

Automation Catalogue



STRENGTH THROUGH COOPERATION

A2 Multitrac with A2 process controller PEI

The universal welding tractor for better welding economy

- Can be connected to most analogue, DC power supplies.
- Compact and efficient design allows for easy movement between workpieces.
- Self-propelled, four-wheel drive for stable, accurate and constant operation.
- A2 Process Controller PEI allows simple setting of travel speed, voltage and wire feed speed.
- Heavy-duty feed unit ensures an even and stable wire feed, for top quality, homogenous welding.
- Horizontal, vertical and rotary slides allow for quick adjustment of the nozzle into various positions.
- Reliable mechanical components, even under harsh working conditions.
- Easy to use control equipment with different start methods; direct start or scratch start.
- Wide range of accessories available.



Ordering information

A2 Multitrac SAW, PEI	0449 360 880
A2 Multitrac SAW Twin, PEI	0449 360 881
A2 Multitrac GMAW, PEI	0449 361 880
Sales Literature	XA00114220

Options & Accessories

Guide wheel bogie	0413 542 880
Idling roller	0333 164 880
Guide bar 3 m (10 ft.)	0154 203 880
V-guide wheel	0333 098 881
V-wheeltrack in steel	0443 682 881
Loop for connection of two tractors	0334 680 881
Pilot lamp, laser diode	0821 440 880

Technical data	Single SAW	Twin SAW	GMAW
Wire diameters, mm (in.)			
- Steel	1.6-4.0 (1/16-5/32)	2x1.2-2.5 (2x(0.45x3/32))	0.8-1.6 (.030-1/16)
- Stainless steel	1.6-4.0 (1/16-5/32)	2x1.2-2.5 (2x(0.45x3/32))	0.8-1.6 (.040-1/16)
- Cored wire	1.6-4.0 (1/16-5/32)	-	1.2-2.4 (.045-3/32)
- Aluminium	-	-	1.2-1.6 (.045-1/16)
Max wire feed speed, m/min (ipm)	9 (354)	9 (354)	16 (630)
Wire reel weight, kg (lbs.)	30 (66)	2x15 (2.2x33)	30 (66)
Flux hopper capacity, l (gal.)	6 (1.4)	6 (1.4)	-
Weight, excl wire and flux, kg (lbs.)	47 (103)	47 (103)	43 (95)
Permissible load 100%, A	800	800	600
Control voltage, V AC	42	42	42
Travel speed, m/min (ipm)	0.1-1.7 (4-67)	0.1-1.7 (4-67)	0.1-1.7 (4-67)
Linear slides stroke length, mm (in.)	90 (3.5)	90 (3.5)	90 (3.5)
Rotary slide setting angle	360°	360°	360°

A2 Multitrac with A2/A6 process controller PEK

The universal welding tractor for Submerged-arc Welding (SAW) and Gas Metal Arc Welding (GMAW)

- The A2 Multitrac with the A2/A6 process controller PEK is available for both the SAW and the GMAW method.
- If the SAW-version is chosen, the A2 Multitrac is capable of working equally well with either single or twin wire.
- The feed unit secures an even, stable wire-feed speed.
- Four-wheel drive ensures accurate travel speed.
- Digital control panel allows exact pre-set and control of welding parameters.
- The Multitrac is fully mobile and can easily be moved from one welding station to another. It can also be quickly set-up for different workpieces.
- Designed for use with LAF or TAF welding power sources.



Ordering information

A2 Multitrac A2TF (SAW), PEK	0461 233 880
A2 Multitrac A2TF (SAW Twin), PEK	0461 233 881
A2 Multitrac A2TG (GMAW), PEK	0461 234 880
A2 Multitrac A2TG (4WD, GMAW MTW 600), PEK	0451 234 881
Sales Literature SAW	XA00143220
Sales Literature GMAW	XA00143320

Options & Accessories

Guide wheel bogie	0413 542 880
Idling roller	0333 164 880
Guide bar 3 m (10 ft.)	0154 203 880
V-guide wheel	0333 098 881
V-wheeltrack in steel	0443 682 881
Loop for connection of two tractors	0334 680 881
Pilot lamp, laser diode	0821 440 880



Technical data	Single SAW	Twin SAW	Single GMAW	GMAW with MTW 600
Wire diameters, mm (in.)				
- Steel	1.6-4.0 (1/16-5/32)	2x1.2-2.5 (2x(0.45x3/32))	0.8-1.6 (.030-1/16)	1.0-1.6 (.039-1/16)
- Stainless steel	1.6-4.0 (1/16-5/32)	2x1.2-2.5 (2x(0.45x3/32))	0.8-1.6 (.040-1/16)	1.0-1.6 (.039-1/16)
- Cored wire	1.6-4.0 (1/16-5/32)	-	1.2-2.4 (.045-3/32)	1.0-2.4 (.039-3/32)
- Aluminium	-	-	1.2-1.6 (.045-1/16)	1.0-2.0 (.039-5/64)
Max wire feed speed, m/min (ipm)	9 (354)	9 (354)	16 (630)	25 (984)
Wire reel weight, kg (lbs.)	30 (66)	2x15 (2.2x33)	30 (66)	30 (66)
Flux hopper capacity, l (gal.)	6 (1.4)	6 (1.4)	-	-
Weight, excl wire and flux, kg (lbs.)	47 (103)	47 (103)	43 (95)	43 (95)
Permissible load 100%, A	800	800	600	600
Control voltage, V AC	42	42	42	42
Travel speed, m/min (ipm)	0.1-1.7 (4-67)	0.1-1.7 (4-67)	0.1-1.7 (4-67)	0.1-1.7 (4-67)
Linear slides stroke length, mm (in.)	90 (3.5)	90 (3.5)	90 (3.5)	90 (3.5)
Rotary slide setting angle	360°	360°	360°	360°

A2 Tripletrac A2TF

The superb welding tractor for internal circumferential welding

- For increased productivity and quality.
- Ideal for internal circumferential welding of large cylindrical objects that are rotating on a turning roll system.
- Heavy-duty feed unit secures even and stable wire feed for top quality, homogenous welds.
- Delivered with either the digital A2-A6 PEK or the analogue A2 PEI process controller.
- Unique steering system allows operator to simultaneously adjust the wheel and torch position for accurate and effortless seam tracking.
- Control equipment is easy to use and requires minimal training.
- Choose between start methods, burn-back times and other settings.

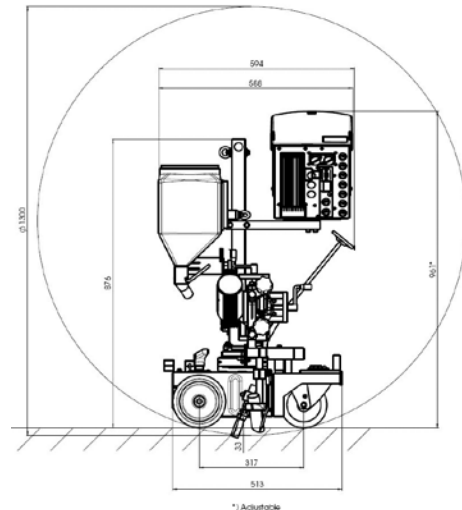


Ordering information

A2 Tripletrac with PEK	0461 236 880
A2 Tripletrac with PEI	0449 430 881
Sales Literature	XA00143520

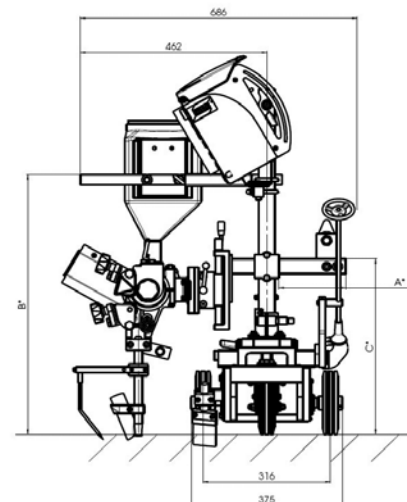
Options & Accessories

Pilot lamp, laser diode	0821 440 880
Utility light, incl transf. and 50 m (164 ft.) cable	0449 443 880
Flux recovery unit OPC	0148 140 880
Bracket suction	0332 947 880
Flux hopper of silumin alloy	0413 315 881
Concentric flux feeding funnel (included in the A2 Tripletrac)	0145 221 881
Contact tube, bent	0413 511 001
Wire reel, plastic 30 kg (66 lbs.)	0153 872 880
Wire reel, steel, fixed width	0416 492 880
Wire reel, steel, flexible width	0449 125 880
Wire reel, steel, Ø 220 mm (8.6)	0671 164 080



Technical data

Wire diameters, mm (in.)	
- Steel	1.6-4.0 (1/16-5/32)
- Stainless steel	1.6-4.0 (1/16-5/32)
- Cored wire	1.6-4.0 (1/16-5/32)
Max wire feed speed, m/min (ipm)	9 (354)
Wire reel weight, kg (lbs.), W	30 (66)
Flux hopper capacity, l (gal.)	6 (1.4)
Weight, excl. wire and flux, kg (lbs.)	47 (103)
Permissible load 100%, A	800
Control voltage, V AC	42
Travel speed, m/min (ipm)	0.1-1.7 (4-67)
Linear slides stroke length, mm (in.)	90 (3.5)
Rotary slide setting angle	360°
Max inclination for the tractor	5°



A6 Mastertrac A6TF (SAW)

For efficient Submerged-arc Welding

- Self-propelled, four-wheel drive automatic welding machine.
- Easy to move with quick set-up for different workpieces.
- Suitable for heavy production welding with capacity for up to 6 mm (0.24 inch) wire using 1500A direct or alternating current.
- Designed for use with LAF or TAF welding power sources.
- Three different designs:

Single: available with standard or high speed motor

Twin-Arc: with a simple add-on for the extra wire, you can convert an A6 Single Mastertrac into a highly productive automatic Twin-arc welder for fillet and butt welds without the use of an extra machine or power source.

Tandem: the high deposition rate using a multi-electrode system increases productivity substantially. By selecting different combinations of direct and alternating currents, the A6 Tandem Mastertrac can handle any type of welding work resulting in increased profitability.

- Weld mild steel and aluminium solid or cored wire by modifying an A6 Single Mastertrac with an easy conversion kit for Gas metal arc welding (GMAW).
- Pre-set and control of welding parameters with the A2-A6 Process Controller PEK - a digital control system with display menus; 255 different weld sets can be stored.

Ordering information

A6 Mastertrac A6TF (SAW)	0461 235 880
A6 Mastertrac A6TF (SAW Twin)	0461 235 881
A6 Mastertrac A6TF (SAW, high speed)	0461 235 890
A6 Mastertrac A6TF (SAW, Twin, high-speed)	0461 235 891
A6 Mastertrac Tandem A6TF (SAW, AC/DC 1500)	0461 232 882
Sales Literature	XA00143420



A6 Mastertrac Tandem

Options & Accessories

Contact equipment heavy Twin Arc, compl.	0334 291 889
Wire reel, plastic 30 kg (66 lbs.)	0153 872 880
Wire reel, steel 30 kg (66 lbs.)	0416 492 880
Wire reel, steel, flexible width	0449 125 880
Brake hub extra	0146 967 880
Rebuilding kit GMAW	0334 299 890
Strip cladding kit	0155 972 880
Flux hopper holder for strip cladding	0148 107 003
Wire reel, steel for strip cladding 30-100 mm (1.2-4.0 in.)	0671 161 880
Flux recovery nozzle, strip cladding	0156 025 001
Flux funnel	0254 900 880
Insert, extended	0254 900 301
Angular slide	0671 171 580
Pilot lamp, laser diode	0821 440 880
Flux recovery unit OPC	0148 140 880
Bracket suction	0332 947 880
Idler rollers (2 per automat)	0333 164 880
Guide wheel, fillet	0671 125 780
Magnet guide rail, 3 m (10 ft.)	0154 203 880

Carbon arc gouging

Rebuilding kit (use with carbon electrodes Ø 8.9-12.7)	0153 592 880
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Technical data	Single SAW	Single GMAW	Twin SAW	Tandem SAW
Permissible load 100%, A	1500	600	1500	2x1500
Wire diameter, mm (in.)	3.0-6.0 (1/8-1/4)	1.0-3.2 (0.045-1/8)	2x2.0-3.0 (2x3/32-1/8)	2x3.0-6.0 (2x1/8-1/4)
Wire feed speed, m/min (ipm)	0.2-4.0 (8-157.5)	0.8-16.6 (31.5-653.5)	0.2-4.0 (8-157.5)	0.2-4.0 (8-157.5)
Wire feed speed high, m/min (ipm)	0.4-8.0 (16-315)	-	0.4-8.0 (16-315)	-
Travel speed, m/min (ipm)	0.1-2.0 (4-79)	0.1-2.0 (4-79)	0.1-2.0 (4-79)	0.1-2.0 (4-79)
Control voltage, V AC	42	42	42	42
Wire reel weight, kg (lbs.)	30 (66)	30 (66)	2x30 (2x66)	2x30 (2x66)
Flux hopper capacity, l (gal.)	10 (2.6)	-	10 (2.6)	10 (2.6)
Weight excl wire and flux, kg (lbs.)	110 (242.5)	100 (220.5)	110 (242.5)	158 (348)

A6-DK

The portal welding machine

- Works with a single wire on each head.
- Each weld head is controlled by the A2-A6 PEK process controller and LAF (DC) or TAF (AC) power source.
- Ideal for simultaneous horizontal-vertical welding on both sides of a web or through panel.
- Straddles workpieces up to 800 mm (31 inch) tall and symmetrical profile widths of 400 mm (16 inch).
- Travels directly on a workpiece guided by a joint.
- Travel speed adjustable from 0.15-2.0 m/min (6-79 ipm).
- Store up to 10 l (2.6 gal.) of flux in the hopper.
- Each weld head is equipped with OPC flux recovery system.



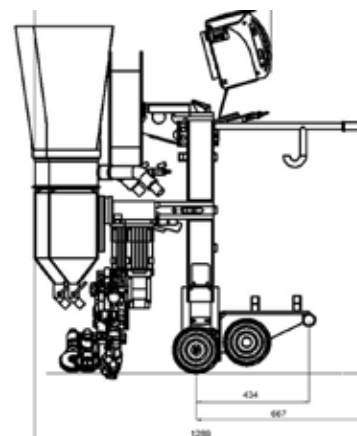
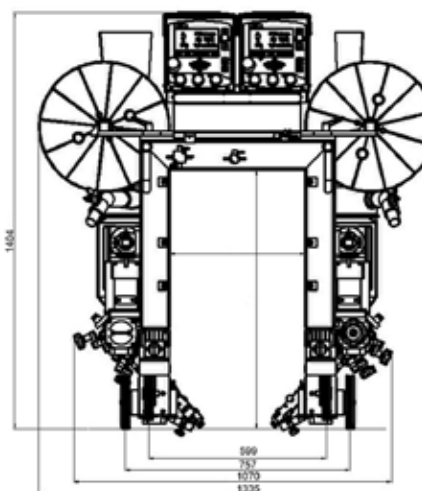
Ordering information

A6-DK SAW, single wire
 excl. wire reel, feed rollers and contact jaws *) 0461 237 901
 Sales Literature XA00143620

*) when contact equipment is excluded, feed rollers and contact jaws have to be ordered separately.

Options & Accessories

Wire reel, plastic, 30 kg (66 lbs.) 0153 872 880
 Wire reel, steel, 30 kg (66 lbs.) 0416 492 880



Technical data

Permissible load 100%, A	1500
Travel speed, m/min (ipm)	0.15-2.0 (6-79)
Wire feed speed, m/min (ipm)	0.2-4.0 (8-157.5)
Wire reel weight, kg (lbs.)	2x30 (2x66)
Wire diameter SAW, mm (in.)	3.0-6.0 (1/8-1/4)
Flux hopper capacity (each weld head), l (gal.)	10 (2.6)
Weight, excl wire and flux, kg (lbs.)	150 (331)

Straddle opening:

Vertical space limitation, mm (in.)	800 (31)
Longitudinal. symmetrical extension, mm (in.)	400 (16)

A2S Mini Master

A multi-purpose automatic welding system

- Versatile welding system for single wire SAW, twin wire SAW or GMAW.
- Light-weight, compact design allows for greater flexibility.
- Modular design allows user to expand, integrate or modify the system quickly and easily.
- Uses A2-A6 PEK or A2 PEI process controller.
- Accurate, easy joint-tracking with manual or motorized slide system and manual PAV or automatic GMH joint tracking.
- The system attaches to any beam travelling carriage or Column & Boom system.



Ordering information

A2S Mini Master SAW Systems

Incl A2-A6 Process controller PEK and wire equipment

With manual slides 90x90 mm	0449 170 900
With motorized slides 180x180 mm and PAV	0449 170 901
With motorized slides 180x180 mm and GMH	0449 170 902

Incl A2 Process controller PEI and wire equipment

With manual slides 90x90 mm	0449 370 880
With motorized slides 180x180 mm and PAV	0449 370 881
With motorized slides 180x180 mm and GMH	0449 370 882

A2S Mini Master GMAW MTW (4WD) Systems

Incl A2-A6 Process controller PEK and wire equipment

With manual slides 90x90 mm	0449 181 900
With motorized slides 180x180 mm and PAV	0449 181 901
With motorized slides 180x180 mm and GMH	0449 181 902

Incl A2 Process controller PEI and wire equipment

With manual slides 90x90 mm	0449 380 880
With motorized slides 180x180 mm and PAV	0449 380 881
With motorized slides 180x180 mm and GMH	0449 380 882
Sales Literature	XA00088820

Options & Accessories

Pilot lamp, laser diode (for PEK), 2 m cable	0821 440 880
Pilot lamp, laser diode (for PEK), 5 m cable	0821 440 882
Pilot lamp, laser diode (for PEK), 7 m cable	0821 440 883
Thin wire straightener, single wire	0332 565 880

Gas handling equipment, GMAW only:

Cooling unit OCE 2H, 220V AC 50/60 Hz	0414 191 881
Gas hose	0190 270 101
Water-cooling hose	0190 315 104
Arc shield	0334 689 880

Optional equipment SAW:

Flux recovery unit OPC	0148 140 880
Flux container, silumin alloy	0413 315 881
Concentric flux funnel	0145 221 881
Contact tube, bent	0413 511 001
Wire reel, plastic, 30 kg (66 lbs.)	0153 872 880
Wire reel, steel, 30 kg (66 lbs.)	0416 492 880
Wire reel, steel, flexible width	0449 125 880
Wire reel, steel, Ø 220 mm (8.7 inch)	0671 164 080

For PEK:

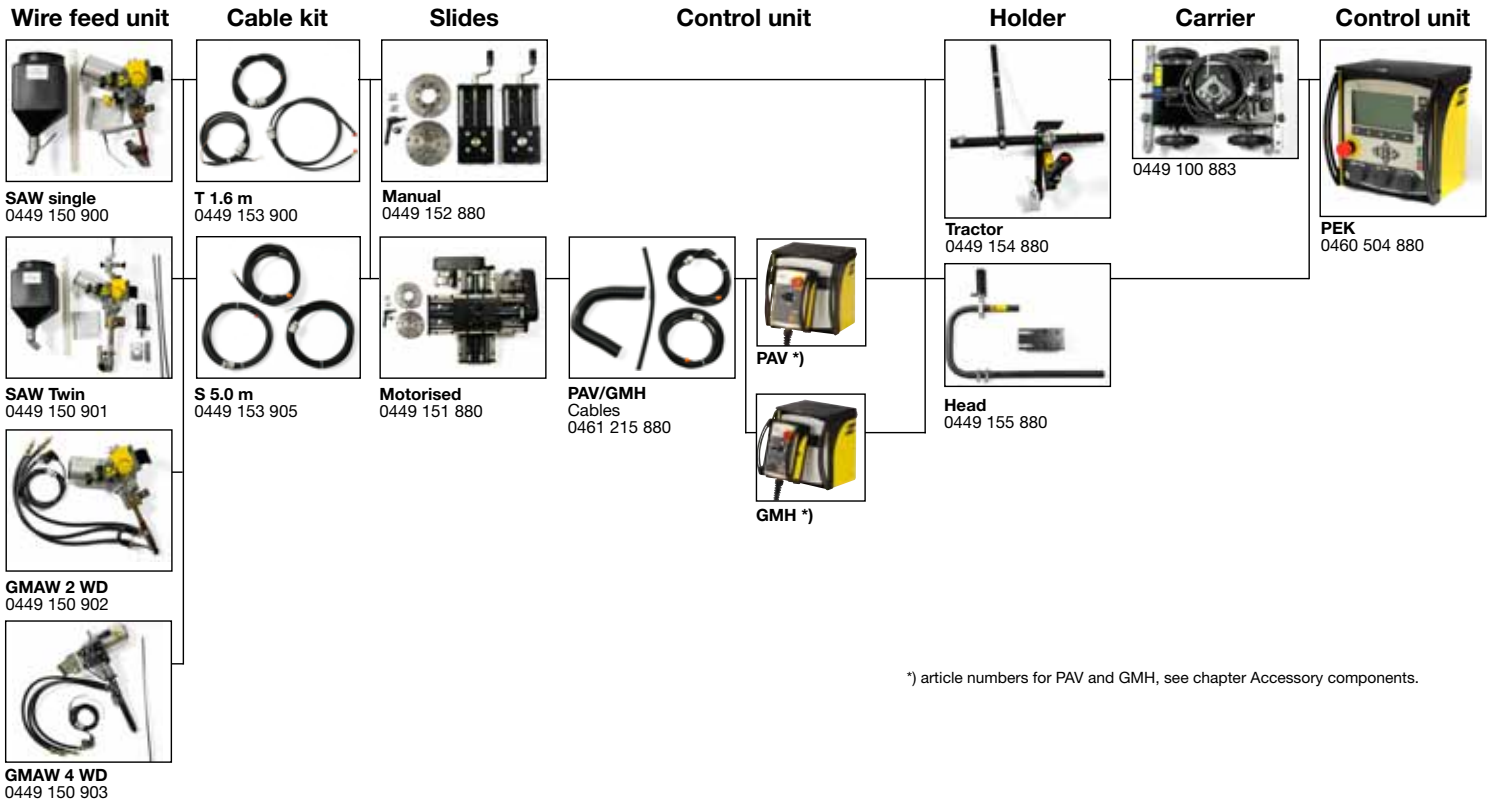
Conversion kit, SAW to GMAW A2 (2WD)	0461 247 880
Conversion kit, SAW to GMAW MTW (4WD)	0461 248 880

For PEI:

Conversion kit, SAW to GMAW	0413 526 881
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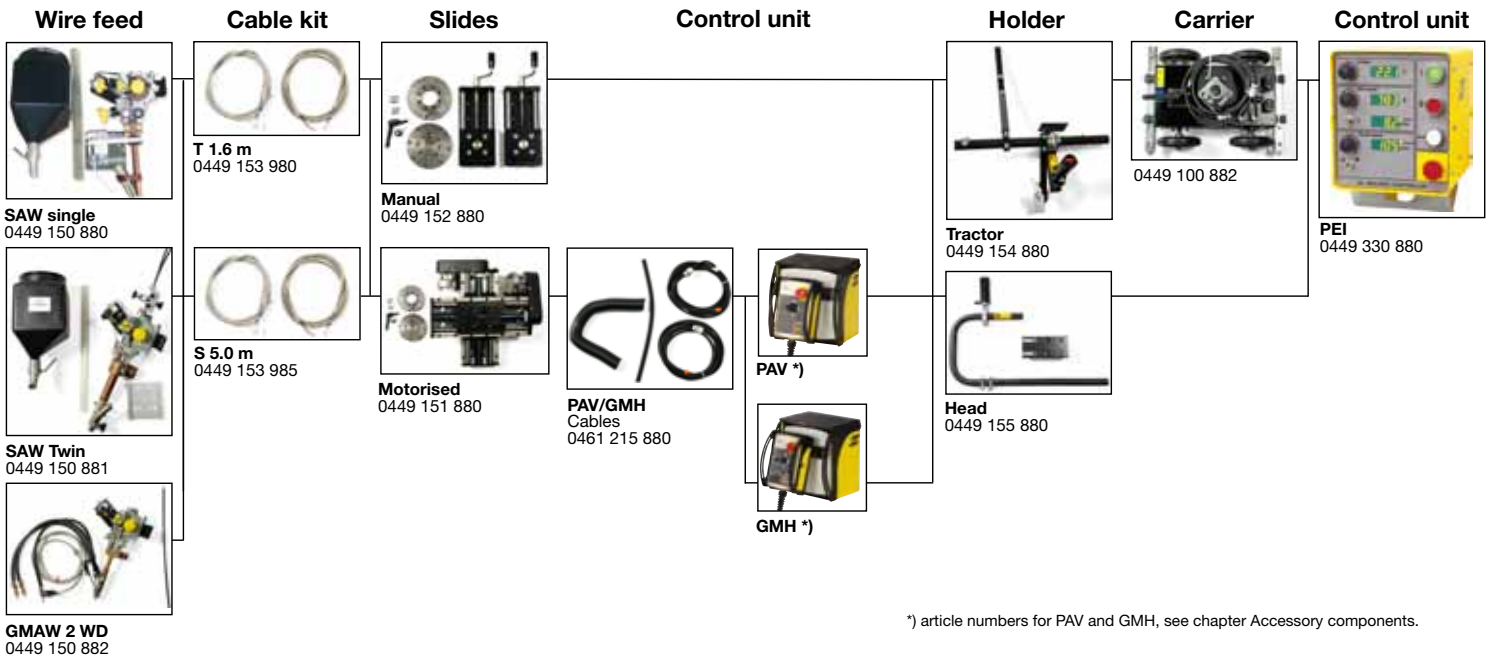
Technical data	Single wire SAW	Twin wire SAW	GMAW	GMAW MTW 600w
Wire diameter, mm (in.)	Steel 1.6-4.0 (1/16-5/32) Stainless Steel 1.6-4.0 (1/16-5/32) Cored wire 1.6-4.0 (1/16-5/32) Aluminium -	2x1.2-2.5 (2x.045-3/32) - - -	0.8-1.6 (.030-1/16) 0.8-1.6 (.030-1/16) 1.2-2.4 (.045-3/32) 1.2-1.6 (.045-1/16)	1.0-1.6 (.040-1/16) 1.0-1.6 (.040-1/16) 1.0-2.4 (.040-3/32) 1.0-2.0 (.040-5/64)
Max. wire feed speed, m/min (ipm)	9 (354)	9 (354)	16 (630)	25 (984)
Flux hopper capacity, l (gal.)	6 (1.4)	6 (1.4)	-	-
Max. permissible load 100%, A	800	800	600	600
Control voltage, V AC	42	42	42	42
Linear slide stroke length, mm (in.)	90 (3.5)	90 (3.5)	90 (3.5)	90 (3.5)
Rotary slide setting range	360°	360°	360°	360°

A2 Component system Modularization - PEK



*) article numbers for PAV and GMH, see chapter Accessory components.

A2 Component system Modularization - PEI



*) article numbers for PAV and GMH, see chapter Accessory components.

A6S Arc Master

Flexibility as standard

- Flexibility, reliability and superior performance capability
- Comprehensive component and module system make process customization easy.
- A6 VEC motor for reliable and consistent wire feed.
- Accurate, easy manual PAV or automatic GMH joint tracking with manual slides or joystick-controlled motor-operated cross slides.
- Capable of heavy-duty gas metal arc welding (GMAW), single/twin wire submerged arc welding (SAW), as well as strip cladding and Synergic Cold Wire (SCW) welding with optional accessories.
- Uses A2-A6 PEK process controller for fast, accurate pre-setting of all parameters before welding starts.
- Feedback system ensures high and consistent welding quality - saves time and material.
- The welding heads can be equipped with a standard wire feed unit (gear ratio 156:1) or with a high-speed wire feed unit (gear ratio 74:1).



Ordering information

Single wire SAW systems

standard wire feed unit (gear ratio 156:1)

With manual slides 210x210 mm	0449 270 900
With motorized slides 300x300 mm and PAV	0449 270 901
With motorized slides 300x300 mm and GMH	0449 270 902

high-speed wire feed unit (gear ratio 74:1)

With manual slides 210x210 mm	0449 270 910
With motorized slides 300x300 mm and PAV	0449 270 911
With motorized slides 300x300 mm and GMH	0449 270 912

Twin-wire SAW system

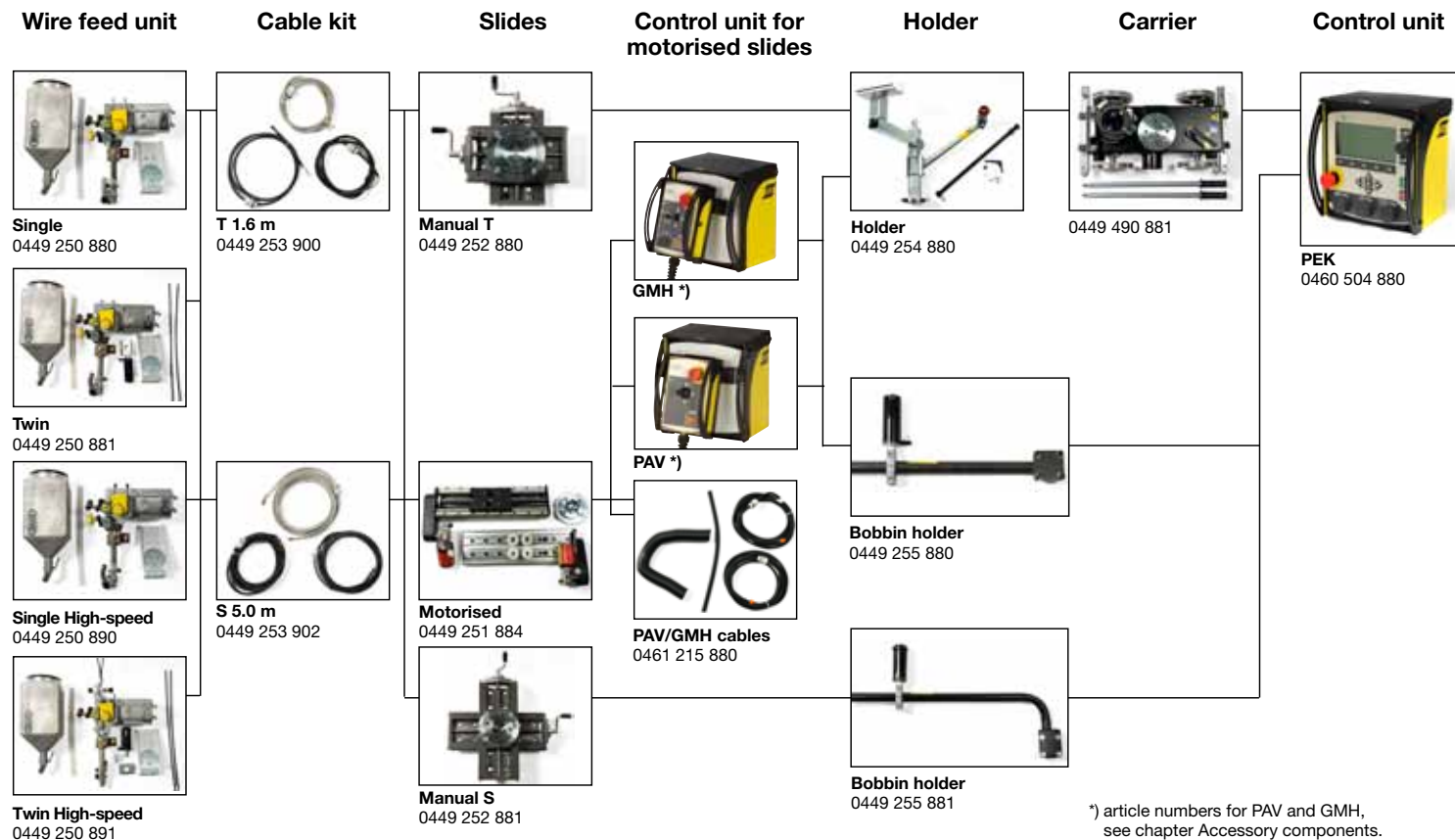
high-speed wire feed unit (gear ratio 74:1)

With manual slides 210x210 mm	0449 271 910
With motorized slides 300x300 mm and PAV	0449 271 911
With motorized slides 300x300 mm and GMH	0449 271 912
Sales Literature	XA00088920



Technical data	Ratio 156:1	Ratio 74:1
Max. wire feed speed, m/min (ipm)	0.2-4.0 (8-157)	0.4-8.0 (16-315)
Wire diameter, single, mm (in.)	3.0-6.0 (0.118-0.236)	1.6-4.0 (0.063-0.157)
Wire diameter, twin, mm (in.)	2x2.0-2x3.0 (2x0.079-2x0.118)	2x1.6-2x2.5 (2x0.063-2x0.098)
Tubular wire single, mm (in.)	3.0-4.0 (0.118-0.157)	1.6-4.0 (0.063-0.157)
Linear slide stroke length, mm (in.)	90 (3.5)	90 (3.5)
Rotary slide setting range		
Circular slide, crank operated	± 180°	± 180°
Straightener	± 45°	± 45°
Max. permissible load, 100%, A	1500	1500

A6 Component system Modularization



A6S and A6DS Tandem welding heads

For optimum productivity

- Suitable for heavy construction welding.
- Capable of welding DC/DC, DC/AC or AC/AC.
- Uses A2-A6 Process Controller PEK for quick and accurate programming of welding parameters for each torch.
- Feedback system gives high and consistent welding quality from start to finish, saving time and money.
- Versatile positioning through easy to use, complete slide assembly for welding torch position, distance stick-out and angle on both leading and trailing torches.
- Enhance productivity by adding optional equipment such as Twin Wire and Synergic Cold Wire systems.
- Available in two basic versions, A6S Tandem Master and A6DS Tandem Master with several configurations to match specific safety, quality and productivity requirements.
- Welding heads can be equipped with a standard wire feed unit (gear ratio 156:1) or with a high-speed wire feed unit (gear ratio 74:1).



Ordering information

A6S Tandem Master, standard (156:1)	0818 971 880
A6S Tandem Master, high-speed (74:1)	0818 971 881
A6DS Tandem Master, standard (156:1)	0818 970 880
A6DS Master, high-speed (74:1)	0818 970 881
Sales Literature	XA00119120

Options & Accessories

Twinkit (one per torch)	0809 934 882
GMH, joint tracking with remote, complete	0460 884 880
GMH, joint tracking with control panel, compl	0460 884 881
GMH, slide motor cables, 5.0 m (16 ft.)	0461 215 880
Laser lamp, 5 m cable (16 ft.)	0821 440 882
Laser lamp, 7 m cable (23 ft.)	0821 440 883
Bracket (straight) for wire	0334 318 880
Brake hub, for wire reel	0146 967 880
Wire reel, plastic, 30 kg (66 lbs.)	0153 872 880
Wire reel, steel, fixed width, 30 kg (66 lbs.)	0416 492 880
Wire reel, steel, flexible width, 30 kg (66 lbs.)	0449 125 880

Technical data (Basic components)	A6S Tandem Master	A6DS Tandem Master
A6 feed unit HD type for wire 3-6 mm (1/8-1/4 in.)	2 pcs	2 pcs
Horizontal motorized slide with double runners L=355 mm (14 in.)	1 pc	1 pc
Vertical motorized slide with double runners L=595 mm (23.4 in.)	1 pc	1 pc
PEK, process controller	2 pcs	2 pcs
Flux hopper, 10 l (2.3 gal.) incl bracket	1 pc	1 pc
Cable holder	1 pc	1 pc
Main bracket with mounting flange for cross slide assembly	1 pc (0810 786 880)	-
Swivel bracket for rotating head 90°	1 pc (0334 549 880)	1 pc (0809 873 880)
Welding head	2 pcs	2 pcs
Each welding head has:		
A6 manual slide L=90 mm	1 pc (0154 465 880)	1 pc (0154 465 880)
A6 circular slide	1 pc (0671 171 580)	1 pc (0671 171 580)
Insulators	4 pcs (0278 300 180)	4 pcs (0278 300 180)
Total weight (excl PEK, wire and flux) approx. kg (lbs)	215 (474)	190 (419)

A6S and A6DS Tandem welding heads

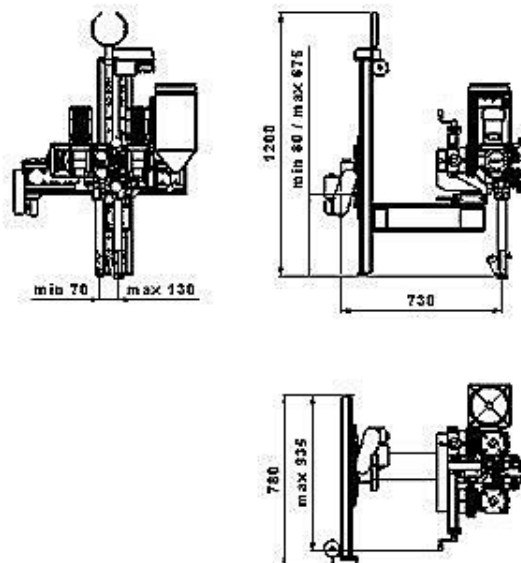
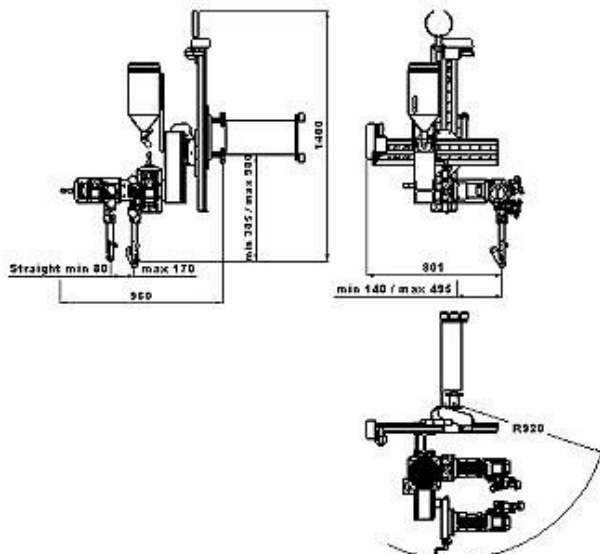
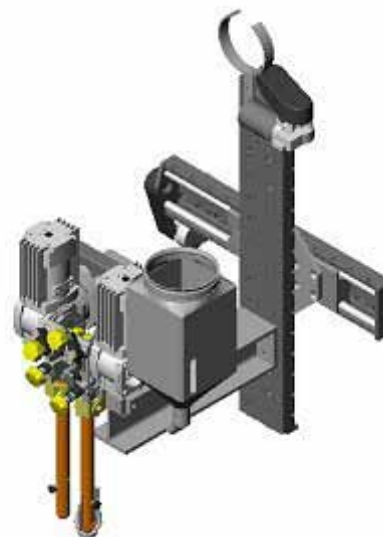
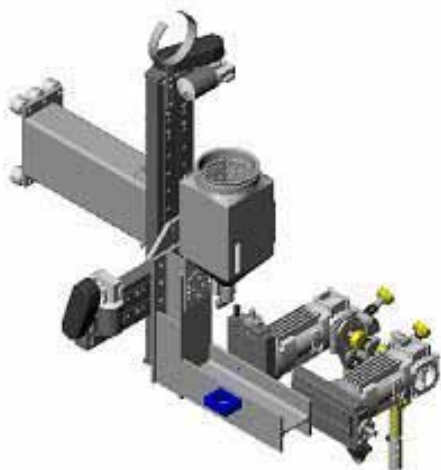
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A6S Tandem Master

- Optimized for welding across multiple perpendicular axes and is key in the welding of cylindrical objects where both longitudinal and circumferential welding is required.
- Adjustable $+90^\circ$ interval turning bracket and cross slide.
- Automatic joint tracking keeps in track no matter which direction welding occurs.

A6DS Tandem Master

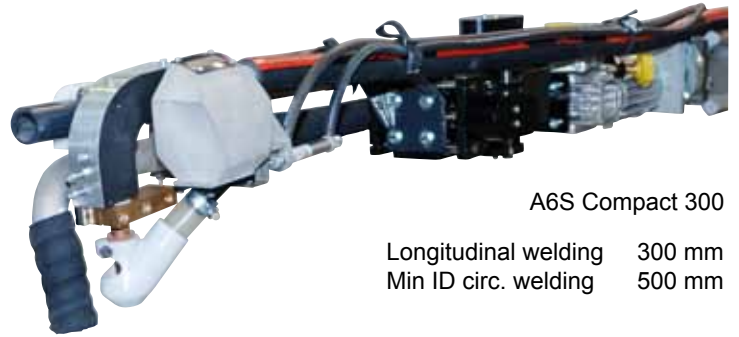
- Optimized for welding in multiple directions and is key in the automated welding of long weld joints such as beams and girders.
- Adjustable $\pm 90^\circ$ interval turning bracket and fixed cross slide.
- Automatic joint tracking in any direction when integrated to ESAB column and boom M-model systems; simply rotate the head 180° and weld in the reverse direction.



A6S Compact welding heads for internal welding

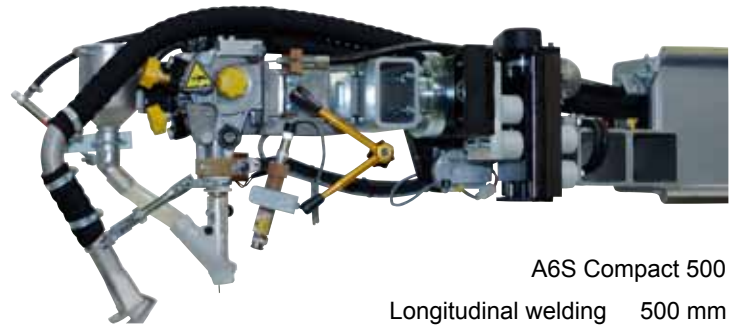
For excellent welding results

- For welding longitudinal and circumferential butt joints inside tubes.
- Three versions available:
 - A6S Compact 300 for internal welding of tubes down to 300 mm (12 inch) inside diameter.
 - A6S Compact 500 for internal welding of tubes down to 500 mm (20 inch) inside diameter.
 - A6S Compact 700 for internal welding of tubes down to 700 mm (27.5 inch) inside diameter.
- Equipped with reliable, VEC feed motor for superior weld performance.
- Supervise and adjust the head position via TV monitoring system - Optional.
- Use standard mini-cross slide assembly and PAV manual tracking system or GMH automatic joint tracking system to easily follow the joint - Optional.
- Add either the FFRS Basic/Super or FFRS 1200/3000 Flux Feed & Recovery System to optimize the welding process.



A6S Compact 300

Longitudinal welding 300 mm
Min ID circ. welding 500 mm



A6S Compact 500

Longitudinal welding 500 mm
Min ID circ. welding 550 mm



A6S Compact 700

Longitudinal welding 700 mm
Min ID circ. welding 750 mm

Ordering information

A6S Compact 300 Welding head, standard	0809 280 880
A6S Compact 300 Welding head, high-speed	0809 280 881
A6S Compact 500 Welding head, standard	0416 967 880
A6S Compact 500 Welding head, high-speed	0416 967 882
A6S Compact 700 Welding head, standard	0811 054 880
A6S Compact 700 Welding head, high-speed	0811 054 881
Sales Literature	XA00124620

Technical data	Compact 300
Wire diameters, mm (in.)	
- Steel	3.0-4.0 (1/8-5/32)
- Stainless steel	3.2 (1/8)
Permissible load 100%, A	800
Control voltage, V AC	42
Travel speed, m/min (ipm)	0.1-1.7 (4-67)
Linear slides stroke range, mm (in.)	50 (2)
Rotary slide setting range	360°
Wire feed speed, standard, m/min (ipm)	0.2-4.0 (8-157)
Wire feed speed, high.speed, m/min (ipm)	0.4-8.0 (15.7-315)

For technical data for Compact 500 and 700, please contact your local ESAB representative.

Options & Accessories - Compact 300

Flux valve control kit, including solenoid valve and 5 m (16.4 ft.) air hose	0813 620 880
TV monitoring equipment	0811 176 880
Laser pointer	0811 177 880

Contact tips, wire size

M12, 3.0 mm (7/64 in.)	0154 623 005
M12, 3.2 mm (1/8 in.)	0154 623 004
M12, 4.0 mm (5/32 in.)	0154 623 003

Feed rollers, wire size

3.0-3.2 mm (1/8 in.)	0218 510 298
4.0 mm (5/32 in.)	0218 510 286

A6S SAW strip cladding head

For surfacing with high alloyed materials

- Used in combination with standard A6S Arc Master welding head.
- Provides an economical solution for surfacing with high alloyed materials such as stainless steel or nickel-based alloys.
- Choose a wider variety of parent materials and consumables.
- Stainless steel cladding is widely used in production of components where additional strength or corrosion resistance is required.
- Welding head can be fitted with electrode strips as wide as 30-100 mm (1.2-4.0 inch) and as thick as 0.5 mm (0.02 inch).

Ordering information

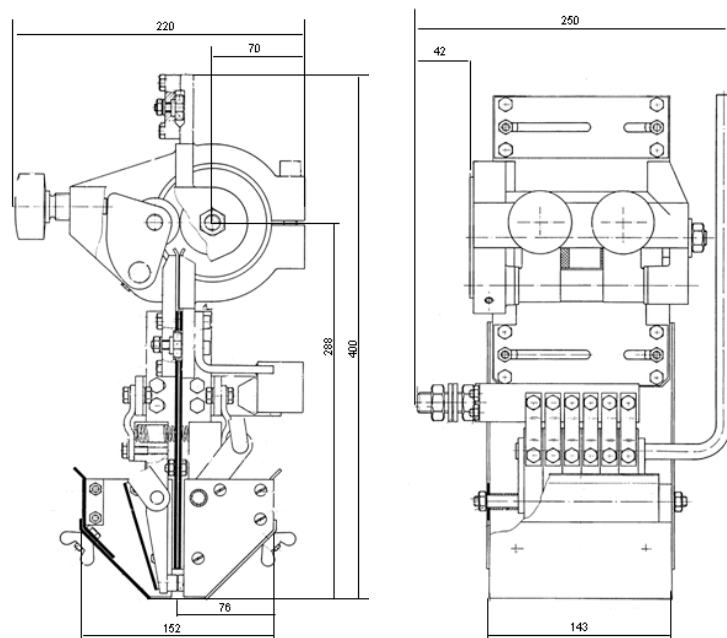
Strip cladding kit
(for use with A6T SAW Tractor or
A6S Arc Master HD)
Sales Literature

0155 972 880
XA00101020

Options & Accessories

Reel holder (not to be used with
motor-operated cross slide)
Wire reel, steel
Suction nozzle, flux

0417 636 880
0416 492 880
0156 025 001



ESW - Electroslag welding - is a method of strip cladding, but differs from SAW strip cladding in that the arc is created between the electrode and the workpiece.

The welding flux that is put into the joint melts and a slag pool is produced, which then increases in depth.

When the temperature of the slag and its conductive capacity thereby increases, the arc is extinguished and the welding current is conducted via the molten slag where the necessary welding energy is produced through resistance.

This method can be used for joining thicknesses of 25 mm (1 in.) and above.

Contact ESAB for Options & Accessories and Technical Data for the ESW Welding Head.

Technical data

Max. welding current at 100% duty cycle, A	1500
Feed roller diameter, mm (in.)	50 (2.0)
Strip width, mm (in.)	30-100 (1.2-4.0)
Strip thickness, mm (in.)	0.5 (0.02)
Strip feed speed	see sales literature for A6 Mastertrac, (XA00109420) or A6S Arc Master (XA00088920)