

Circumferential seam welding machine



Circumferential seam welding machine with series compensation
for the economical manufacture of steel radiator elements

schlatter
The Secure Connection.

Circumferential seam welding machine with series compensation

Advantages

- ▶ Reproducible high quality welds
- ▶ Automatic speed and weld current regulation at corner radius and overlap areas
- ▶ Most reliable process safety
- ▶ Clean, water and oil tight weld seams
- ▶ Quick change over to different element sizes
- ▶ Low electric energy consumption
- ▶ Long electrode life of weld rolls
- ▶ Integrated electrode roll profiling device at the machine

Machine Type: **NF 80/100 IM-SK**

Welding processor: **SWEP M01**

Working Range

Distance between bosses A	200 - 1000 mm
Depth B (standard)	110 - 250 mm
Depth B (special design)	63 - 110 mm
Boss diameter	42 - 43 mm

Electrical Data

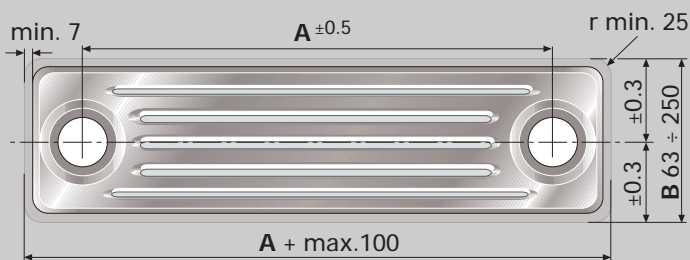
Nominal secondary current	25 kA
Connection voltage	400V / 50 Hz
Mains supply requirement	100 kVA

Mechanical Data

Electrode force at 5 bar air pressure	80 - 800 daN
Electrode stroke	50 mm
Electrode wheel diameter	230 - 270 mm



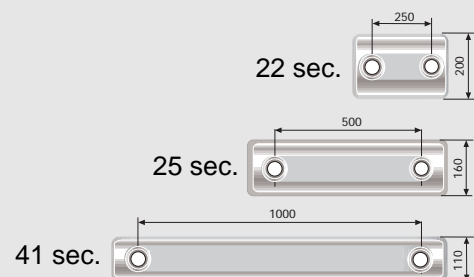
Boss shape and tolerance for radiator elements



Weldable sheet thickness 0,8 mm - 1,25 mm (drawing sheet steel grade U.St 12.03 according EN 10130). Other sheet thicknesses on demand

Guiding figures for cycle times

Examples:



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