



Kjellberg®

FINSTERWALDE

SUBMERGED ARC WELDING

WELDING AUTOMAT



KA 1-UP 5 mm

Application: SA single arc welding and cladding on even surfaces with or without guide rails

Welding wire: 2.4-5.0 mm

Article no.: .11.300.105.N

Advantages

- ✓ Mobile, self-propelled welding automat, which easily can be moved to any working place
- ✓ Easy control by pre-set controls for welding current, arc voltage and travel speed in connection with Kjellberg power sources
- ✓ Start and stop circuit for optimising the welding process; start and crater filler parameters to adjust separately
- ✓ Exact positioning of the welding head with cross slides in horizontal and vertical direction or guidance along bars, profiles etc.
- ✓ Reliable wire feed
- ✓ Encoder-controlled tractor with all-wheel drive (rubber or optional grooved rims)
- ✓ Dust-protected manual drive coupling and optional axle extensions for additional stabilisation
- ✓ Control elements on two service levels
- ✓ Quick adaptation to other process variant thanks of modular system (e.g. single wire to double wire)

Standard equipment

Carriage
Wire feeder
Laser pointer
KA control
Flux hopper



Robust feeding gear for wire up to Ø 5.0 mm



SA parallel wire nozzle for KA 7-UPP

Options

Flux recovery unit
Rails
Gap welding nozzle
Grooved wheels

Kjellberg is certified acc. to
DIN EN ISO 9001

Technical data	KA 1-UP 3 mm	KA 1-UP 5 mm	KA 7-UPP
Article no.	.11.300.103.N	.11.300.105.N	.11.300.700.N (double wire)
Welding current max.	800 A	1200 A	1200 A
Wire diameter	1.6-3.2mm	2.4-5.0 mm	2x 2.0-2x 3.0 mm
Wire feed speed	0.1-10 m/min	0.1-6.5 m/min	0.1-10 m/min
Travel speed		0.1-1.5 m/min	
Cross/height adjustment		100/100 mm	
Column swivel range		360 °	
Welding head inclination		45 ° (to both sides)	
Mass KA+wire reel	57 kg + max. 30 kg	66 kg + max. 30 kg	68 kg + max. 2x 25 kg
Travel gauge		265 mm Option: 330 oder 395	
Dimensions L x W x H ca.	1110 x 560 x 940 mm	1050 x 600 x 900 mm	1050 x 600 x 900 mm
Control voltage		42 V AC/50 Hz	
Recomm. power source	GTH 802	GTH 1202	GTH 1202

+49 3531 500-800

welding@kjellberg.de

www.kjellberg.de

Kjellberg Finsterwalde
Schweißtechnik und
Verschleißschutzsysteme
GmbH
Oscar-Kjellberg-Str. 18
03238 Finsterwalde
Germany

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