

# MAESTRO SERIES

800, 1000, 1200

A RANGE OF SUBMERGED ARC WELDING EQUIPMENT  
TO SUIT A WIDE RANGE OF APPLICATIONS



- Choice of Boom mounted or Tractor mounted Welding head models offered with Diode or Thyristorized Power Source
- Boom mounted head comes with a choice of manual, semi – motorized and fully motorized cross slides

- Programmed sequential operations of Power Source, Wire feed and carriage through built- in solid state circuitry
- Twin Wire Attachment is optionally available – which helps to achieve 20% to 30% increase in Productivity

**The Welder – friendly Tractor or Boom Mounted Welding Head with Diode / Thyristorized Power Sources perfectly matched; adapted to local conditions; offering a Range of models to suit every Budget and Need**



PASSION FOR WELDING SINCE 1951

**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

[www.adorwelding.com](http://www.adorwelding.com)

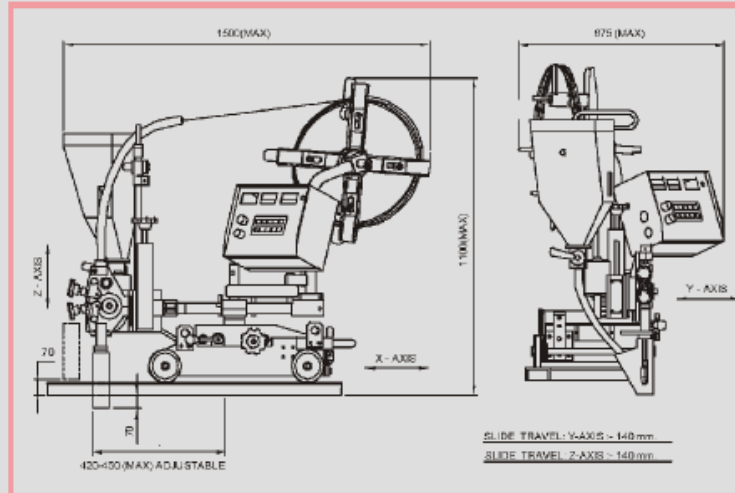


# MAESTRO SERIES

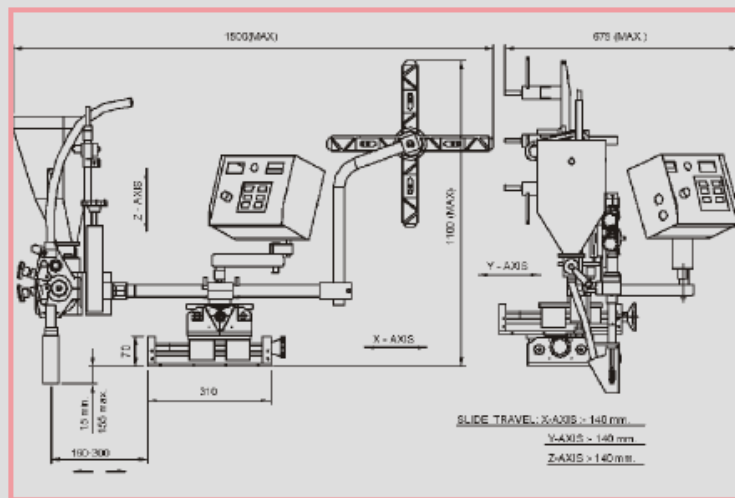
**3**  
Phase



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



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



- ✦ **TWIN WIRE ATTACHMENT:** Twin Wire Attachment is available for the Tractor as well as boom mounted welding heads. The arrangement consists of one set of each of wire drive roll and nozzle for 2 and 2.5 mm size wire to feed two wires in tandem and increase the deposition rate substantially. These arrangements is ideal for applications like cladding of hard surfaces as well as for filling weld metal in extra large size preparation grooves. Twin 2.5 mm wires can deliver up to 20% higher deposition rates than a single 5 mm wire at the same welding current and arc voltage parameters.
- ✦ **FILLET WELDING ATTACHMENT:** To enhance the usability of SAW Outfits, a Fillet Welding attachment can be provided to increase shop-floor productivity.
- ✦ **SPOT LIGHT PROJECTOR:** This facility is especially useful for welding operations inside cylindrical jobs where a light source is required to examine the seam



PASSION FOR WELDING SINCE 1951

**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

[www.adorwelding.com](http://www.adorwelding.com)



# MAESTRO SERIES

## TECHNICAL SPECIFICATIONS - DIODE BASED SYSTEMS

POWER SOURCE	UNIT	PS 800 (F)	PS 1000 (F)	PS 1200 (F)
INPUT				
INPUT SUPPLY				
VOLTAGE	VOLTS, AC	415	415	415
PHASE	No.	3	3	3
FREQUENCY	Hz	50	50	50
INPUT KVA @ 100% duty cycle	KVA	37	45	54
RECOMMENDED SWITCH FUSE RATING	AMPS, AC	TP - 60	TP - 80	TP - 100
OUTPUT				
STATIC CHARACTERISTICS	TYPE	CV	CV	CV
OPEN CIRCUIT VOLTAGE RANGE (MAX. WITH IPT)		35 - 63	35 - 63	35 - 63
OPEN CIRCUIT VOLTAGE RANGE (ACTUAL)	VOLTS, DC	29 - 54	29 - 54	29 - 54
WELDING VOLTAGE		21.5 - 44	24 - 44	24 - 44
WELDING CURRENT RANGE		150 - 800	200 - 1000	200 - 1200
WELDING CURRENT @ 60% DUTY CYCLE	AMPS, DC	800	1000	1200
WELDING CURRENT @ 100% DUTY CYCLE		650	800	1000
GENERAL				
INSULATION	CLASS	H	H	H
COOLING	TYPE	FORCED AIR	FORCED AIR	FORCED AIR
DIMENSIONS (L X W X H)	MM	1225 X 800 X 900	1225 X 800 X 900	1225 X 800 X 900
WEIGHT	KG	350	365	390

## TECHNICAL SPECIFICATIONS - THYRISTOR BASED SYSTEMS

POWER SOURCE	UNIT	PS 800 T (F)	PS 1000 T (F)	PS 1200 T (F)
INPUT				
INPUT SUPPLY				
VOLTAGE	VOLTS, AC	415	415	415
PHASE	No.	3	3	3
FREQUENCY	Hz	50	50	50
INPUT KVA @ 100% duty cycle	KVA	44	50	63
RECOMMENDED SWITCH FUSE RATING	AMPS, AC	TP - 70	TP - 80	TP - 100
OUTPUT				
STATIC CHARACTERISTICS	TYPE	CV	CV	CV
OPEN CIRCUIT VOLTAGE RANGE (MAX.)	VOLTS, DC	62	62	62
WELDING CURRENT RANGE		150 - 800	200 - 1000	200 - 1200
WELDING CURRENT @ 60% DUTY CYCLE	AMPS, DC	800	1000	1200
WELDING CURRENT @ 100% DUTY CYCLE		650	800	1000
GENERAL				
INSULATION	CLASS	H	H	H
COOLING	TYPE	FORCED AIR	FORCED AIR	FORCED AIR
DIMENSIONS (L X W X H)	MM	1225 X 800 X 1060	1225 X 800 X 1060	1225 X 800 X 1060
WEIGHT	KG	350	365	390

## ORDERING INFORMATION OPTIONAL ACCESSORIES

DESCRIPTION	PRODUCT CODE
SET OF WELDING CABLES SAC 800, FOR PS 800 (F), 800 T (F)	S10.36.011.0005
SET OF WELDING CABLES SAC 1000, FOR PS 1000 (F), 1000 T (F)	S10.36.011.0006
SET OF WELDING CABLES SAC 1200, FOR PS 1200 (F), 1200 T (F)	S10.36.011.0004
DESCRIPTION	PRODUCT CODE
WAS : SET OF WELDERS ACCESSORIES - ALL MODELS	S10.36.041.0001
SLP: SPOTLIGHT PROJECTOR - ALL MODELS	S10.36.031.0001
FWA: FILLET WELDING ATTACHMENT - ALL MODELS	S10.36.021.0001
TWA: TWIN WIRE ATTACHMENT (2 AND 2.5 MM) - ALL MODELS	S10.36.021.0003



PASSION FOR WELDING SINCE 1951  
**ADOR WELDING LIMITED**  
 (Formerly Known as Advani-Oerlikon Ltd.)  
[www.adorwelding.com](http://www.adorwelding.com)



# MAESTRO SERIES

## TECHNICAL SPECIFICATIONS - WELDING HEADS

SAW HEAD	UNIT	WH -15 (F)	WH -15-01 (F)	WH -15-02 (F)	WH -15-03 (F)
MAX. WELDING CURRENT @ 60% DUTY CYCLE	AMPS, DC	1500	1500	1500	1500
MAX. WELDING CURRENT @ 60% DUTY CYCLE		1250	1250	1250	1250
RECOMMENDED POWER SOURCE		PS 800 (F) / PS 1000 (F) / PS 1200 (F)			
RECOMMENDED WIRE DIAMETER SINGLE WIRE	MM	2, 2.5, 3.2 FOR 800 (F); 2, 2.5, 3.2, 4.5 FOR 1000 (F) AND 1200 (F)			
RECOMMENDED WIRE DIAMETER TWIN WIRE	MM	2, 2.5 (OPTIONAL)			
SPEED RANGE WIRE FEED	M / MIN.	0.5 - 4	0.5 - 4	0.5 - 4	0.5 - 4
SPEED RANGE CARRIAGE	M / MIN.	0.1 - 1.5	N. A.	N. A.	N. A.
INPUT TO CONTROL UNIT	VOLTS, AC	42 V, 1 PH, 50 HZ FROM POWER SOURCE			
<b>RANGE OF ADJUSTMENT</b>					
VERTICAL (Z)	MM	140 (MANUAL)	140 (MANUAL)	100 (MOTORIZED)	100 (MOTORIZED)
HORIZONTAL (X) - TRANSVERSE TO TRAVEL DIRECTION		140 (MANUAL)	140 (MANUAL)	100 (MOTORIZED)	100 (MOTORIZED)
HORIZONTAL (7) - IN DIRECTION OF TRAVEL		-	140 (MANUAL)	140 (MANUAL)	100 (MOTORIZED)
<b>MAXIMUM SWIVEL</b>					
TRANSVERSE TO HEAD TRAVEL	DEGREE	45			
PARALLEL TO HEAD TRAVEL		30			
HORIZONTAL SWING		270			
STANDARD BORE FOR SPOOL	MM	285 - 315 (ADJUSTABLE)			
WEIGHT OF SPOOL (MAX.)	KG	25			
FLUX HOPPER CAPACITY (MAX.)	KG / LITRES	*10 / 7			
DIMENSIONS (L X W X H)	MM	1500 X 1030 X 580	1500 X 1030 X 580	1500 X 1050 X 600	1500 X 1050 X 600
WEIGHT (WITHOUT FLUX AND WIRE)	KG	80	80	110	110
<b>NOTES:</b>					
* HOPPER 80 MM ADJUSTMENT FOR WELDING HEAD					
# RANGE OF ADJUSTMENTS: THE THREE AXES OF WELDING HEAD ARE DEFINED AS FOLLOWS:					
X - AXIS: HORIZONTAL AXIS, TRANSVERSE TO DIRECTION OF BOOM TRAVEL					
Y - AXIS: HORIZONTAL AXIS, ALONG THE DIRECTION OF BOOM TRAVEL					
Z - AXIS: VERTICAL AXIS, PERPENDICULAR TO DIRECTION OF BOOM TRAVEL					

## ORDERING INFORMATION MAIN OUTFITS

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

- **Warranty:** One year from the date of commissioning. ADOR WELDING LIMITED warrants that all new equipment sold from Plant/Area Offices / Authorized 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.
- 



PASSION FOR WELDING SINCE 1951  
**ADOR WELDING LIMITED**  
 (Formerly Known as Advani-Oerlikon Ltd.)  
[www.adorwelding.com](http://www.adorwelding.com)



Corporate Marketing Office: Survey No. 147 / 2B +3, Near Akurdi Chowk,  
 Chinchwad, Pune - 411 019. Maharashtra, INDIA.  
 Tel.: +91 20 4070 6000, Fax: +91 20 4070 6001, Email: [cmo@adorians.com](mailto:cmo@adorians.com)