

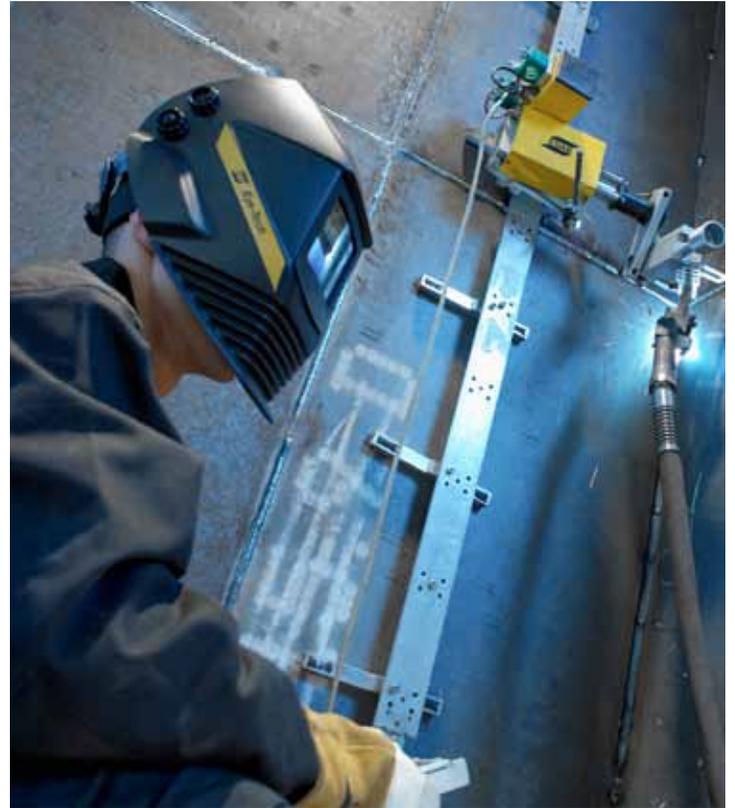
Welding Tractors



Railtrac 1000

Multi-purpose system for welding and cutting

- Ideal for a wide variety automated gas metal arc welding (GMAW) applications.
- Made from aluminium and steel parts to withstand harsh environments.
- Ideal for horizontal to horizontal and vertical (up only) welding.
- Can be customized with a wide range of accessories.
- New joint system allows for both stiff and flexible rail applications.
- Straightforward, well designed programming unit with up to 5 different programs.
- Standard software offers programmable interval welding and backfill function.
- Operator can control machine motions with hand held remote without lifting welding visor.
- Remote Control features: start and stop, shift program, weaving width, zero line displacement and many more.
- Adjust the welding current and voltage during welding with the two potentiometers on the remote control (when using ESAB equipment).
- Remote control only available on FW1000 and FWR1000 models.



Technical data	Railtrac F1000 Flexi	Railtrac FR1000 Flexi Return	Railtrac FW1000 Flexi-Weaver	Railtrac FW1000L Flexi-Weaver	Railtrac FWR1000 Flexi-Weaver-Return
Mains supply, V AC/DC	36-46/40-60	36-46/40-60	36-46/40-60	36-46/40-60	36-46/40-60
Max power consumption, W	30	30	80	80	80
Weight, excl rails, Kg (lbs)	6 (13)	6 (13)	7 (15)	7 (15)	7 (15)
Dimensions, LxWxH, mm (in.)	170x400x190 (6.7x15.8x7.5)	170x400x190 (6.7x15.8x7.5)	170x350x190 (6.7x13.8x7.5)	170x350x190 (6.7x13.8x7.5)	170x350x190 (6.7x13.8x7.5)
Flexi rail dimensions, LxW, mm (in.)	60x5 (2.4x0.2)				
Stiffener bar, LxW, mm (in.)	40x10 (1.6x0.4)				
Min bend diameter, external, mm (in.)	3000 (118)	3000 (118)	3000 (118)	3000 (118)	3000 (118)
Slide for height adjustment, mm (in.)	±22 (±0.87)	±22 (±0.87)	±22 (±0.87)	-	±22 (±0.87)
Mechanical lateral adjustment, mm (in.)	-	-	±35 (±1.4)	±35 (±1.4)	±35 (±1.4)
Welding speed, cm/min (ipm)	10-150 (3.9-59)	10-150 (3.9-59)	10-150 (3.9-59)	5-99 (1.95-39)	10-150 (3.9-59)
Quick transport, cm/min (ipm)	150 (59)	150 (59)	150 (59)	99 (39)	150 (59)
Preheating time, sec	0.0-9.9	0.0-9.9	0.0-9.9	0.0-9.9	0.0-9.9
Interval welding, cm (in.)	1-99 (0.4-39)	1-99 (0.4-39)	1-99 (0.4-39)	1-99 (0.4-39)	1-99 (0.4-39)
Crater-filling time, sec	0.0-9.9	0.0-9.9	0.0-9.9	0.0-9.9	0.0-9.9
"Backfill", mm (in.)	0-99 (0-3.9)	0-99 (0-3.9)	0-99 (0-3.9)	0-99 (0-3.9)	0-99 (0-3.9)
Weaving speed, mm/s (ips)	-	-	6-60 (0.2-2.4)	6-60 (0.2-2.4)	6-60 (0.2-2.4)
Weaving width, mm (in.)	-	-	1-30 (0.04-1.2)	1-30 (0.04-1.2)	1-30 (0.04-1.2)
Electrical 0-line displacement, mm (in.)	-	-	±12.5 (±0.5)	±12.5 (±0.5)	±12.5 (±0.5)
Pause time at outer edge, sec	-	-	0.0-9.9	0.0-9.9	0.0-9.9
Weaving pattern, No.	-	-	3	3	3
Number of programs	5	5	5	5	5
Temperature machine and magnets, °C	0-70	0-70	0-70	0-70	0-70
Temperature vacuum attachments, °C	0-90	0-90	0-90	0-90	0-90
Enclosure class	IP23	IP23	IP23	IP23	IP23

Railtrac 1000

System configuration

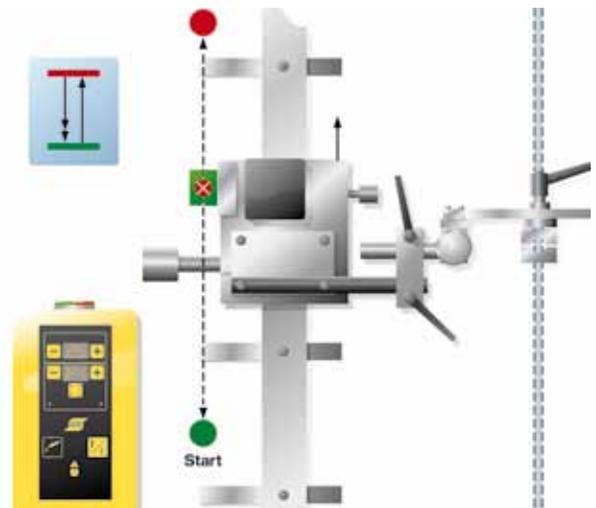
Railtrac F1000 Flexi

A mechanised system with a flexible combi-rail, suitable for both inside and outside welding and cutting along sharp curves as well as straight surfaces. This model is also suitable for thermal cutting.



Railtrac FR1000 Flexi Return

Railtrac FR1000 has the combi-rail and facilities for movable start and stop for automatic return for any length. This system is ideal for use in fixed installations or where a weld is repeated over and over again.



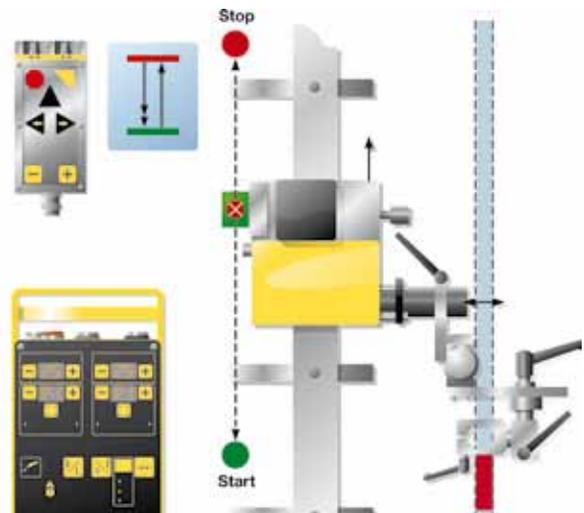
Railtrac FW1000 Flexi Weaver

This version has a flexible combi-rail and a weaver for weaving in many different patterns. It is also equipped with a remote-controlled unit with a user-friendly design.



Railtrac FWR1000 Flexi Weaver Return

Like the Flexi Weaver, this system has a weaving unit, but it also has adjustable start, stop and return facilities. Equipped with a remote control unit with a unique design, this is a very advanced solution for a number of applications.



Railtrac 1000

Cont.

Ordering information

Railtrac F1000 Flexi	0398 146 002
Railtrac FR1000 Flexi Return	0398 146 003
Railtrac FW1000 Flexi Weaver	0398 146 012
Railtrac FW1000L Flexi Weaver (<i>low speed</i>)	0398 146 014
Railtrac FWR1000 Flexi Weaver Return	0398 146 013
Sales Literature	XA00135520

Options & Accessories

Standard

- Weaving unit *)
- Control unit
- Remote control *)
- Universal Torch holder with slide
- Automatic start and stop function **)

Components

Flexible alu-rail, 2.5 m (8 ft.)	0398 146 115
Flexible alu-rail, 2.5 m (8 ft.), 8 magnets	0398 146 112
Flexible alu-rail, 2.5 m (8 ft.), vacuum attachments	0398 146 113
Stiffener Bar, 2.5 m (8 ft.)	0398 146 116
Magnetic attachment 90°, at least 8/2.5 m (8/8 ft.)	0398 146 100
Vacuum attachment 90°, at least 4/2.5 m (4/8 ft.)	0398 146 104
Vacuum attachment 200°, at least 4/2.5 m (4/8 ft.)	0398 146 105
Screw attachment for stiffened rail	0398 146 114

Accessories

Torch holder	0398 145 101
Adapter for stiffened rail attachments	0398 146 106
Universal pivoted torch holder	0398 145 104
Attachment for IMP cutting torch	0398 145 260
Torch angle attachment	0398 145 215
Tilt unit for weaving unit *)	0398 145 200
Turning unit for weaving unit *)	0398 145 201
"Floating" head	0398 145 211
IMP cutting torch	0398 145 250
Transport and storage box	0398 145 199
Control cable, 5 m (16.4 ft.)	0457 360 880
AristoFeed wire feeder adaptor kit	0458 757 881
Universal control cable, 5 m (16.4 ft.)	0457 360 881
Transformer kit	0457 467 880

*) FW1000, FW1000L, FWR1000 only

***) FR1000 and FWR1000 only



Railtrac Orbital W

The machine to automate your tube welding

The Railtrac Orbital W is a superb alternative if you wish to automate your tube welding. It is ideal for use with ESAB's semi-automatic power sources and feed units.

The Railtrac Orbital W is a small compact motor powered tractor. A standard ESAB welding torch can be attached quickly. Two motors guarantee an even, stable movement on the rail.

The control box allows you to control the following parameters and store 5 different welding programs:

- Start and stop
- Shift program
- Travel or welding direction
- Travel or welding speed
- Weaving width
- Zero line displacement
- Welding current (wire feed speed)
- Welding voltage
- Backfill function



Technical data

Control voltage, V AC	36-46
Power, W	90
Connection	Burndy, 12 pins
Welding speed, cm/min (ipm)	5-99 (2-39)
Slide for height adjustment, mm (in.)	±22 (±0.9)
Weaving speed, mm/sec. (ips.)	6-60 (0.2-2.4)
Weaving width, mm (in.)	1-30 (0.04-1.2)
Pause time at outer edge, sec	0.0-9.9
Electrical 0-line displacement, mm (in.)	±12.5 (±0.5)
Number of programs	5
Dimensions (LxWxH), mm (in.)	312x327x181 (12.3x12.9x7.1)
Weight, kg (lbs)	8 (17.6)
Enclosure class	IP 23

Ordering information

Railtrac Orbital W 0398 146 032

Options & Accessories

Floating head	0398 145 211
Orbital ring 6"	0449 900 706
Orbital ring 8"	0449 900 708
Orbital ring 10"	0449 900 710
Orbital ring 12"	0449 900 712
Orbital ring 14"	0449 900 714
Orbital ring 16"	0449 900 716
Orbital ring 18"	0449 900 718
Orbital ring 20"	0449 900 720
Orbital ring 22"	0449 900 722
Orbital ring 24"	0449 900 724
Orbital ring 26"	0449 900 726
Sales Literature	XA00133720

Larger ring sizes available on request

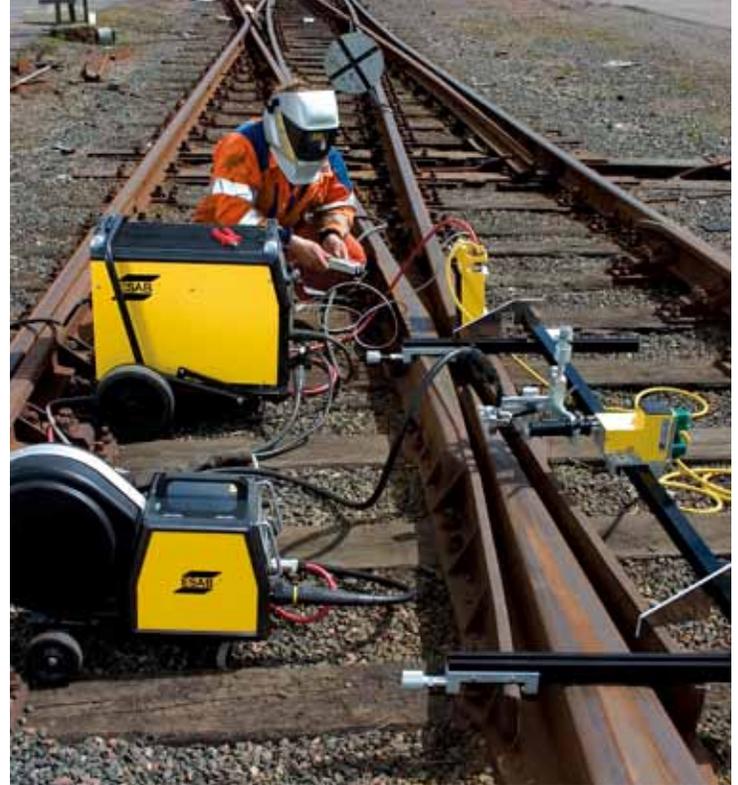
Railtrac BV/BVR 1000

Programmable equipment for hardfacing and repair of rail profiles

- Light weight makes it quick and easy to remove the aluminium travel beam from rail or crossing and simple to restore to its original position on the work piece.
- It can be used with a number of different power sources and wire feeder combinations.
- Precise adjustments of the weaving pattern, travel speed and zero line can all be achieved during welding.
- Welding parameters are adjustable from the remote control.
- CE and EMC approved.
- IP 23 enclosure class makes it suitable for use out-doors. Control voltage level of 42V AC is safe for use anywhere.

Ordering information

Railtrac BV 1000, complete excl welding equipment	0398 145 002
Railtrac BVR 1000, complete excl welding equipment	0398 145 003
Torch holder	0398 145 101
Sales Literature	XA00067820



Technical data

Connection voltage, V AC / V DC	36-46 / 40-60
Max. output consumption, W	80
Weight excl. rail, kg (lbs.)	7 (15.4)
Weight of rail 2 m, kg (lbs.)	4 (8.8)
Slide for adjusting height of torch, mm (in.)	±22 (±0.9)
Mechanical lateral adjustment, mm (in.)	200 (7.9)
Gun attachment universal, mm (in.)	Ø 12-36 (Ø 0.5-1.4)
Max. effective weld length, mm (in.)	1500 (59)
Welding speed, cm/min (ipm)	10-150 (0.2-59)
Fast transport speed, cm/min (ipm)	150 (59)
Weaving speed, mm/s (ips)	7-50 (0.3-2.0)
Weaving width (W), mm (in.)	1-80 (0.04-3.1)
Zero-line shift, mm (in.)	25 / ±12.5 (1.0 / ±0.5)
Programmable edge length (L), cm (in.)	6-99 (2.4-39)
Number of programs	BV: 4, BVR: 6
Enclosure class	IP23

Tramtrac™ II

A cost-efficient and flexible solution for the repair of embedded city tramway rails.

Tramtrac™ II is ESAB's latest equipment for the repair of embedded grooved city tramway rails. Using the FCAW process with self-shielded wires, instead of the conventional SAW process, provides a number of advantages in terms of ease of use and cost-efficiency.

- The FCAW process makes Tramtrac™ II a small and ultra light-weight solution.
- Easy to store and move around from site to site.
- The tractor can be hand-carried and is easily installed and removed on and off the rail, allowing trams to pass within a controlled safety situation.

Ordering information

Tramtrac™ II	0814 721 880
Connection cable 10 m (33 ft.)	0457 360 884
Origo™ MIG 410	0349 302 408
Origo™ MIG 320	0349 303 562
Magnetic earth return cable & clamp	0000 500 415
OK Tubrodur 14.71, 1.6 mm (1/16 in.)	1471 167 730
OK Tubrodur 15.65, 1.6 mm (1/16 in.)	1565 167 730
Sales Literature	XA00133420

Technical data

Control voltage, V AC	36-46
Power, W	90
Welding speed, mm/min (ipm)	30-100 (1.2-3.9)
Dimensions LxWxH, mm (in.)	600x300x150 (23.6x11.8x5.9)
Weight without consumables, kg (lbs.)	12 (26.5)



Miggytrac 1001

The perfect complement to your GMAW power source

- Small, compact, motorized tractor.
- Easy to attach to ESAB welding torch.
- The tractor is held in the correct position on the workpiece with a magnet, even if the workpiece is bent or angled.
- Remote controlled travel.
- Start/stop function from the remote control panel.
- Travel speed settings of 150-1200 mm/min (6-47 ipm), wire feed speed and voltage all functions of the remote control.
- Significantly increased welding speed, especially when using cored wire.



Ordering information

Miggytrac 1001	0457 357 881
Welding screen	0457 463 880
Sales Literature	XA00126320

Options & Accessories

ESAB Control cable, 5 m (16.4 ft)
(12 pin male-23 pin male Burndy style)
Origo™ Feed and Aristo™ Feed feeders

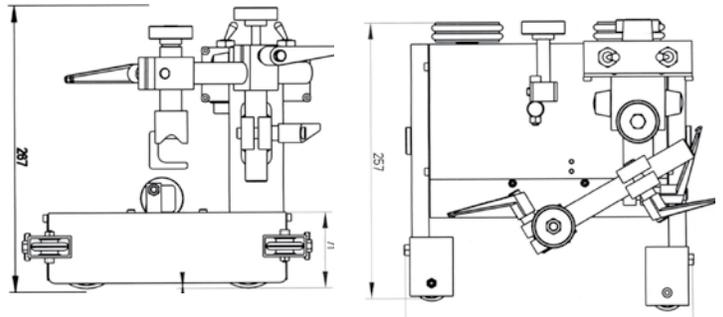
0457 360 880

ESAB AristoFeed adaptor kit
(required for connection of Miggytrac to
Aristo™ Feed feeders)

0459 681 880

Universal control cable, 5 m (16.4 ft)
(12 pin male Burndy style-open end).
Requires user-supplied plug to connect
cable to OEM feeders)

0457 360 881



Technical data

Control voltage, V AC	36-46
Power, W	20
Welding speed, mm/min (ipm)	150-1200 (6-47)
Remote control outlet	Volt and ampere (wire feed speed)
Connection	Burndy, 12 pins
Dimensions, LxWxH, mm (in.)	266x257x267 (10.5x10x10.5)
Weight, kg (lbs.)	7 (15.4)



Miggytrac 2000

The perfect complement to your GMAW power source

- Ideal for long welds eliminating stressful welding positions for the welder.
- The tractor is held in the correct position on the workpiece with a magnet, even if the workpiece is bent or angled.
- Guide wheels adjust to allow the unit to drive itself against the workpiece.
- Program for intermittent welding.
- Set length of weld and distance between welds from 1-99 cm (0.4-39 in.)
- High-speed travel between welds - 250 cm/min (98 ipm) - for increased efficiency.
- Backfill function for crater filling at the end of the weld.
- Adjust the welding current and voltage during welding with the two potentiometers on the control panel (when using ESAB equipment).



Ordering information

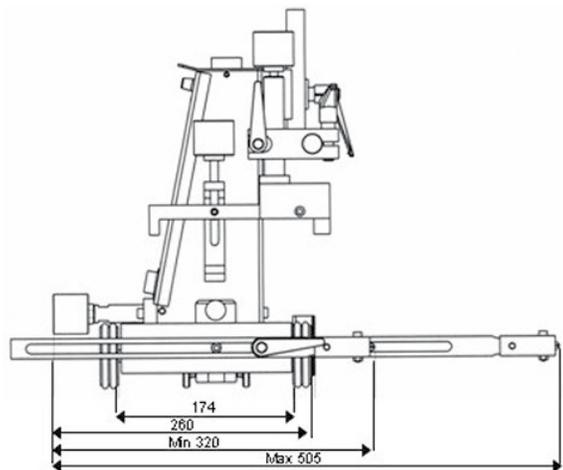
Miggytrac 2000	0457 358 880
Welding screen	0457 463 881
Sales Literature	XA00104720

Options & Accessories

ESAB Control cable, 5 m (16.4 ft) (12 pin male-23 pin male Burndy style) Origo™ Feed and Aristo™ Feed feeders	0457 360 880
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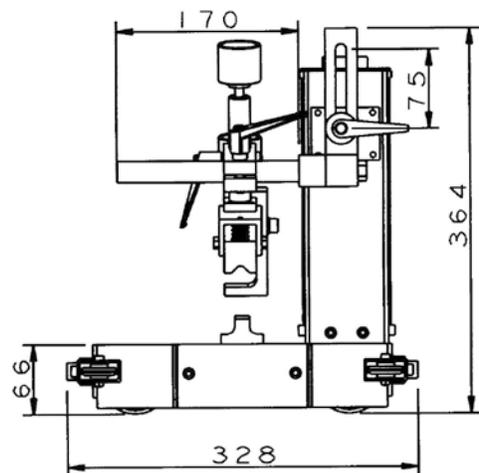
ESAB AristoFeed adaptor kit (required for connection of Miggytrac to Aristo™ Feed feeders)	0459 681 880
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Universal control cable, 5 m (16.4 ft) (12 pin male Burndy style-open end). Requires user-supplied plug to connect cable to OEM feeders)	0457 360 881
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Technical data

Control voltage, V AC	36-46
Power, W	40
Welding speed, mm/min (ipm)	150-1500 (6-59)
Fast travel speed, cm/min (ipm)	250 (98.4)
Programmable Interval Welding, cm (in.)	1-99 (0.4-37)
Linear slide stroke length (horizontal), mm (in.)	±17 (±0.67)
Remote control outlet	Volt and ampere (wire feed speed)
Connection	Burndy, 12 pins
Crater fill time, s	0-9.9
Backfill, cm (in.)	0-9.9 (0-4)
Dimensions, LxWxH, mm (in.)	330x260x360 (13x10x14)



Miggytrac 3000

The complete small welding automat for Gas Metal Arc Welding

- Small, compact, motorized tractor with integrated wire feed and water-cooled welding torch designed for horizontal mechanized MIG welding of plates and beams
- Four-wheel drive carriage
- Carriage can travel diagonally towards the flange or stiffener to be welded.
- Program for intermittent welding.
- Carriage motion and wire feed controlled separately.
- Set weld length and distance between welds from 1-99 cm (0.4-39 in.)
- Distance between beads run at transport speed of 250 cm/min (98 ipm) for optimal efficiency.
- Program wire feed speed, time for gas pre-flow, gas post-flow and burnback.

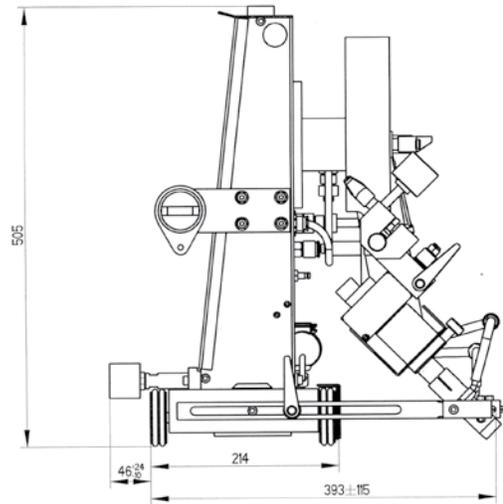


Ordering information

Miggytrac 3000	0457 359 880
<i>With straight, water-cooled swan neck</i>	
<i>Delivered without contact tip</i>	
Sales Literature	XA00123620

Technical data

Wire dimensions, mm (inch)	
- Unalloyed steel	1.0-1.4 (0.040 - 0.055)
- Stainless steel	1.0-1.4 (0.040 - 0.055)
- Cored wire	1.0-1.4 (0.040 - 0.055)
Control voltage, V AC	36-46
Power, W	80
Welding speed, mm/min (ipm)	150-1500 (6-59)
Transport speed, cm/min (ipm)	250 (98.4)
Lengths at Intermittent welding, cm (in.)	1-99 (0.4-39)
Crater fill time, sec.	0-9.9
Backfill, cm (in.)	0-9.9 (0-4)
Wire feed speed, m/min (ipm)	2-25 (79-984)
Gas pre-flow/post-flow, sec	0-9.9
Burnback, sec.	0-9.9
Filler wire reel, in.	12
Dimensions, LxWxH, mm (in.)	370x400-530x520 (14.5x16-21x20.5)
Linear slide stroke length (horizontal), mm (in.)	±17 (±0.67)
Remote control, max value, Kohm	2.5
Max current over the start relay, A	5
Connection	straight 23-pin Burndy
Enclosure class	IP 23
Weight, excl wire reel, kg (lbs.)	17 (37.5)



Options & Accessories

Contact Tip M8 x 37 CuCrZr	
- CO ₂ 1.0	0468 502 005
- CO ₂ 1.2, Mix/Ar 1.0	0468 502 007
- CO ₂ 1.4, Mix/Ar 1.2	0468 502 008
Gas nozzle, water-cooled	0449 903 101
Bent swan neck, 15°	0449 903 115
Bent swan neck, 30°	0449 903 130
Wire feed roller for aluminium	0449 903 031
Pressure roller for aluminium	0449 903 032

For Connection cables and Adaptor Kit, please see separate leaflet for Miggytrac 3000.

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.

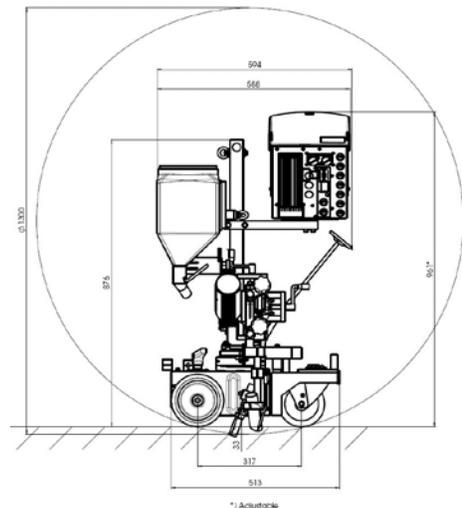


Ordering information

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

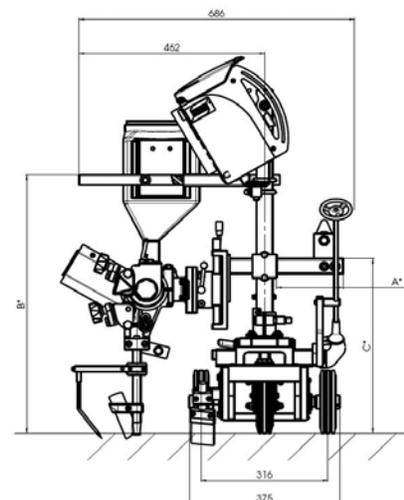
Options & Accessories

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.



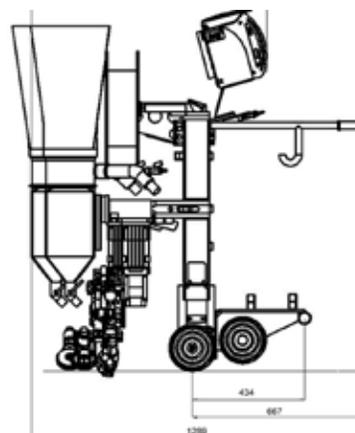
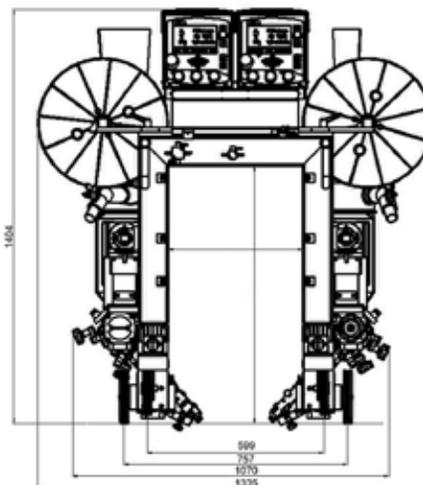
Ordering information

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)

Welding Heads

