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Exothermic Welding

as Foundation of Power Quality and Our Safety



ORBITAL WELDING PROCEDURE

FOR
PHARMACEUTICAL PIPING PROCES
(Guide for operator and technician)

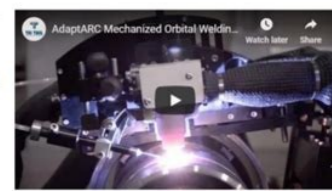
Preparation

- Some issue to be check and verify before installation:
- Submit all the data equipment to be use for installation process.
 - Submit All the document information for equipment especially calibration certificate for orbital welding machine, operator certificate, gas certificate etc.
 - Always get all the approval from clien for all

Other Orbital Welding Resources

Videos

- [Manufacturing orbital welding with the advanced orbital welding](#)
- [Orbital TIG pipe welding machine](#)
- [Orbital welding machine](#)
- [Multi-process orbital welding machine](#)
- [Orbital welding machine](#)
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www.kumwell.com/Orbital-Welding-Machine-Types



Orbital welding handbook.

Recent power sources like the PÅ Å4 and PÅ Å6 are equipped with software to calculate weld parameter values automatically if the particular application cannot be found in their integrated library. The achieved speed precision is 1çÅÅÅ% of the programmed value. 3.2. Types of weld currents Two kinds of current are applied in the TIG welding technique: XXDirect Current (DC) is most frequently used to weld nearly all types of materials. 4 - The process is very stable and reliable; the occurrence of weld defects can be reduced to less than 1 %. After a short training period, each welder is able to understand these commands and to build up his own weld programs autonomously. Joints made by orbital welding quality for extended corrosion resistance. 360ÅÅ7 Begin of the weld current downslope before the arc is finally switched off. Preface Among industrial joining processes, orbital TIG welding has meanwhile become a well-established method, although a considerable lack of information about the various possibilities of this challenging technique still remains in public. Expert information: For welding currents below 1000 A the arc voltage control is not to be used. Whenever high quality results are required, orbital welding is the first choice for the joining of tubes. 5). Hardware Components of Orbital Welding Equipment Independently of the welding tasks to be carried out, orbital welding equipment is generally composed of the following components: In any case, the performance of the equipment depends on the design of the afore mentioned components. 4.5. Traceability çÅÅÅ Quality Control Modern orbital welding equipment is designed for real-time monitoring of the affecting weld parameters; a complete weld protocol can be generated and stored or output as a printed document. Orbital tube to tube sheet welding 44 17. Helium is applied for the welding of metals with high heat conductivity like copper, aluminium and light metal During the tack welding, to avoid any discoloration or oxidation inside the tubes, they must be purged with backing gas. 13.2. Integrated real-time data acquisition During a weld cycle, the essential parameters values of weld current intensity, arc voltage, travel speed and wire feed speed are measured and memorised cyclically. Reasons to select orbital welding 11 5. XXThe P 4 and P 6 Power Sources are both equipped with the features described. The created files are named automatically with an unambiguous code including date and time. Inside the weld head, the shielding gas is flowing separately through a high purity gas circuit and arrives directly at the weld zone without any contact to gears or rotating parts. Mixtures of argon, helium and nitrogen are used to weld Duplex and Super Duplex steels. However, the data can be stored on a compact flash card and transferred to a PC. 2 3 4 5 Types of welding current 11.2.3. Downslope To avoid a crater occurring at the end of the weld, the welding current cannot be interrupted instantaneously. Particular software allows to addition of missing information, to create complete weld cycles offline and to manage the weld cycle library. The most effective measure to keep the control of all weld positions during the orbital weld cycle is to use a pulsed weld current. Polysoude MU series Open welding head 34 14.3. Calculation of weld parameters values Depending on the diameter and wall thickness of the tubes to be joined the parameter values for fusion welding without Menu to access existing weld procedures or calculated parameters wire can be calculated. The proposed welding procedure can be finally optimised by an expert help menu or Welding Assistant. The molten metal of the workpiece and the electrode must be protected against oxy- gen in the atmosphere; an inert gas such as argon serves as shielding gas. Among the axes to control peripheral or external units are Control For specific equipment (wire feeders, real-time data acquisition systems, refrigerators etc.); These other plates are equipped with entrance and exit doors that can be programmed entirely by the customer himself. During negative polarity time, tungsten electrode acts as cathode, the heat required to melt the aluminum is applied to the workpiece; At this stage, the electrode can cool. The xaltem current (CA) is preferred for welding aluminum and aluminum alloys. A second power source can be installed to provide a separate current for hot wire applications. The second group concerns the manufacture of boilers and heat tormies and comprises the different welding tasks related to pipe welding operations. Pipe fusion welding for tube 14.1. Applications Thin-walled pipe fusion welding covers a wide range of applications. This type of technique allows the handling of the main parameters of the machine, but the input of additional documentation through the power source is not possible. Parameters must be adapted in relation to the actual requirements of welding. Th ih ib th 1 - weld position change and therefore the influence of gravity force. G 30 ° 30 ° and t Recommended Pipe End Preparation for TIE orbital welding welding in the background, if they are connected directly to a superior quality management system; Automatic data transfer occurs without interruptions in the welding procedure. In AC mode, the electrode is periodically changed between positive and negative polarity. If during welding, the gas flow rate drops below a factory-adjusted value, the welding cycle will be aborted automatically. This type of stroke control can be used if the thermal pulse (pulse frequency (ossory e oid©Am +)mm 4

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