

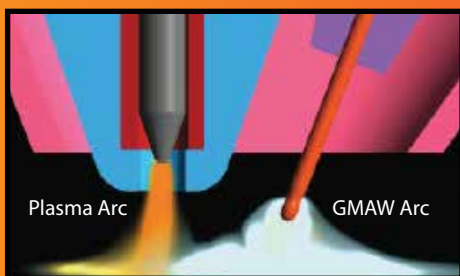


Technology



SuperMIG[®]

Hybrid Welding
Plasma & GMAW



Principle of work:

Plasma arc melting base material creating a keyhole, GMAW arc following and providing the filler metal and creating full penetration.

Welding Control Module (WCM)

Torches

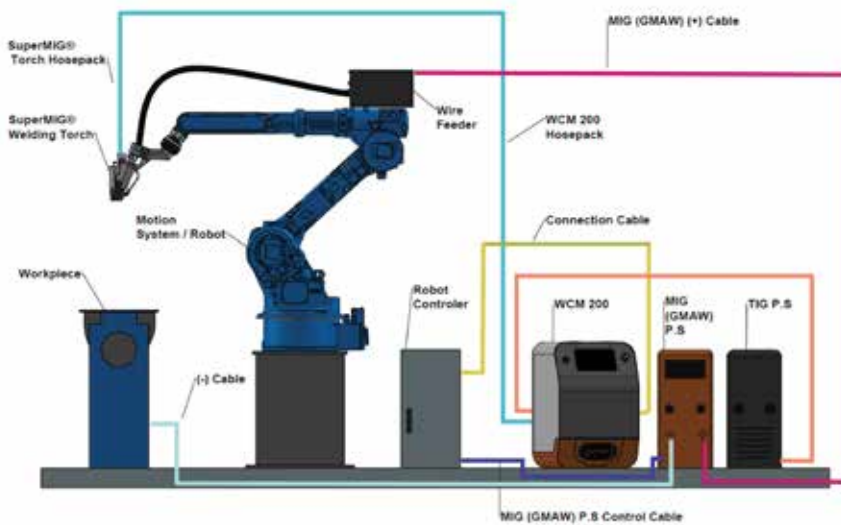

Medium Duty



HD Slim (HDS)



Heavy Duty (HD)

System configuration

Applications

- Mainly welding 5mm thick and above
- Boilers (steel & stainless)
- Autoclaves
- Heat exchangers
- Construction parts-H/T beams
- Crane Booms
- Silos & containers
- Shipyards
- Armored steel constructions
- Earth moving machinery

SuperMIG® Performances & advantages

- One side welding up to 12.5 mm (1/2 in)
- No edge-preparation or beveling required
- Deep weld penetration
- High welding travel speed
- Reduced heat input
- Narrow heat affected zone
- Clean and environment friendly
- Increases productivity & profitability

WORKPIECE MATERIAL	WORKPIECE THICKNESS (mm)	WELD PASSES	TRAVEL SPEED m/min	PLASMA ARC PARAMETERS	GMAW ARC PARAMETERS			
					CURRENT (A)	WIRE FEED RATE m/min	VOLTAGE (V)	CURRENT (A)
Carbon Steel	6	1	1	220	12	26.5	350	1.2
Carbon Steel	8	1	0.75	200	12.5	30.5	350	1.2
Carbon Steel	12	1	0.45	240	10	32	592	1.6
Armored Steel	8	1	0.8	220	14.5	25	360	1.2
Armored Steel	8	1	0.5	300	12.3	20.6	330	1.2
Armored Steel	8	1	0.7	280	12	26	312	1.2
Stainless Steel	6	1	0.6	150	10	27.6	251	1.2
Stainless Steel	9	1	0.6	150	11.7	28.9	285	1.2
Stainless Steel	10	1	0.85	190	22	35.9	520	1.2



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