

# *AVTOMATIC DEVICE FOR LONGITUDINAL WELDING 101 – different types*



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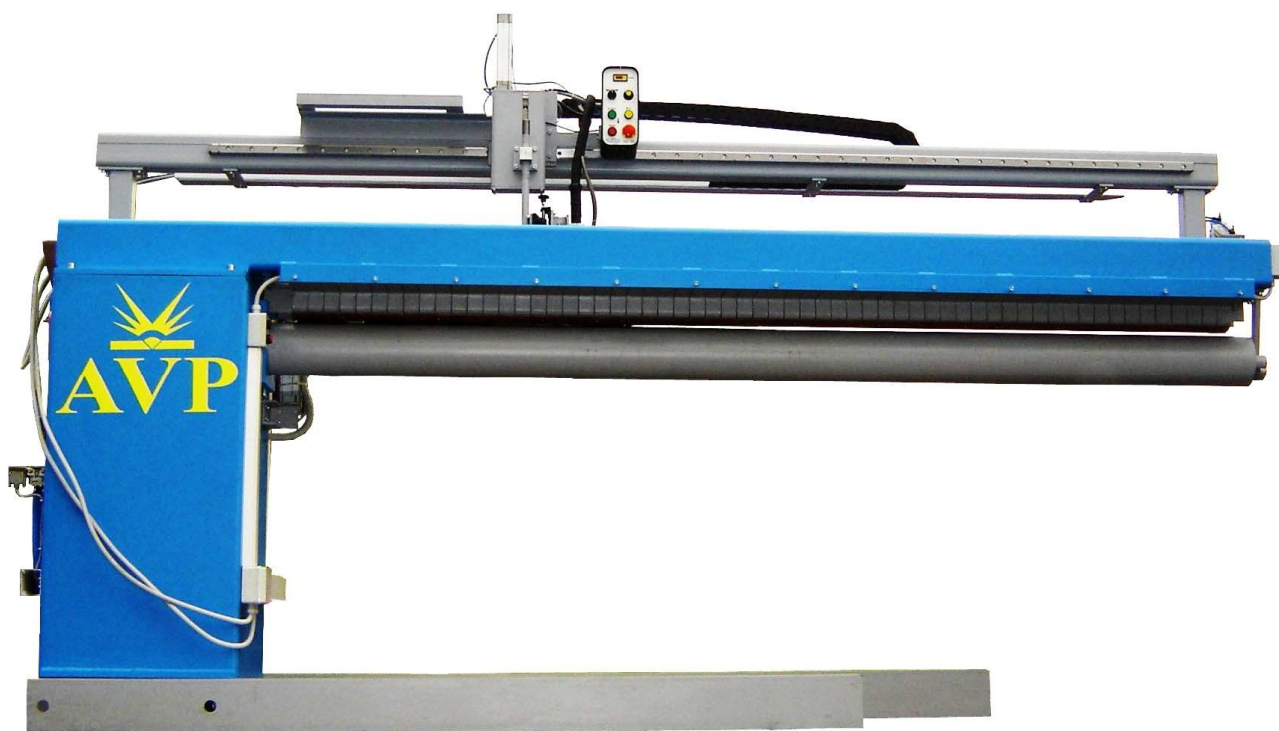
**Welding automation**

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# **LONGITUDINAL WELDING MACHINE**

## **VSV 311 – 3m**



### **Technical characteristics**

Welding procedure	MIG/MAG, TIG, SAW
Thickness of material	min. 0,8 mm max. 10 mm
Tube diameter, outside welding	min. 180 mm max. 1300 mm
Tube diameter, inner welding	more than 1300 mm
Welding length	3050 mm
Welding speed	0,1-2 m/min

#### Options:

- NC control (position set up, max. welding speed up to 9 m/min)
- Wire feeder (TIG procedure)
- Unit for assuring clean weld (Inox)

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# **LONGITUDINAL WELDING MACHINE**

## **VSV 101 - NC**



Automatic longitudinal welding devices enable high quality adjustment and welding for plate thickness 0,5 - 3 mm without previous binding and up to 6 mm with binding welds.

It can be used for welding with MIG, TIG, plasma or SAW procedure.

Clamping device is designed as water-cooled copper weld pool backing (supporting rail) with possibility under-blowing protective gas. Adjustable limiters on the rail limit the welding length. The torch can be precisely set into required position with possible corrections during the welding.

Options:

- pneumatic slide with a torch
- water-cooled copper supporting rail
- pneumatic bolt
- pneumatic descent of centering device
- welding length setting
- wire feed unit

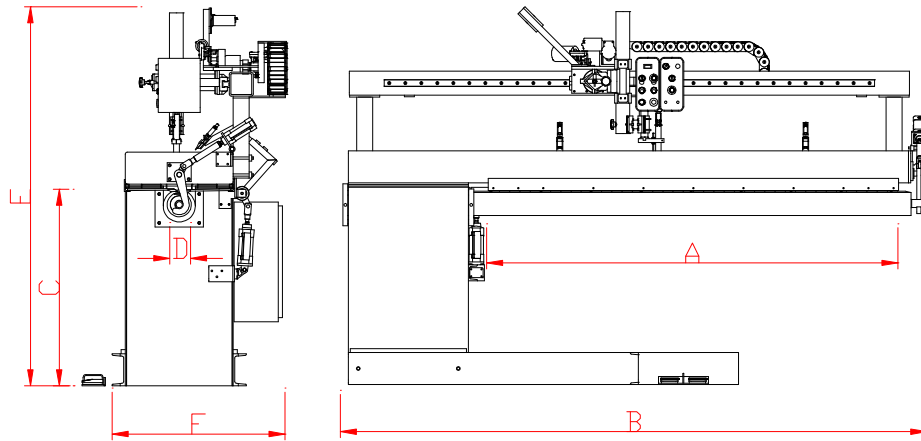
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# LONGITUDINAL WELDING MACHINE VSV 101 - NC



<b>A* (mm)</b>	<b>1050</b>	<b>1550</b>	<b>2050</b>	<b>3050</b>
<b>B (mm)</b>	2000	2500	3000	4000
<b>C (mm)</b>	1000	1000	1000 - 1300	1000 - 1500
<b>D (mm) min</b>	80	100	130	180
<b>E (mm)</b>	1800	1800	C + 800	C + 1000
<b>F (mm)</b>	800	800	800	900
<b>S<sub>min</sub>/S<sub>max</sub> (mm)</b>	0,5 - 3	0,6 - 3	0,6 - 3	0,8 - 3

Other dimensions also available

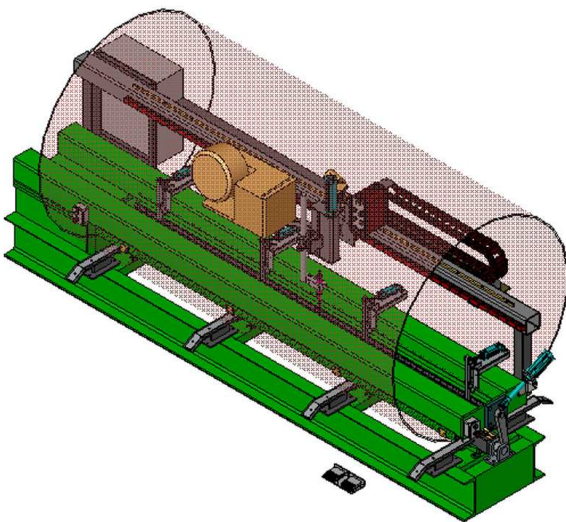
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# LONGITUDINAL WELDING MACHINE VSV 311/S



## Technical characteristic:

- Welding length 3050 mm-8050 mm
- Min diameter Ø 1.350 mm
- Welding speed 0 - 2 m/min
- Sheet thickness 1 - 8 mm
- Weld pool backing (water-cooled )  
for welding aluminum sheet metal
- Weld pool backing ( water-cooled-  
cooper ) for welding steel sheet  
metal



Both weld pool backing are installed within common alongside carrier. To use one or another, pull the carrier from machine and turn it on other side for 180° around along axe and push it back to its place.

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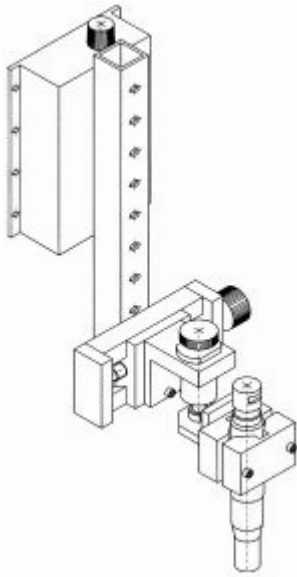
# AVC ARC VOLTAGE CONTROL

## AVC module

- positioning of the welding torch for the ignition distance (touch-retract)
- positioning for the welding distance
- arc voltage control for TIG welding processes
- automatic welding current detection
- HF security
- 4 quadrant motor control
- precision lengths control
- voltage sensor for the AVC arc length monitoring
- motor operated adjustable slide with 66 mm operating distance
- X axis with two limit switches as safety device and torch holding device



- Manually operated slide 50 mm
- Bearing joint with torch holder



- Motor driven slide, 66 mm or 100 mm travel length  
motor with tacho feedback  
limit switches, torch holder

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