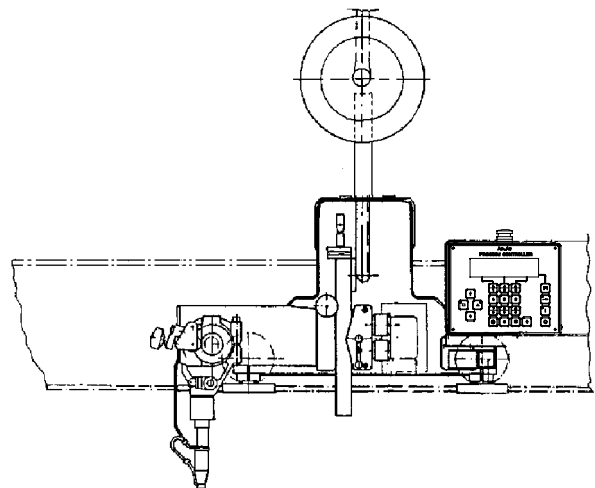
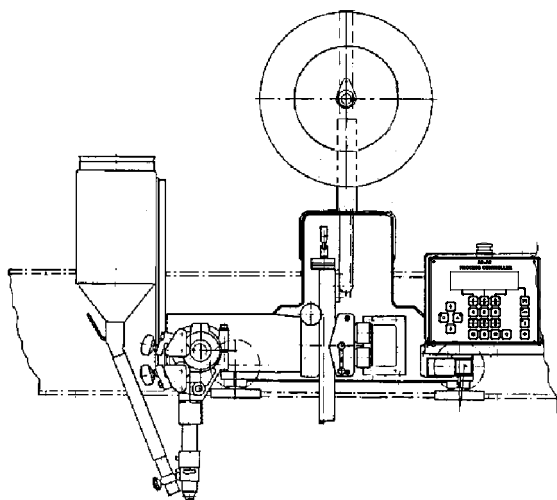


A2/A6 B



**Bruksanvisning
Brugsanvisning
Bruksanvisning
Käyttöohjeet
Instruction manual
Betriebsanweisung**

**Manuel d'instructions
Gebruiksaanwijzing
Instrucciones de uso
Istruzioni per l'uso
Manual de instruções
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FÖRSÄKRAN OM ÖVERENSSTÄMMELSE

Esab Welding Equipment AB, 695 81 Laxå, Sverige, försäkrar under eget ansvar att svetsautomat A2/A6 B från serienummer 846 är i överensstämmelse med standard EN 60292 enligt villkoren i direktiv (89/392/EEG) med tillägg (93/68/EEG) och standard EN 50199 enligt villkoren i direktiv (89/336/EEG) med tillägg (93/68/EEG).

OVERENSSTEMMELSEERKLÆRING

Esab Welding Equipment AB, S- 695 81 Laxå, Sverige, erklærer på eget ansvar, at svejseautomat A2/A6 B fra serienummer 846 er i overensstemmelse med standarden EN 60292 ifølge betingelserne i direktiv (89/392/EØF) med tillæg (93/68/EØF) og standarden EN 50199 ifølge betingelserne i direktiv (89/336/EØF) med tillæg (93/68/EØF).

FORSIKRING OM SAMSVAR

Esab Welding Equipment AB, S-695 81 Laxå, Sverige, försäkrar på eget ansvar at sveiseautomat A2/A6 B fra serienummer 846 er i overensstemmelse med standard EN 60292 i følge vilkårene i direktiv (89/392/EF) med tillegg (93/68/EF) og standard EN 50199 i følge vilkårene i direktiv (89/336/EF) med tillegg (93/68/EF).

VAATIMUSTENMUKAISUUSVAKUUTUS

Esab Welding Equipment AB, S-695 81 Laxå, Ruotsi, vakuuttaa omalla vastuullaan, että hitsausautomaatti A2/A6 B alkaen sarjanumerosta 846 täyttää standardin EN 60292 vaatimukset direktiivin (89/392/ETY) ja sen lisäysten (93/68/ETY) ehtojen mukaisesti sekä standardin EN 50199 vaatimukset direktiivin (89/336/ETY) ja sen lisäysten (93/68/ETY) ehtojen mukaisesti.

DECLARATION OF CONFORMITY

Esab Welding Equipment AB, S-695 81 Laxå, Sweden, gives its unreserved guarantee that automatic welding machine A2/A6 B from serial number 846 complies with standard EN 60292, in accordance with the requirements of directive (89/392/EEC) and addendum (93/68/EEC), and with standard EN 50199, in accordance with the requirements of directive (89/336/EEC) and addendum (93/68/EEC).

ZULASSUNGSNACHWEIS

Esab Welding Equipment AB, S-695 81 Laxå Schweden, bestätigt hiermit in Eigenverantwortung, daß der Schweißautomat A2/A6 B ab Seriennummer 846 dem Standard EN 60292 gemäß den Bedingungen der Direktive (89/392/EEG) mit Zusatz (93/68/EEG) und dem Standard EN 50199 gemäß den Bedingungen der Direktive (89/336/EEG) mit Zusatz (93/68/EEG) entspricht.

CERTIFICAT DE CONFORMITÉ

Esab Welding Equipment AB, S-695 81 Laxå, Suède, certifie que la machine automatique de soudage A2/A6 B à partir du numéro de série 846 est conforme à la norme EN 60292 selon les conditions de la directive (89/392/CEE) avec additif (93/68/CEE) et à la norme EN 50199 selon les conditions de la directive (89/336/CEE) avec additif (93/68/CEE).

VERKLARING VAN OVEREENSTEMMING

Esab Welding Equipment AB, S-695 81 Laxå Zweden, verklaart geheel onder eigen verantwoordelijkheid dat lasautomaat A2/A6 B van het serienummer 846 in overeenstemming is met norm EN 60292 conform de bepalingen in richtlijn (89/392/EEG) met annex (93/68/EEG) en met norm EN 50199 conform de bepalingen in richtlijn (89/336/EEG) met annex (93/68/EEG).

DECLARACIÓN DE CONFORMIDAD

Esab Welding Equipment AB, S-695 81 Laxå, Suecia, garantiza bajo propia responsabilidad que el equipo de soldadura automática A2/A6 B a partir del número de serie 846 concuerda con la norma EN 60292 conforme a la directiva (89/392/CEE) con el suplemento (93/68/CEE) y con la norma EN 50199 según los requisitos de la directiva (89/336/CEE) con el suplemento (93/68/CEE).

DICHIARAZIONE DI CONFORMITA

Esab Welding Equipment AB, S-695 81 Laxå Svezia, dichiara sotto la propria responsabilità che la saldatrice automatica A2/A6 B con numero di serie a partire da 846 è conforme alla norma EN 60292 come previsto dalla direttiva (89/392/CEE) e successive integrazioni (93/68/CEE) ed alla norma EN 50199 come previsto dalla direttiva (89/336/CEE) e successive integrazioni (93/68/CEE).

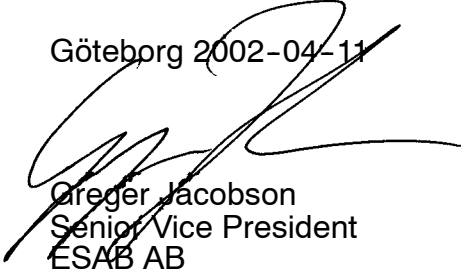
DECLARAÇÃO DE CONFORMIDADE

Esab Welding Equipment AB, S-695 81 Laxå Suécia, garante sob responsabilidade própria que a máquina de soldadura automático A2/A6 B a partir do número de série 846 está em conformidade com a norma EN 60292 segundo os requisitos da directiva (89/392/CEE) com o suplemento (93/68/CEE) e com a norma EN 50199 segundo os requisitos da directiva (89/336/CEE) com o suplemento (93/68/CEE).

ΔΗΛΩΣΗ ΣΥΜΜΟΡΦΩΣΗΣ

Η εταιρεία Esab Welding Equipment AB, S-695 81 Laxå, Σουηδία, δηλώνει ότι τα μηχανήματα αυτόματης συγκόλλησης A2/A6 B από τον αριθμό σειράς 846 και έπειτα, συμμορφώνονται με το πρότυπο EN 60292 σύμφωνα με τις απαιτήσεις της οδηγίας (89/392/ΑΑΓ) και του παραρτήματος (93/68/ΕΕΓ) και το πρότυπο EN 50199 σύμφωνα με τις απαιτήσεις της οδηγίας (89/336/ΕΕΓ) και του παραρτήματος (93/68/ΕΕΓ).

Göteborg 2002-04-11


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1 SAFETY

Users of ESAB welding equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of welding equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the welding equipment must be familiar with:
 - its operation
 - location of emergency stops
 - its function
 - relevant safety precautions
 - welding
2. The operator must ensure that:
 - no unauthorised person is stationed within the working area of the equipment when it is started up.
 - no-one is unprotected when the arc is struck
3. The workplace must:
 - be suitable for the purpose
 - be free from draughts
4. Personal safety equipment
 - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
 - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
 - Make sure the return cable is connected securely.
 - Work on high voltage equipment **may only be carried out by a qualified electrician.**
 - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
 - Lubrication and maintenance must **not** be carried out on the equipment during operation.



WARNING



ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.

ELECTRIC SHOCK - Can kill

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

FUMES AND GASES - Can be dangerous to health

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

ARC RAYS - Can injure eyes and burn skin.

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

FIRE HAZARD

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

NOISE - Excessive noise can damage hearing

- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

MALFUNCTION - Call for expert assistance in the event of malfunction.

READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.

PROTECT YOURSELF AND OTHERS!

WARNING

This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.

2 INTRODUCTION

2.1 General

A2/A6 B is a beam-travelling carriage that can be placed on the standard I-beam IPE 300, or if the accuracy requirements are higher, on a specially machined I-beam supplied by ESAB.

The horizontal drive of the carriage takes place over a drive motor with gear and a drive wheel running against the flange of the I-beam (see fig. 1 below).

By way of a disconnection device it is possible to move the carriage manually along the beam.

The control of the travel motor takes place over the PEH control unit where the desired speed can be set.

The beam-travelling carriage A6 B can be used in combination with all the modules in the ESAB A6 automation program.

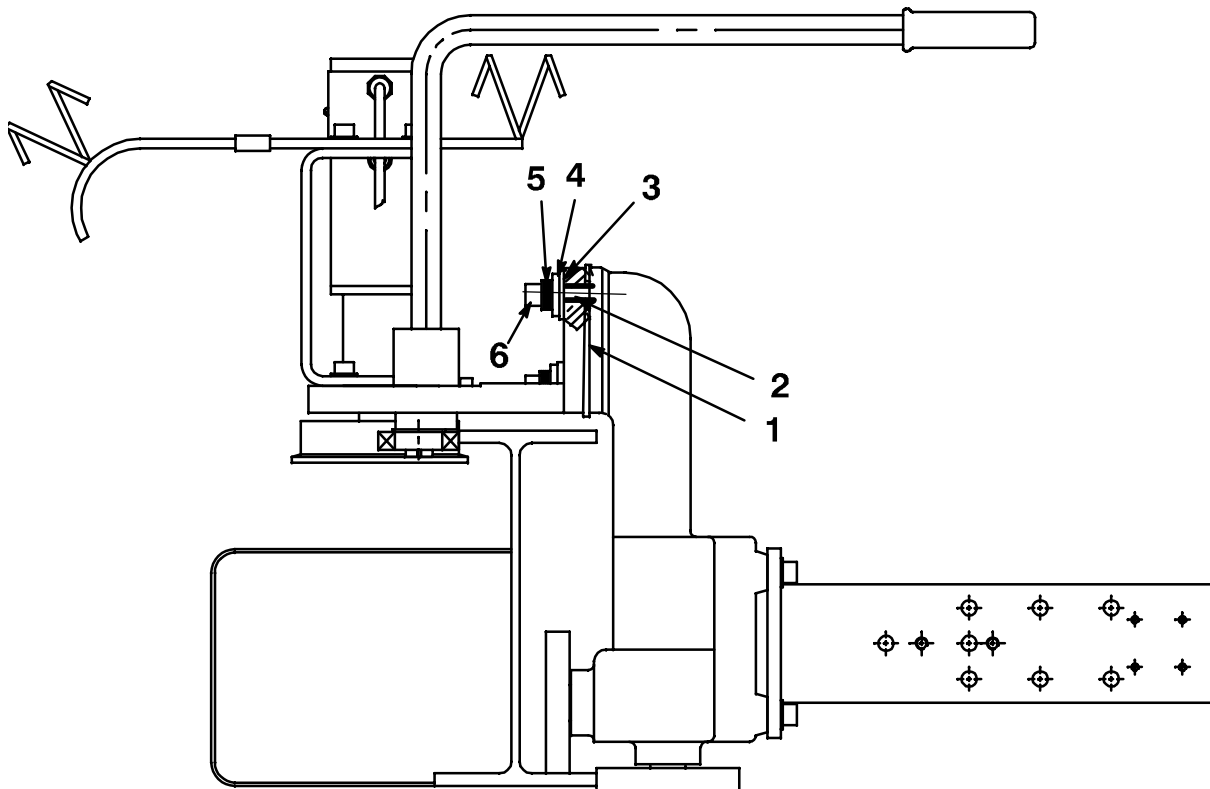
Together with the PAK slide control, GMD joint tracking unit, suitable welding heads and ESAB's automatic welding power sources, a complete welding station can easily be put together.

On delivery the beam-travelling carriage is adapted to be fitted on a machined beam of ESAB design.

Supplemental parts are supplied for the fitting of the carriage on an unmachined standard IPE 300 beam.

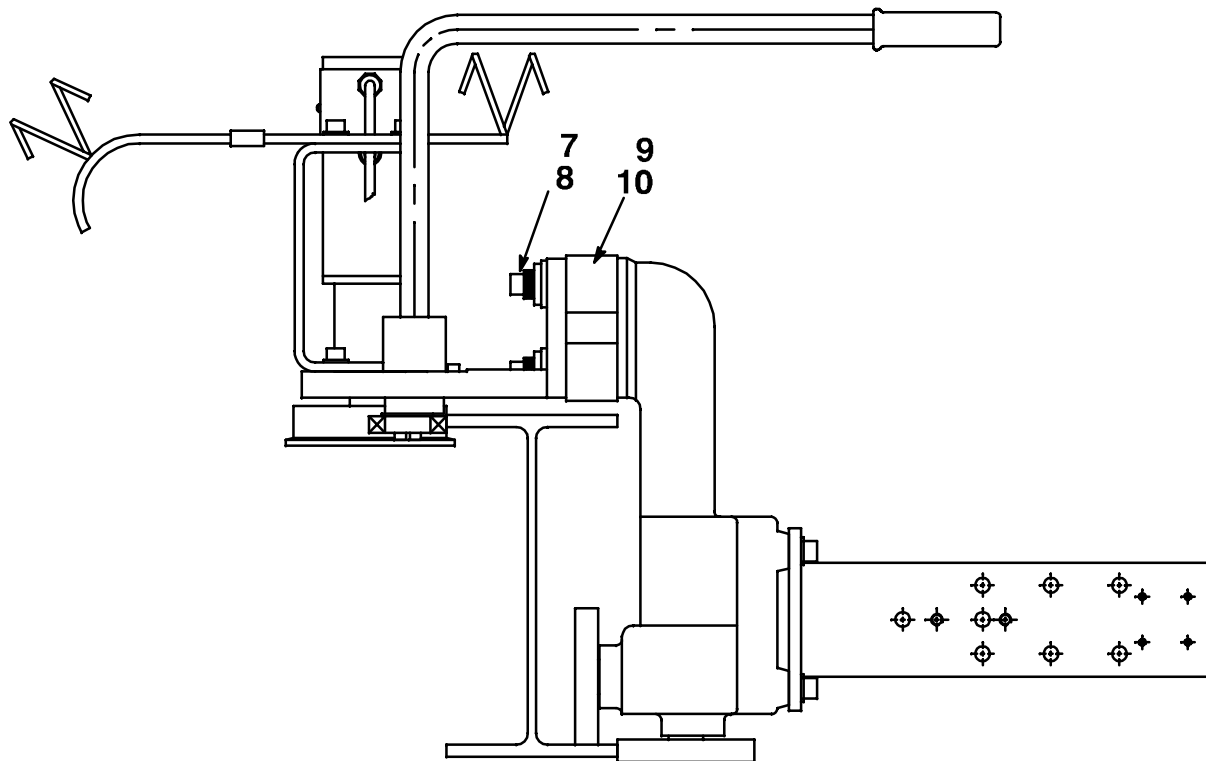
When fitting a tandem welding head against the box girder adapter plate 458 026 001 is to be mounted between the box girder and the tandem attachment.

A2/A6 B on machined beam



- | | |
|---------------------|-----------|
| 1. Insulating plate | 4. Washer |
| 2. Insulating tube | 5. Spring |
| 3. Washer | 6. Washer |

A2/A6 B on unmachined beam



- | | |
|----------------|----------------|
| 7. Washer | 9. Insulator |
| 8. Allen screw | 10. Stop screw |

When an unmachined beam is to be used the positions 1-6 (fitted on delivery) are to be replaced by the supplied positions 7-10 (four of each).

The delivery also contains the following parts:

- Bracket and attachments for fitting of the slides and the welding head to the carriage.
- Attachments for the PEH/PAK unit.
- Motor cable (3m) with contact device to be connected to the PEH unit (terminal X11).

2.2 Technical data

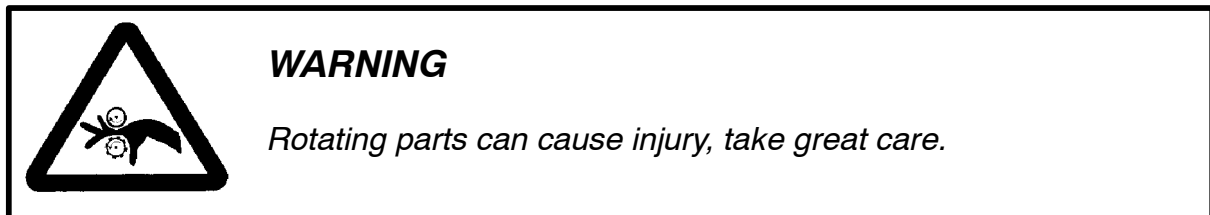
A2/A6 B with PEH	
Travel speed	6-250 cm/min (Motor MET 3700 Rpm / 124 with A6 tachometer)
Load moment	1090 Nm
Weight (without welding machine)	60 kg

3 INSTALLATION

3.1 General

The installation is to be performed by a professional.

Also consider the instructions in the separate instruction manuals supplied with the different modules to be fitted on the beam-travelling carriage A2/A6 B.



When installing, follow the instructions for

1. Automatic welding machine A2 SFE1/SGE1, see instruction manual 0456 552.
2. Automatic welding machine A6 SFE1/SFE2/SGE1/SFE1C, see instruction manual 0456 562.
3. PEH control unit, see instruction manual 0443 745.

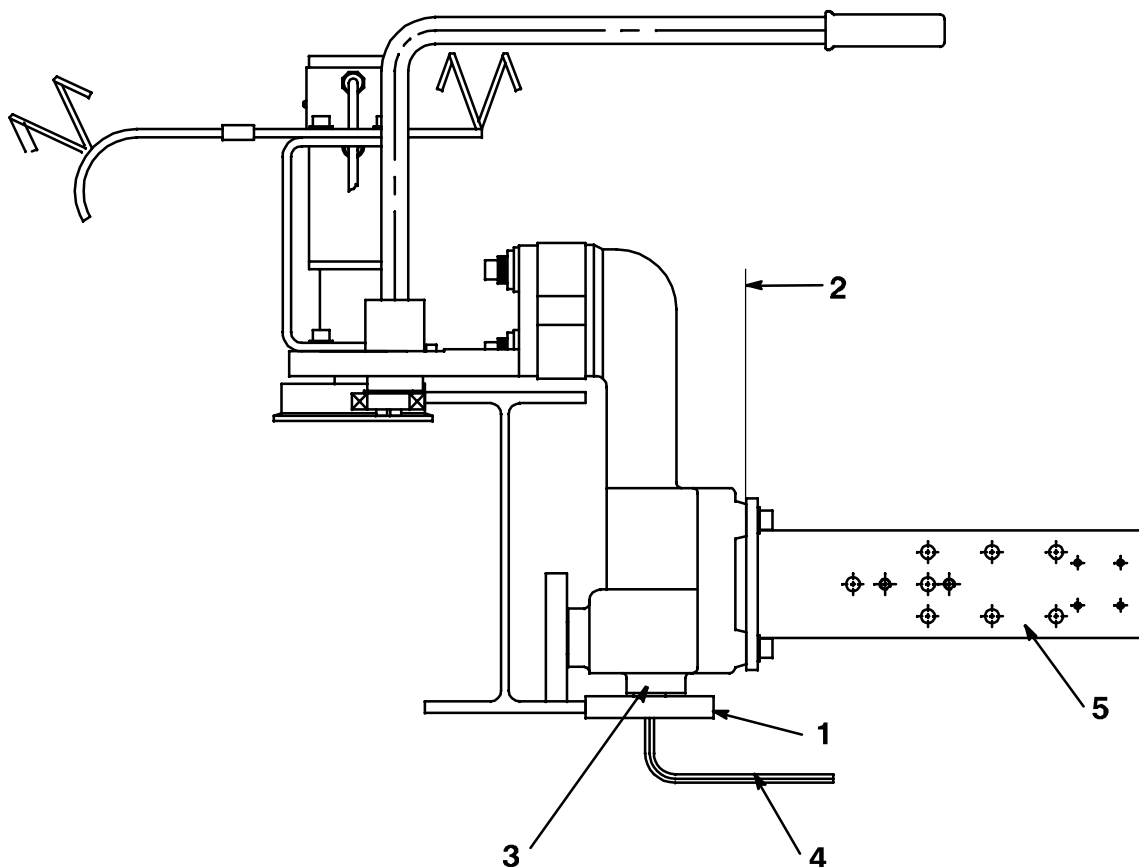
3.2 Assembly

1. Placing the carriage on the beam:
 - Lift up the beam-travelling carriage on the beam.
When lifting or displacing the carriage, use a lifting strap dimensioned for at least 500 kg.
 - Make sure the strap is properly fitted so that the carriage cannot work loose.
 - Check that no sensitive parts have been damaged during the lift.

2. Adjusting the wheels of the carriage:

- The carriage wheels (1) are to be adjusted so that the mounting plane of the carriage (2) is in vertical position.

The adjustment is made by way of the eccentricity lodged wheel pairs running against the flange of the beam (see the following figure).

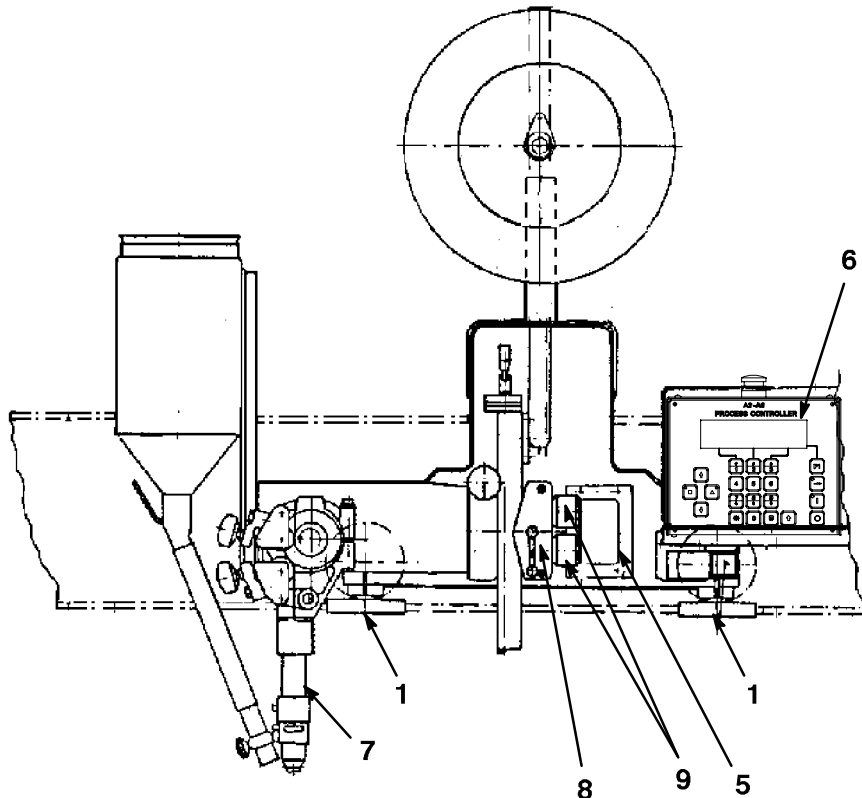


- Undo the attachment screws (Allen, M10) of the respective bearing support (3).
- Turn the eccentric shafts clockwise using Allen key (4).
- Check with a spirit level that the mounting plane is in vertical position.
- Tighten the attachment screws.

N.B. Adjust the two wheel pairs so that they touch the flange of the beam.

3. Fitting the box girder and PEH unit:

- Fit the box girder (5) on to the carriage and screw up the PEH unit (6) with four screws.



4. Fitting the automatic welding machine:

- Fit the automatic welding machine (7) on to the carriage over the horizontal slide (8).

5. Fitting the insulators:

- Place the four insulators (9) between the slide and the carriage to avoid galvanic contact between two units.

3.3 Connections

Connections and adjustments of the beam-travelling carriage A2/A6 B A6 B are to be performed according to the instruction and service manuals for the A2-A6 Process Controller (PEH).

Other system connections appear from the respective manual of the system modules supplied.

4 OPERATION AND MAINTENANCE

4.1 General

General safety regulations for the handling of the equipment can be found on page 42. Read through before you start using the equipment!

Please also observe the directions in the other manuals supplied regarding the assembly of the beam-travelling carriage A2/A6 B.

The bearings in A2/A6 B are permanently lubricated and free of maintenance.

Keep the beam free of oil, grease, dirt and particles, which can obstruct the motions of the beam-travelling carriage.

5 TROUBLE SHOOTING

For trouble shooting, see the respective manual for A2-A6 Process Controller and A2/A6 welding heads and automatic power sources.

6 ORDERING OF SPARE PARTS

A2/A6 B is designed and tested in accordance with the EN 60 292 (IEC 292) international standard.

It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.

Spare parts are ordered through your nearest ESAB representative, see back cover. When ordering spare parts, please state machine type and number as well as designation and spare part number as shown in the spare parts list on page 113. This will simplify dispatch and ensure you get the right part.

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