



ESAB ID Internal seamers

Longitudinal seam welding machines

- **Automated welding of longitudinal seams**
- **Higher welding quality at maximum speed**
- **Improved productivity**
- **Welding processes: SAW, MIG/MAG, TIG**

Reliable

ESAB internal seamers are designed in close co-operation with the best professionals in the field and on the basis of extensive practical experience.

Productive

ESAB ID40H10 and ID60H10 seamers are in fact the best solution for welding high quality longitudinal welds to plates, tanks or other cylindrical workpieces. Internal seamers are available for several types of welding methods. All seamers are delivered ready for welding; seamer and welding equipment installed and tested.

Flexible

Standard internal seamers are available for welding max 6 m long welds and for diameters bigger than 1500 mm. Alignment of plates is easy with pneumatically operated stoppers (option). Also ready tack-welded cylinders can be easily aligned with the help of laser light beam. The clamping of the workpiece is done with heavy duty clamping fingers, which has changeable copper finger tips. The backing bar is water-cooled and for the TIG process the copper backing bar is equipped with shielding gas. To avoid unnecessary use of shielding gas when welding short workpieces, the gas flow to backing is divided with gas valves.

Automatic working cycle

The operation is easy with remote control including manual control as well as automatic working cycle. The automatic working cycle is PLC-controlled.



ID60H10 Seamer



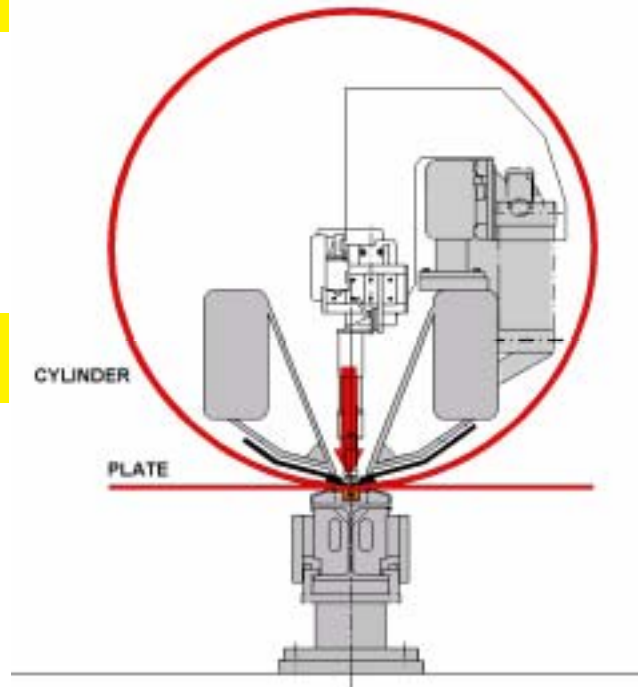
ID60H10 Seamer with remote control and in- and out-feeding conveyor

Technical data

	ID40H10	ID60H10
Nominal length, mm	4000	6000
Welding length, mm	4250	6250
Minimum diameter mm	1500	1500
Plate thickness, not tack-welded, mm	1-8	1-8
Max plate thickness, tack-welded	10	10
Power supply connection	3x400VAC, PE, N, 50 Hz, 16A	

Ordering information (Seamer incl welding equipment)

	ID40H10	ID60H10
SAW1	PH10696300	PH10696400
SAW2	PH10637600	PH10637700
MIG1	PH10696500	PH10696600
MIG2	PH10637800	PH10637900
MIG3	PH10638000	PH10638100
TIG1	PH10638200	PH10638300
TIG2	PH10638400	PH10638500



Optional accessories

	ID40H10	ID60H10
In- and out-feeding conveyor lines	-	-
AVC control for plasma equipment	PH10642300	PH10642300
Camera monitoring systems	PH10642200	PH10642200
Pneumatic plate stopper required amount	3	3

SAW1	LAF 635 power source, A2 wire feeder with PEH control, OPC flux recovery
SAW2	LAF 1000 power source, A2 wire feeder with PEH control, OPC Flux recovery unit
MIG1	Origo™ Mig 500t power source, Origo™ Feed 484w M13 wire feeder, MIG-torch
MIG2	Aristo™ Mig 4000i power source, Aristo™ Feed 4804w MA6 wire feeder, MIG-torch
MIG3	Aristo™ Mig 5000i power source, Aristo™ Feed 4804w MA6 wire feeder, MIG-torch
TIG1	Aristo™ Tig 4000i power source, BTE 500M TIG-torch
TIG2	Aristo™ Tig 4000i power source, MEI 21 wire feeder (cold wire), BTE 500M TIG-torch



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