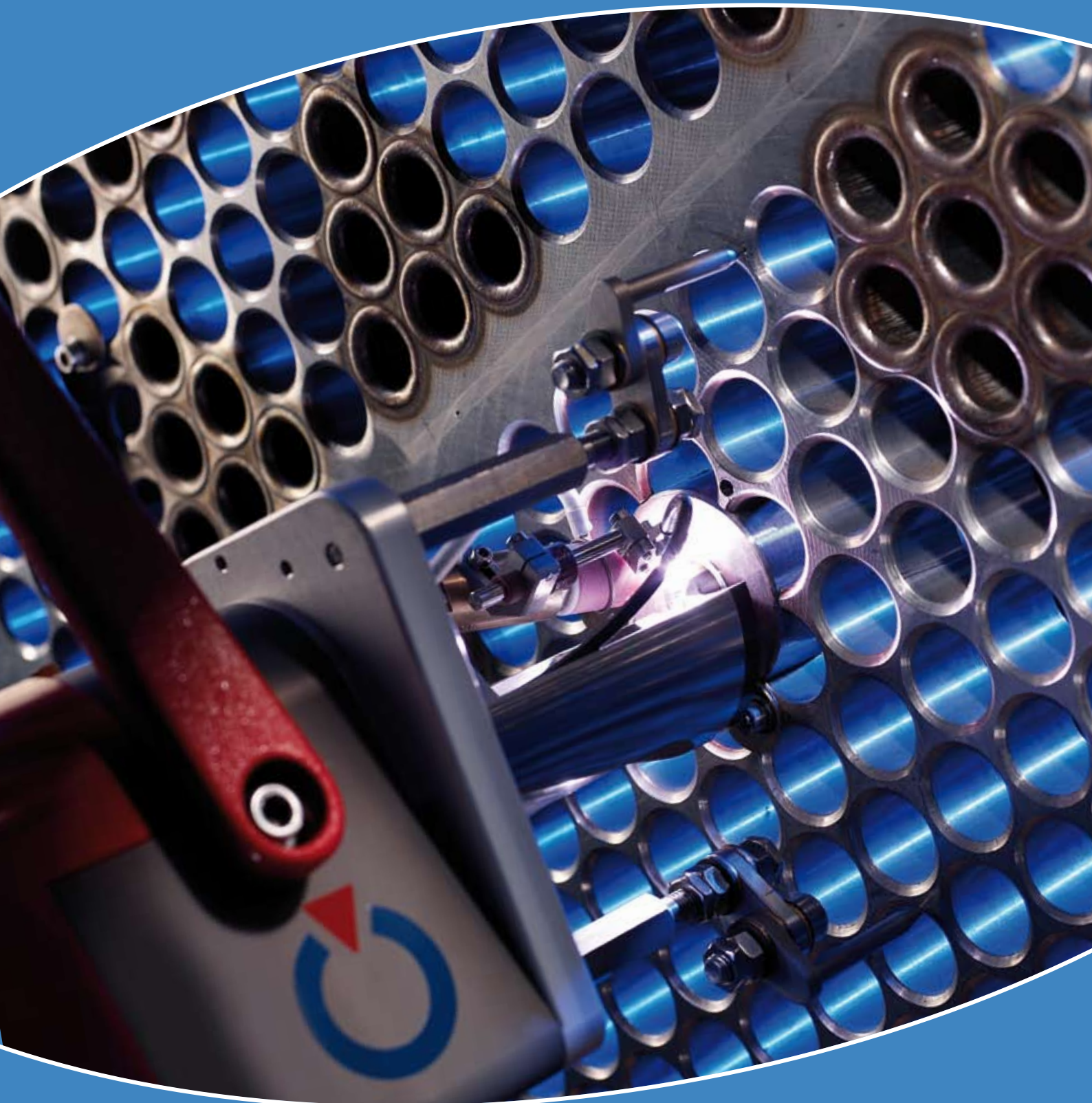


TS 2000

TIG - With or without Filler Wire, AVC

Open Welding Head

for welding of tube to tubesheet joints



TS 2000

Open Welding Head

for welding of
tube to tubesheet joints

Easy to use, highest quality and productivity

Advantages

- ▶ Productivity increase of more than one third
- ▶ Easy to use
- ▶ Instant adaptation to workload variations by simultaneous use of multiple welding heads

Resulting from 50 years' experience in mastering welding technologies

General Characteristics

Pneumatic clamping and holding device

Particularly designed for high duty cycle applications by means of high temperature resistant materials and closed loop water cooling

Expansion mandrel for all tube I.D.'s

Various types of tooling are available to accommodate all existing tube joint designs

Endless rotating torch, no cable wrap-up by means of a unique collector to supply the torch with welding current, shielding gas and cooling liquid

Torch with ceramic nozzle and diffuser providing laminar gas protection

According to the application, motorised Arc Voltage Control (AVC) or programmed arc height

Centering mandrel for all tube I.D.'s

Closed loop regulation to ensure precise, constant or pulsed welding speed

Purge gas chamber for titanium and Inconel®, independent from torch shielding gas, reducing purge time and welding oxidation

Encoder for position based control of the welding program

4-axis wire adjustment

Return-to-home feature: the electrode automatically returns to its starting position

Filler wire feeder modules on board (1,5 kg spool) or floor mounted POLYFIL (15 kg spool)

Different types of configuration

- Protruding tube welding
- Flush tube welding
- Recessed tube welding
- Back plate tube welding
- Double plate - header box welding
- Internal tube welding

Associated Power Sources



▶ PS 406-2

400 A, "all inclusive", with Arc Voltage Control (AVC) and Torch Oscillation Control (OSC), three-phase power supply



▶ P6

300 A, "all applications", programming by PC or touch screen, with Arc Voltage Control (AVC) and Torch Oscillation Control (OSC), three-phase power supply



▶ PC Serie

300 to 600 A, modular design for perfect adaptation to your application. Interface for mechanised and robotic peripherals, three-phase power supply

Wire Feeders



▶ Polyfil-3

External wire feeder for 15 kg spools

 Adapting to all your applications!



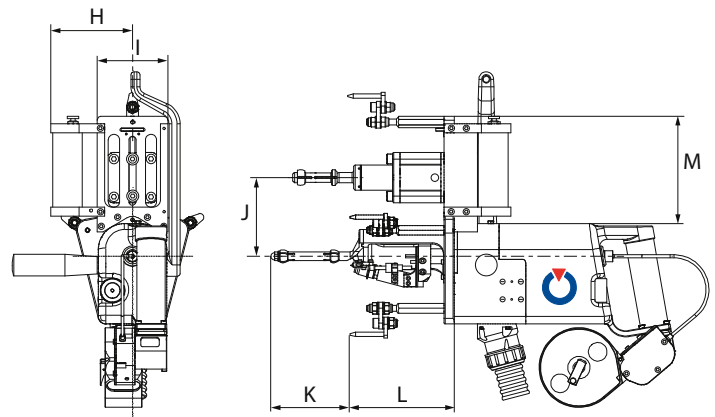
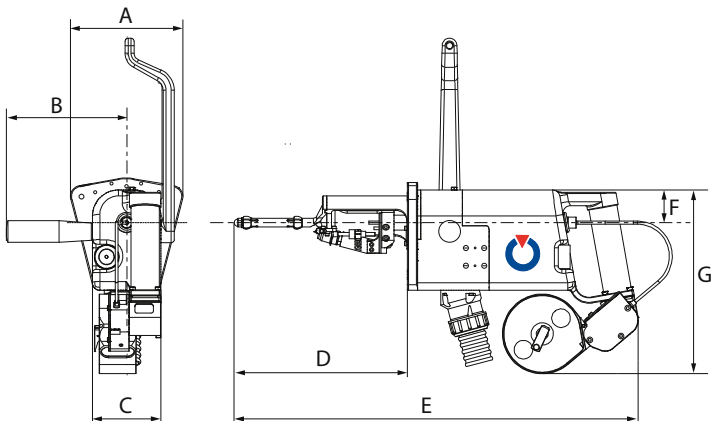
*“The only way to accomplish
double plate - header box welds.”*

Technical Specification

Min. tube I.D.	10 mm
Max. tube O.D.	60 mm
Duty cycle	200 A / 60%
Torch cooling	Closed loop, water
Arc Voltage Control (AVC)	✓
Wire feeder (on-board or floor mounted)	✓
Wire spool diametre	
• on-board	1,5 kg / 4"
• floor mounted	15 kg / 300 mm
Tube joint designs:	
• flush	✓
• recessed	max. 2 mm
• protruding	max. 13 mm
• internal bore welding	✓
• back plate - header box welding	✓
Positioning / centring	Flexible centring mandrel
Weight	11 kg (with on-board wire feeder, excl. cable)

✓ standard
 ✓ option

Cable length: 9 m



Dimensions in mm						
A	B	C	D	E	F	G
152	162	92	233	540	44	250
H	I	Jmin	Jmax	K	L	M
110	95	98,5	131,5	107	140	144

Options and Accessories

- Flexible centring mandrels for all tube I.D.'s
- Filler wire feeder modules on board (1,5 kg spool) or floor mounted POLYFIL (15 kg spool)
- Pneumatic clamping device to increase handling comfort and therefore quality and productivity
- Various standard torch angles and special toolings are available for all existing tube joint designs and types of heat exchangers
- Purge gas chamber for titanium and Inconel®, independent from torch shielding gas, reducing purge time and welding oxidation
- Extension cable (15 m)
- Dual welding head switch box (without AVC)
- Compact brief-case for transport and storage
- Tungsten electrodes pre-sharpened and pre-cut

POLYSOUDE : Related Services

► Guidance and technical support

A welding application specialist in your area will advise you on the welding process and appropriate equipment for your application.

► Commissioning / Training

A complete training program will enable you to start using the equipment immediately and in the best way possible.

► Maintenance / Repair

Maintenance and repair operations can be carried out at the Polysoude plant as well as on site by our service network.

► Rental service

Increase the flexibility of your production! A large range of equipment is available for rental from our hire fleet.

Your partners worldwide

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