

MAESTRO SERIES

600 ■ 800 ■ 1000 ■ 1200

**A range of Submerged Arc Welding equipment
to suit wide range of applications**



Features :

- Choice of Boom mounted or Tractor mounted models with Diode / Thyristorised Power Source
- Boom mounted head comes with a choice of manual, semi-motorised and fully motorised cross slides
- Programmed sequential operations of Power Source, Wire Feed and Carriage through built-in solid state circuitry
- Twin Wire attachment is optionally available - helps to achieve 20 - 30% higher weld deposition rates

The Welder friendly Tractor or Boom Mounted Welding head with Diode / Thyristorised Power Sources perfectly matched; adapted to local conditions; offering a Range of models to suit every budget and Need



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani Oerlikon Ltd.)
www.adorwelding.com

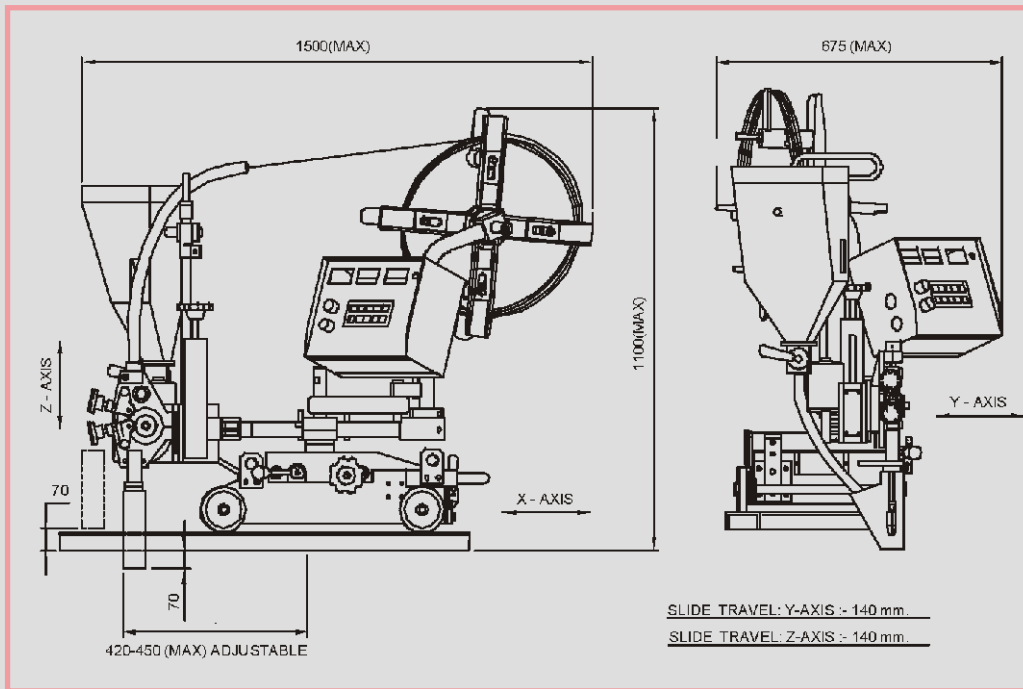


Technical Specifications		Product range							
Power Source Model	Unit	PS 600 (F)	PS 800 (F)	PS 1000 (F)	PS 1200 (F)	PS 600 T (F)	PS 800 T (F)	PS 1000 T (F)	PS 1200 T (F)
INPUT		Diode based				Thyristor based			
Input Supply									
Voltage	Volts	415	415	415	415	415	415	415	415
Phase	No.	3	3	3	3	3	3	3	3
Frequency	Hz.	50	50	50	50	50	50	50	50
Input KVA @ 100% duty cycle	KVA	25	37	45	57	34	44	50	63
Recommended switch fuse rating	Type	TP-50	TP-60	TP-80	TP-100	TP-50	TP-70	TP-80	TP-100
OUTPUT									
Static characteristics	Type	CP	CP	CP	CP	CP	CP	CP	CP
Welding current	Amps	600	800	1000	1200	600	800	1000	1200
Open circuit voltage range (Max.)	Volts	35 - 71	35 - 63	35 - 63	35 - 63	62	62	62	62
Open Circuit Voltage range (Actual)	Volts	32 - 61	29 - 54	29 - 54	29 - 54	-	-	-	-
Welding Current Range	Amps	100 - 600	150 - 800	200 - 1000	200 - 1200	100 - 600	150 - 800	200 - 1000	200 - 1200
Weld Current @ 60% duty cycle	Amps	600	800	1000	1200	600	800	1000	1200
Weld Current @ 100% duty cycle	Amps	465	650	800	1000	465	650	800	1000
GENERAL									
Insulation	Class	H	H	H	H	H	H	H	H
Cooling	Type	Forced air	Forced air	Forced air	Forced air	Forced air	Forced air	Forced air	Forced air
Dimensions:									
Length	mm	930	1225	1225	1225	930	1225	1225	1225
Width	mm	685	800	800	800	685	800	800	800
Height	mm	940	900	900	900	940	1060	1060	1060
Weight (approx.)	Kgs.	240	350	365	390	240	350	365	390
SAW head mode		WH-15 (F)	WH-15-01 (F)	WH-15-02 (F)	WH-15-03 (F)	WH-15 T (F)	WH-15-01 T (F)	WH-15-02 T (F)	WH-15-03 T (F)
Max. welding current : #									
@ 60% duty cycle	Amps	1500				1500			
@ 100% duty cycle	Amps	1250				1250			
Recommended Power Source		PS 600(F) / PS 800(F) / PS 1000(F) / PS 1200(F)				PS 600 T(F) / PS 800 T(F) / PS 1000 T(F) / PS 1200 T(F)			
Wire Diameter		2, 2.5	2, 2.5, 3, 2	2, 2.5, 3, 2, 4, 5		2, 2.5	2, 2.5, 3, 2	2, 2.5, 3, 2, 4, 5	
Single wire		2, 2.5 (Optional)							
Twin wire		2, 2.5 (Optional)							
Speed Range :									
Wire feed	mtr./min	0.5 - 4.0							
Carriage	mtr./min	0.1 - 1.5	N.A.			0.1 - 1.5	N.A.		
Input to Control Unit		42 Volts, 1 Phase, 50 Hz from Power Source							
Range of Adjustment :									
Vertical (Z)	mm	140 Manual	140 Manual	100 Motorised	100 Motorised	140 Manual	140 Manual	100 Motorised	100 Motorised
Horizontal(X) Transverse to Travel direction	mm	140 Manual	140 Manual	100 Motorised	100 Motorised	140 Manual	140 Manual	100 Motorised	100 Motorised
Horizontal(Y) In direction of Travel	mm	-	140 Manual	140 Manual	100 Motorised	-	140 Manual	140 Manual	100 Motorised
Maximum Swivel :									
Transverse to head Travel	deg	45							
Parallel to Head Travel	deg	30							
Horizontal Swing	deg	270							
Standard Bore for Spool	mm	285 - 315 (Adjustable)							
Weight of the spool(Max)	Kgs.	25							
Flux Hoper Capacity (Approx.)	Kgs/Ltr..	*10 / 7							
Dimensions (Approx.)									
Length	mm	1500	1500	1500	1500	1500	1500	1500	1500
Height	mm	1030	1030	1050	1050	1030	1030	1050	1050
Width	mm	580	580	600	600	580	580	600	600
Total Weight (Without Flux & wire)	Kgs.	80	80	110	110	95	80	110	110
<p>Notes : * 80 mm adjustment for welding Head</p> <p># Range of Adjustment : The 3 Axis of the welding head are defined as :</p> <p>X-Axis : Horizontal Axis, Transverse to direction of Boom Travel</p> <p>Y-Axis : Horizontal Axis, Along the direction of Boom Travel</p> <p>Z-Axis : Vertical Axis, perpendicular to the direction of Boom Travel</p>									
Optional Accessories									
Set of Welding Cables	SAC 600	PS 600 (F)	PS 800 (F)	PS 1000 (F)	PS 1200 (F)	PS 600 T (F)	PS 800 T (F)	PS 1000 T (F)	PS 1200 T (F)
	SAC 800	S10.36.001.0001	-	-	-	S10.36.011.0001	-	-	-
	SAC 1000	-	S10.36.011.0005	-	-	-	S10.36.011.0005	-	-
	SAC 1200	-	-	S10.36.011.0006	-	-	-	S10.36.011.0006	-
		-	-	-	S10.36.011.0004	-	-	-	S10.36.011.0004
Set of Welders accessories	WAS	S10.36.041.0001							
Spot Light Projector	SLP	S10.36.031.0001							
Fillet welding Attachment	FWA	S10.36.021.0001							
Twin Wire Attachment (2 & 2.5 mm)	TWA	S10.36.021.0003							
<p>Notes :</p> <p>TWIN WIRE ATTACHMENT TWIN WIRE ATTACHMENT is available for the Tractor as well as Boom Mounted type Welding Heads. This arrangement consists of one set each of wire drive Roll and Nozzle for 2 & 2.5mm size wires to feed 2 wires in tandem and increase the deposition rate substantially. This arrangement is ideal for applications like cladding of hard surfacing as well as for filling weld metal in extra large edge preparation grooves. Twin 2.5 mm wires can deliver up to 20% higher deposition rates than a single 5 mm diameter wire at the same welding current and arc voltage parameters.</p> <p>FILLET WELDING ATTACHMENT To enhance the usability of the SAW outfit, a FILLET Welding Attachment can be provided for increased shopfloor productivity.</p> <p>SPOT LIGHT PROJECTOR This facility is especially useful for welding operations inside cylindrical jobs where a light source is required to examine the seams.</p>									

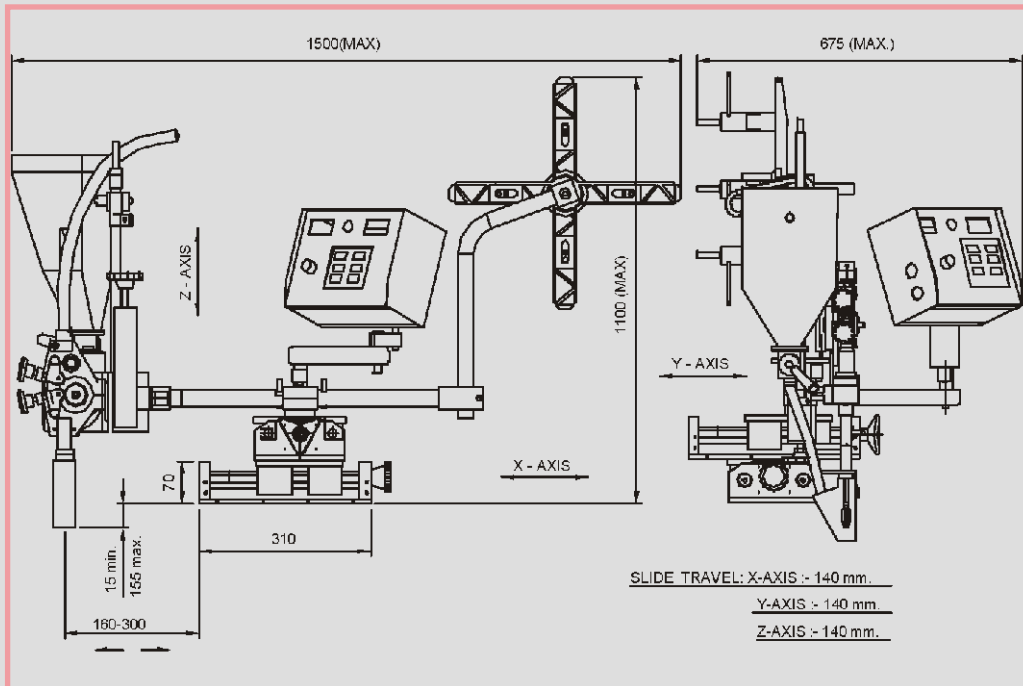
ORDERING INFORMATION

SUBARC OUTFIT	PRODUCT CODE	POWER SOURCE	WELDING HEAD	SUBARC OUTFIT	PRODUCT CODE	POWER SOURCE	WELDING HEAD
Maestro 600 (F)	F10.36.004.0041	PS 600 (F)	WH-15 (F)	Maestro 600 T (F)	F10.36.004.0066	PS 600 T (F)	WH-15T (F)
Maestro 600 - 01 (F)	F10.36.004.0042	PS 600 (F)	WH-15-01 (F)	Maestro 600 -01 T (F)	F10.36.004.0035	PS 600 T (F)	WH-15-01T (F)
Maestro 600 - 02 (F)	F10.36.004.0043	PS 600 (F)	WH-15-02 (F)	Maestro 600 - 02 T (F)	F10.36.004.0062	PS 600 T (F)	WH-15-02T (F)
Maestro 600 - 03 (F)	F10.36.004.0044	PS 600 (F)	WH-15-03 (F)	Maestro 600 - 03 T (F)	F10.36.004.0071	PS 600 T (F)	WH-15-03T (F)
Maestro 800 (F)	F10.36.004.0045	PS 800 (F)	WH-15 (F)	Maestro 800 T (F)	F10.36.004.0061	PS 800 T (F)	WH-15T (F)
Maestro 800 - 01 (F)	F10.36.004.0046	PS 800 (F)	WH-15-01 (F)	Maestro 800 -01 T (F)	F10.36.004.0036	PS 800 T (F)	WH-15-01T (F)
Maestro 800 - 02 (F)	F10.36.004.0047	PS 800 (F)	WH-15-02 (F)	Maestro 800 -02 T (F)	F10.36.004.0063	PS 800 T (F)	WH-15-02T (F)
Maestro 800 - 03 (F)	F10.36.004.0048	PS 800 (F)	WH-15-03 (F)	Maestro 800 -03 T (F)	F10.36.004.0064	PS 800 T (F)	WH-15-03T (F)
Maestro 1000 (F)	F10.36.004.0049	PS 1000 (F)	WH-15 (F)	Maestro 1000 T (F)	F10.36.004.0068	PS 1000 T (F)	WH-15 T (F)
Maestro 1000 - 01 (F)	F10.36.004.0050	PS 1000 (F)	WH-15-01 (F)	Maestro 1000 -01 T (F)	F10.36.004.0037	PS 1000 T (F)	WH-15-01T (F)
Maestro 1000 - 02 (F)	F10.36.004.0051	PS 1000 (F)	WH-15-02 (F)	Maestro 1000 -02 T (F)	F10.36.004.0059	PS 1000 T (F)	WH-15-02 T (F)
Maestro 1000 - 03 (F)	F10.36.004.0052	PS 1000 (F)	WH-15-03 (F)	Maestro 1000 -03 T (F)	F10.36.004.0070	PS 1000 T (F)	WH-15-03 T (F)
Maestro 1200 (F)	F10.36.004.0053	PS 1200 (F)	WH-15 (F)	Maestro 1200 T (F)	F10.36.004.0069	PS 1200 T (F)	WH-15T (F)
Maestro 1200 - 01 (F)	F10.36.004.0054	PS 1200 (F)	WH-15-01 (F)	Maestro 1200 -01 T (F)	F10.36.004.0038	PS 1200 T (F)	WH-15-01T (F)
Maestro 1200 - 02 (F)	F10.36.004.0055	PS 1200 (F)	WH-15-02 (F)	Maestro 1200 -02 T (F)	F10.36.004.0060	PS 1200 T (F)	WH-15-02T (F)
Maestro 1200 - 03 (F)	F10.36.004.0056	PS 1200 (F)	WH-15-03 (F)	Maestro 1200 -03 T (F)	F10.36.004.0072	PS 1200 T (F)	WH-15-03T (F)

TRACTOR MOUNTED WELDING HEAD WH-15 (F) & WH-15 T(F)



BOOM MOUNTED WELDING HEAD WH-15-01 (F) & WH-15-01 T(F)



- **Warranty:** One year from the date of purchase. ADOR WELDING LIMITED warrants that all new equipment sold from Plant/Area Offices / Authorised Distributors are free from defects in materials and workmanship and will perform in full accordance with applicable specifications.
- In view of continuous development, ADOR WELDING LIMITED reserves the right to modify/change the design and/or the specifications without any prior notice.
- Backed by dedicated customer care package.



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