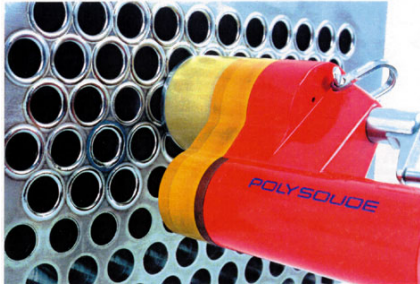


## TS 25 CLOSED WELD HEAD

*Welding of tube to tube-sheet joints*



*Location and positioning on tube-sheet*



*TS 25 in the production of heat exchangers*



*TS 25 with expandable mandrel*

### CHARACTERISTICS

- Centring spindle for mandrel uptake
- Reliable shielding gas system with total gas protection of the weld pool during the entire welding cycle for welding materials that are extremely sensitive to oxidation
- Small, light and very compact
- Modular design
- Lever for fixing and opening of the clamping-positioning-system
- Water resistant plastic storage case
- Rigid, vibration-free mechanical system
- Max. weld current intensity of 100 A at a 20% duty cycle
- 30 welds per hour on 25.4 mm O.D. tubes with 1 mm wall thickness and Argon shielding gas
- Highly accurate speed and position controls due to a DC gear drive with closed loop regulation

### USE

Special for welding of flush tubes (highly oxidisable materials) on tube-sheet (from tube inside-diameter 10 mm up to 25,4 mm)

Designed for automatic orbital welding of thin walled tubes to tube sheet conditions of productivity owing to the TIG process without filler wire

### MATERIAL

- Stainless steel
- Titanium
- Inconel
- etc.

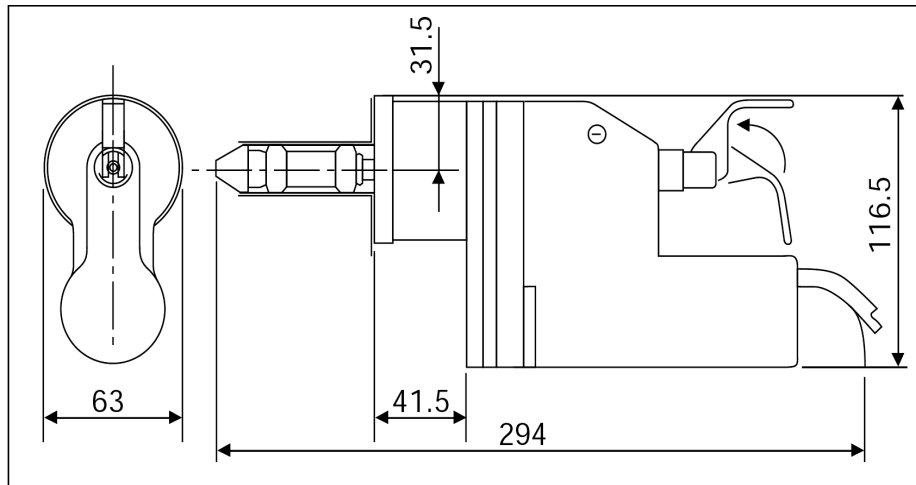
### APPLICATION SECTORS

- Chemical, food & beverage industries
- Heating and ventilation: production of heat exchangers
- Pharmaceutical / Biochemical industry

### ACCESSORIES & OPTIONS

- Hose & cable supply 9 m
- Sharpened and cut electrode to suitable length
- Toolings
- Complete clamping assembly for int.  $\varnothing < 10$  mm (TS 25)
- Container for safety packing and transport

**TECHNICAL DATA TS 25**



TS 25

<b>Min. tube I.D.</b>	10 (*)
<b>Max. tube O.D. (in mm)</b>	25,4 for lower dimensions, please consult us
<b>Capacity</b>	100 A
<b>Torch cooling</b>	Water
<b>Welding of tubes :</b>	
- flush	●
- recessed	1 mm max
- protruding	0,5 mm max
<b>Positioning on the tube sheet</b>	Expandable mandrel
<b>Internal welding</b>	○
<b>Protection chamber</b>	● ●
<b>Weight</b>	1,5 kg
● Standard	
○ Option	

(\*)  $\varnothing$  min. 7 mm with option clamping assembly

**EXAMPLE OF APPLICATION:**  
Flush tubes at the front of the plate

