



# Kjellberg®

## FINSTERWALDE

## SUBMERGED ARC WELDING

## WELDING AUTOMAT STEERABLE



### KA 1-UP 5 mm steerable

Application: UP-Eindrahtschweißen und  
-Plattieren insbesondere  
von Rundnähten in Rohren

Welding wire: 2.5-5.0 mm

Article no.: .11.303.105

Alternatives:

KA 1-UP 3 mm .11.303.103

KA 7-UPP .11.300.700 (double wire)

### Advantages

- ✓ Mobile, self-propelled welding automat, which easily can be moved to any working place
- ✓ Especially suitable for welding inside of conical tubes from approx. 1,000 mm Ø
- ✓ 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
- Reliable wire feed
- ✓ Tachogenerator controlled tractor with all-wheel drive (rubber rims)
- Dust-protected manual drive coupling
- 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

### Options

**Flux recovery unit**  
**Rails**



KA 1-UP 5 mm as steerable version

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.	.11.303.103	.11.303.105	.11.303.700
Welding current max.	800 A	1,400 A	1,400 A
Wire diameter	1.6-3.0mm	2.5-5.0 mm	2x 2.0-2x 3.0 mm
Wire feed speed	0.1-10 m/min	0.1-6.1 m/min	0.1-6.1 m/min
Travel speed		0.1-1.6 m/min	
Cross/height adjustment		100/100 mm	
Column swivel range		360 °	
Welding head inclination		45 ° (to both sides)	
Mass KA+wire reel	51 kg + max. 30 kg	61 kg + max. 30 kg	61 kg + max. 2x 25 kg
Travel gauge		265 mm Option: 330 or 395	
Dimensions L x W x H ca.	1,110 x 560 x 940 mm	1,050 x 600 x 900 mm	1,050 x 600 x 900 mm
Control voltage		42 V AC/50 Hz	
Power sources (recomm.)		GTH 802, <b>GTH 1002</b>	

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