/ Battery Charging Systems / Welding Technology / Solar Electronics

SHIFTING THE LIMITS

STOP VALVE

/ Circular welding system
/ MAG
/ Stop valve

OVERVIEW

/ Compact circular welding system for stop valves. The work piece can be clamped pneumatically via tailstock. Work piece center cones provide perfect centring. The simultaneous use of 2 MAG torches allows mechanized welding of inner and outer body in one single operation.

FEATURES

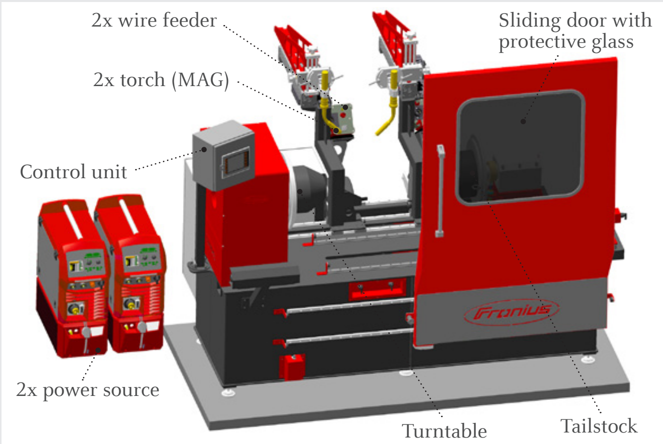
/ Easy handling and robust long life system design
/ Sliding door with protective glass and safety switch
/ Wire feeder consoles
/ Weld heads – fast and easy adjustable
/ Pneumatic torch positioning
/ Head- and tailstock with work piece centring cones
/ Clamping system with safety switch
/ PLC control unit with display incl. current flow signal monitoring
/ Data transfer between control unit and power source via digital interface
/ Sector-programming, job-memory and job-access
/ Clamping pressure display
/ EasyJob function for storing the power, arc-force dynamic and correction values with one push of the button
/ Best welding performance with Steel Transfer Technology
/ Dust filter protects the inner workings of the power source from soiling
/ Water filter cleans the coolant, prolonging the service life of the whole system
/ Thermostat-controlled fan runs only when needed, which lessens dirt accumulation inside the unit

/ Pneumatic torch positioning

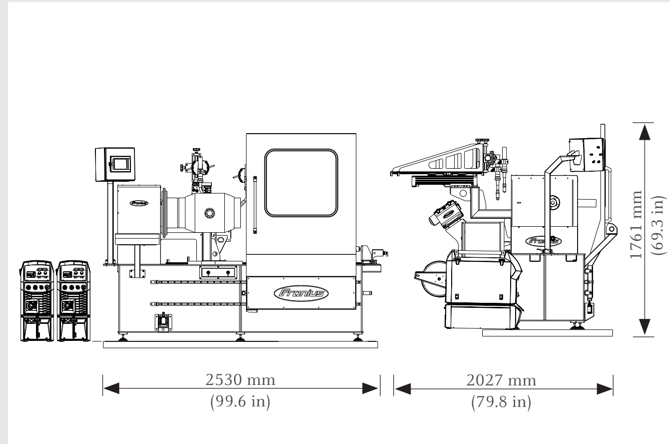
/ Sliding door with protective glass

/ Work piece – stop valve

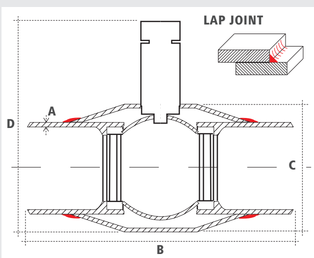
SYSTEM COMPONENTS



LAYOUT



APPLICATION



WORK PIECE	
Work piece description	Ball valve
Material	Steel
Material thickness (A)	2 - 3 mm (0.079 - 0.12 in)
Work piece length (B)	max. 635 mm (25 in)
Outer diameter (C)	max. 325 mm (12.8 in)
Outer diameter (D)	max. 500 mm (19.7 in)
Weight	max. 60 kg (132.3 lb)
Arrangements by customer	Cleaned, tack welded, machined

WELDING PROCESS	
Welding process	MAG
Welding position	PA, PB
Welding speed	35 - 50 cm/min (13.8 - 19.7 in/min)
Layers	1 - 3
Filler material	GS3Si1
Gas	80% Ar, 20% CO_2
Wire diameter	1,2 mm (0.047 in)
Wire speed	8,1 m/min (318.9 in/min)
Joint	Lap joint

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Fronius Canada Ltd.
2875 Argentia Road, Units 4,5 & 6
Mississauga, ON L5N 8G6
Canada
Telephone +1 905 288-2100
Fax +1 905 288-2101
sales.canada@fronius.com
www.fronius.ca

Fronius USA LLC
10421 Citation Drive, Suite 1100
Brighton, Michigan 48116
USA
Telephone +1 810 220 4414
Fax +1 810 220 4424
sales.usa@fronius.com
www.fronius-usa.com

Fronius UK Limited
Maidstone Road, Kingston
Milton Keynes, MK10 0BD
United Kingdom
Telephone +44 1908 512 300
Fax +44 1908 512 329
sales.uk@fronius.com
www.fronius.co.uk

Fronius International GmbH
Froniusplatz 1
4600 Wels
Austria
Telephone +43 7242 241-0
Fax +43 7242 241-953940
sales@fronius.com
www.fronius.com