	Slangklamma	Hose clamp	Schlauchklemme	Collier de serrage	SKF 626- 2Z
059	2	192 471-104	Rörklamma	Pipe clamp	Rohrklemme	Bride de tube	
061	2	332 413-001	Vägg	Wall	Wand	Paroi	

Deposit
rate
kg/h



Functional description:

1. Assembly flange with clamp
2. Feed roller, strips 30-100 mm.
3. Thrust roller for strip feeding.
4. Articulated pressure arms for the contact jaws.
5. Individually loaded contact jaws for sure contact transition to the strip electrode.
6. Flux nozzle for adjustable flux quantity.
7. Connection of welding cable.
8. Adjustable guide rollers for different strip dimensions.
9. Lever for opening of the contact jaws for insertion of the strip electrode.