



Kjellberg[®]
FINSTERWALDE

High-Performance Submerged Arc Welding with Multi-Wire Technology



With immediate effect, Kjellberg Finsterwalde offers you the opportunity to optimise the submerged arc welding process. This is made possible by using an increased number of wire electrodes. Several (≥ 2) wires arranged one after another form a collective cavern and, thereby, create a considerably higher melt volume. While the first electrode (DC) produces the optimum penetration by way of higher welding current, the following wires (AC) fill the joint. Depending on the seam geometry, the last wire electrode produces a broad seam with an excellent surface, usually at lower current and higher voltage.

Generally, the melting deposition rate increases with every further wire electrode used, with 3 or 4 being the usual number of wires. The welding speed amounts up to 120 cm/min and is considerably higher compared to the single-wire technology.

The submerged arc welding technology is a high-performance welding method which guarantees excellent quality. The cavern is covered with a flux layer and, thus, atmospheric influences are excluded and the undesirable open arc can be avoided. These features allow a mechanisation of the entire process which, due to modern control technology, fulfils almost every customer requirement.

Specifications:

- 1 leading nozzle fitting (DC)
- 2 or more subsequently arranged nozzle fittings (AC)
- Long version of the nozzle fittings for welding wires from $\varnothing 3$ mm to $\varnothing 5$ mm
- Flux feeding from front is possible with pressure tank and combined with different pneumatic extraction systems
- Seam tracing as visual (laser pointer or laser sensor) and mechanical (tactile sensor) version
- Manual fine adjustment of the nozzle fittings via motor-driven linear support
- Central control unit
- Welding data recording and parameter filing is possible
- Adaption to components like portals and columns and booms is possible

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