

Retrofit options for GMAW/SAW equipment - Welding Heads and Wire Feeders

Preamble:

It is normally observed that a wire feeder or welding head of a GMAW or SAW outfit has limited life due to wear and tear of its rotating or moving parts, while power source is still working satisfactory without any trouble for many years. Due to various factors like market requirement or due to advances in technology, old models of welding equipment are getting replaced with new models and availability of only wire feeders or welding heads as replacement for existing equipment models becomes difficult. However nobody likes to discard the welding outfit because of non availability of wire feeders/ welding heads.

ADOR has introduced retrofits which give solution on this requirement. This article gives information on such retrofits which can be used along with ADOR's old SAW or GMAW outfits as well as recommends retrofits for other SAW/GMAW makes.

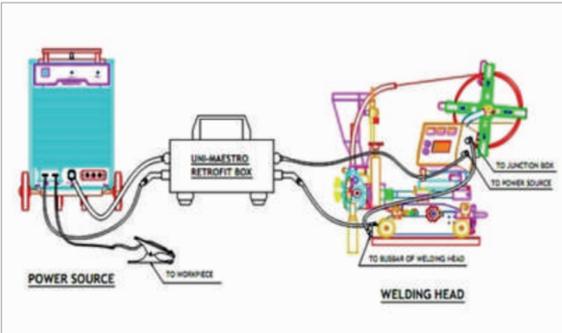
1. Basic need for introducing retrofits:

- 1) Normally a power source used in MIG-MAG welding outfits as well as submerged arc welding outfits has got sufficient life as compared with wire feeders & welding heads due to wear and tear of their rotating parts.
- 2) Sometimes wire feeders & welding heads are shifted from one shop floor to another, whereas power source is normally stationary. This results in limited life of the welding head & wire feeder due to shop floor movements and maximum utilization in industry.
- 3) Old version of welding head models (like UP-11-CP, UP-15-CP, WH-15 etc.) have been discontinued and are no longer manufactured & Spares are also not available. (obsolete category).
- 4) Similarly, old version of wire feeders fitted with old types of motors (like Ralli-wolf motors, Magna motors) have been also discontinued & spares are also not available. (obsolete category)

2. Retrofit versions are nothing but "Born again packages (Rejuvenate many)" to upgrade and give life to existing old power sources & become ideal when old welding head & wire feeders are non-working.

3. Following are some of the benefits of retrofits:

- 1) Old version of welding heads can be replaced with new "Feather Touch Controlled Welding Head" & SAW power source which is in working condition can be used with this new feather touch controlled welding head.
- 2) Controller used in new welding head is having newly developed welder's friendly "Feather Touch" functions
- 3) One can enhance productivity with very economical solution of Retrofitting version of welding head and wire feeders.
- 4) Similarly, newly developed light-weight wire feeder also can be retrofitted in old MIG-MAG welding power source, which is in working condition.



Connection diagram of UNI-MAESTRO Retrofit unit with SAW power source:

4. Retrofit options available for SAW welding outfits:

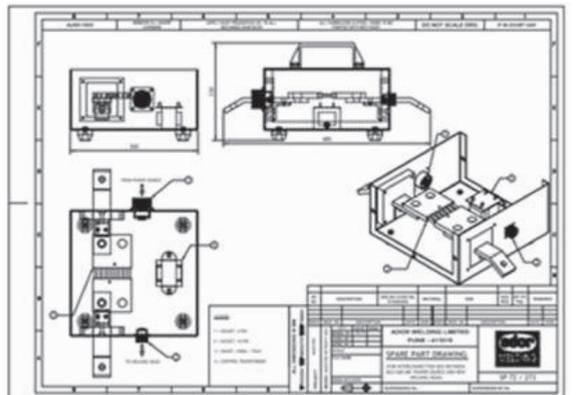
Retrofit "UNI-MAESTRO" System:

It consists of following parts:

1. Retrofit "UNI-MAESTRO" box assembly.
2. Control cable assembly with end connectors suitable for connecting old power source & UNI-MAESTRO Box.
3. Tractor mounted welding head OR Boom mounted welding head suitable for both Conventional power source or Thyristorised power source as per customer's requirement.
4. Any type of "Feather-Touch Controlled" Welding Heads is suitable for both Conventional as well as Thyristorised Power Source.



Retrofit "UNI-MAESTRO" Box assembly (With Control cable)



Retrofit "UNI-MAESTRO" Box (Internal connection diagram)

5. Various options are available in UNI MAESTRO retrofits as per the variation in tractor mounted welding head & boom mounted welding head:

a) With conventional diode power source =>

- 1) Model: UNI MAESTRO (F)
- 2) Model: UNI MAESTRO-01 (F)
- 3) Model: UNI MAESTRO-02 (F)
- 4) Model: UNI MAESTRO-03 (F)

b) With thyristorized power source =>

- 1) Model: UNI MAESTRO T (F)
- 2) Model: UNI MAESTRO-01 T (F)
- 3) Model: UNI MAESTRO-02 T (F)
- 4) Model: UNI MAESTRO-03 T (F)

6. Retrofit options available for GMAW welding outfits:

6.1 Retrofit "UNIFEED WIRE FEEDER":

This System consists of following parts:

1. Retrofit UNIFEED Inter connection box assembly.
2. Control cable assembly with end connectors suitable for connecting old power source & UNIFEED Interconnection Box.
3. 2-Roll or 4-Roll wire feeder with 5-meter long interconnection cable & hose. Against specific requirement, this Interconnection cable is available up to 20-meter.
4. Remote control unit.
5. UNIFEED wire feeder system is also available for other manufacturers' MIG-MAG welding power sources (Only suitable for diode base MIG-MAG welding outfits)



Retrofit "WF-20 (F) complete system (6.2.b below) >



Retrofit "UNIFEED" complete system =>

6.2 Various options are available in UNIFEED wire feeder based on 2-roll & 4-roll wire feeders:

a) With diode power source:

- 1) Model: UNIFEED-20 (NEL-5) => 2-Roll version suitable for 250 -Amps capacity.
- 2) Model: UNIFEED-20 (NEM-5) => 2-Roll version suitable for 400-Amps capacity.
- 3) Model: UNIFEED-40 (NEM-5) => 4-Roll version suitable for 400-Amps capacity.
- 4) Model: UNIFEED-40 (NEH-5) =>4-Roll version suitable for 600-Amps capacity.

b) Totally enclosed wire feeders are also available on request where interconnection box is not required & customer can directly connect to the AWL make old MIG-MAG Diode based power source. Following are the options available in enclosed type wire feeders:

- 1) Model: WF-20 (F) => 2-Roll version suitable for 400-Amps capacity.
- 2) Model: WF-40 (F) => 4-Roll version suitable for 400-Amps capacity.

c) Any special requirements for retrofitting of welding heads & wire feeders are also available against specific need.

Follow Us:



Please contact cmo@adorians.com for suggestions

