

Circumferential Seam Welder

ROTAWELD D0200



Figure 1: ROTAWELD D0200-L0500-HW032 with servo driven torch positioning (optional)

The **ROTAWELD** machine system is our **platform** for the widest range of tasks in **circumferential seam welding**. A precise servo-motor rotation axis and the **extensive** circular seam control form the basis of our circumferential seam welding machines. Machine sizes, part holders, welding equipment, torch holders and any additional axes required are designed specific to customer and product specification.

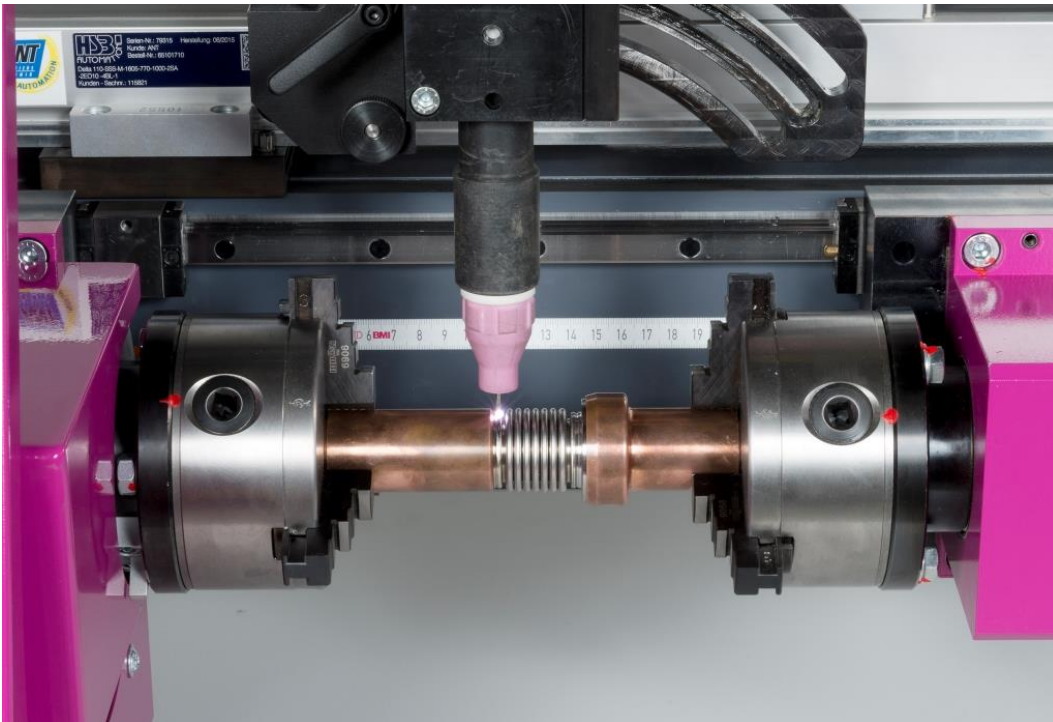


Figure 2: Welding of a flange to a metal bellow (chucks and part holder optional)

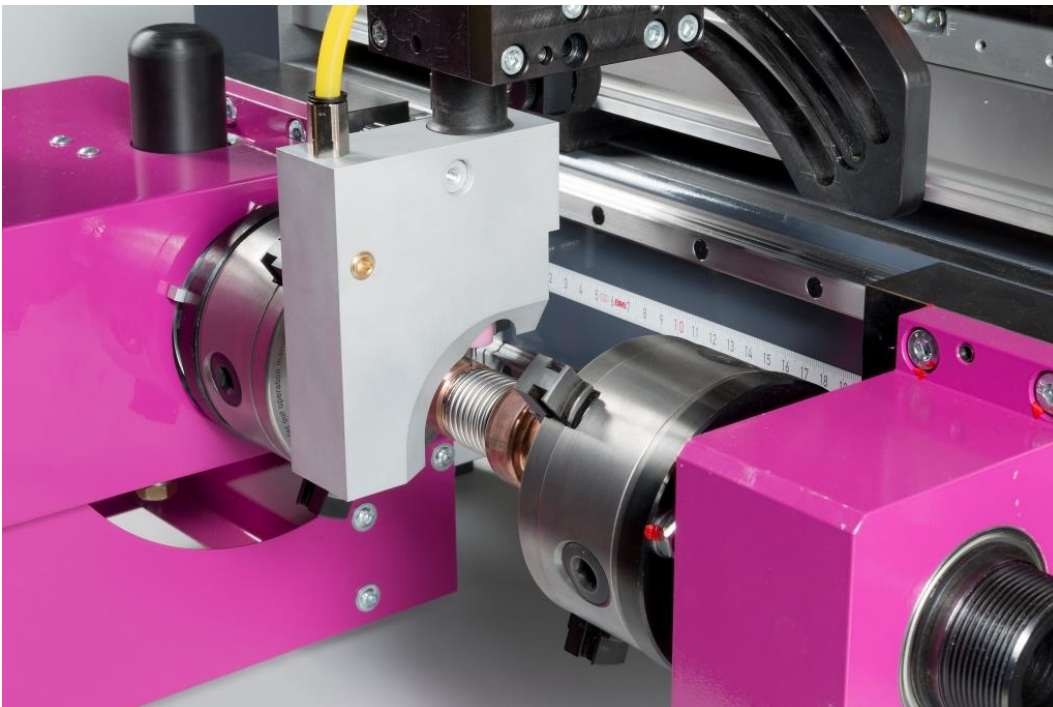


Figure 3: Circumferential seam welding with special trailing gas shield

TECHNICAL DATA

ROTAWELD	D0200-L0500-HW032	D0200-L1100-HW032
Max. part diameter	200 mm	200 mm
Distance between centres	500 mm	1100 mm
Max. swing	110 mm	110 mm
Spindle thru bore	32 mm	
Max. part weight	25 kg	
Welding Process	TIG, GTAW, Plasma	
Gas	Welding Gas, Trailing Gas	
Welding Speed (circumferential)	10 cm/min – 150 cm/min	
Control	Siemens ET200S	
Operator Panel	Siemens Comfort-Panel 7,0", Touch-colour display	
Welding Interface	BUS	
Standard	CE-Mark	
Electric Supply	400/230 Volt / 3 / N / PE; 50/60 Hz; TN-grid	
Air Supply	6 bar, dry, filtered	
Ambient Temperature	+ 10°C to + 35°C	

ROTAWELD D0200 BASIC CONFIGURATION

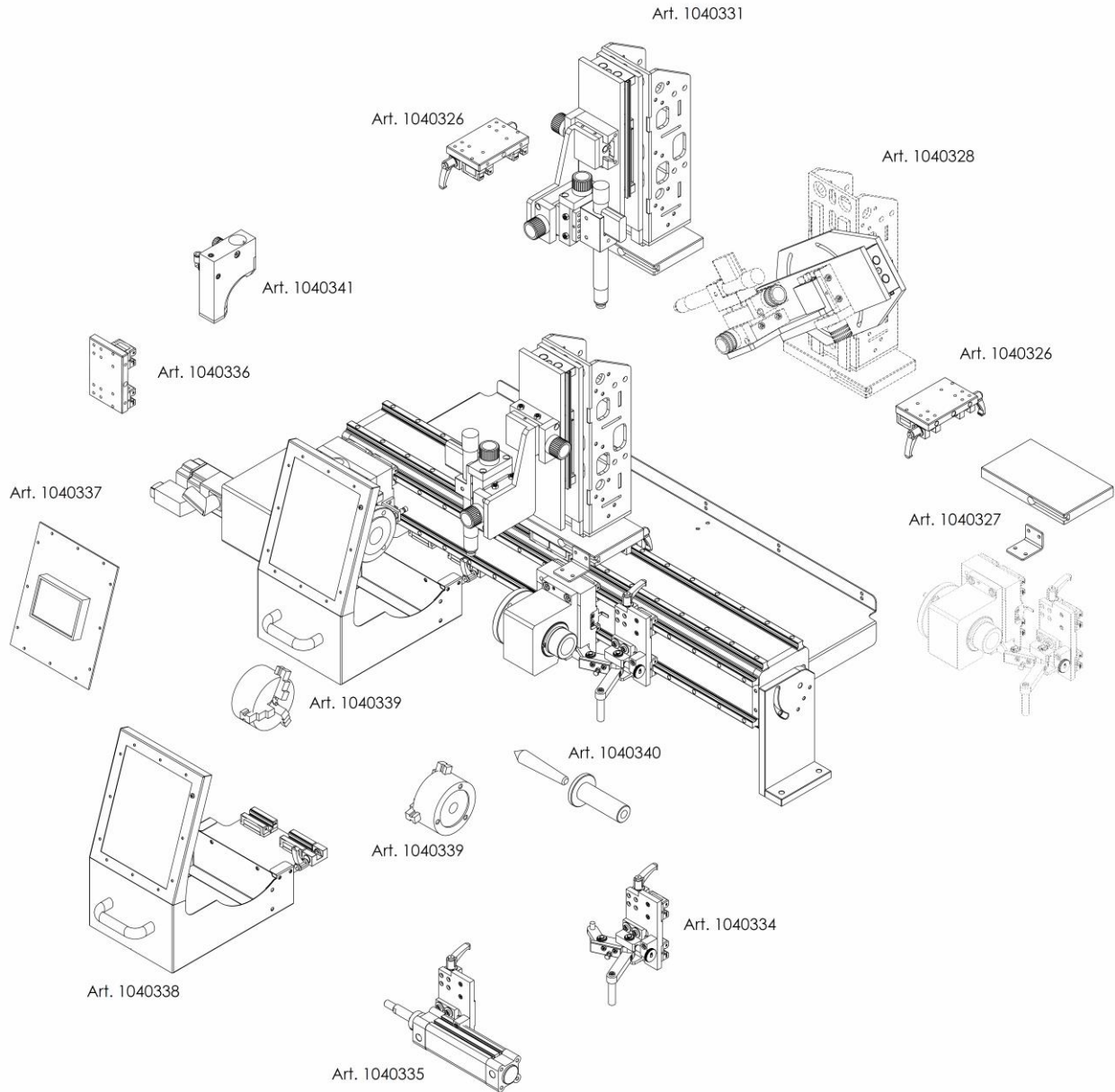


Figure 4: Basic configuration with manual lengthwise torch positioning and pneumatic torch lift, available options

SERVO DRIVEN TORCH POSITIONING FOR ROTAWELD D0200

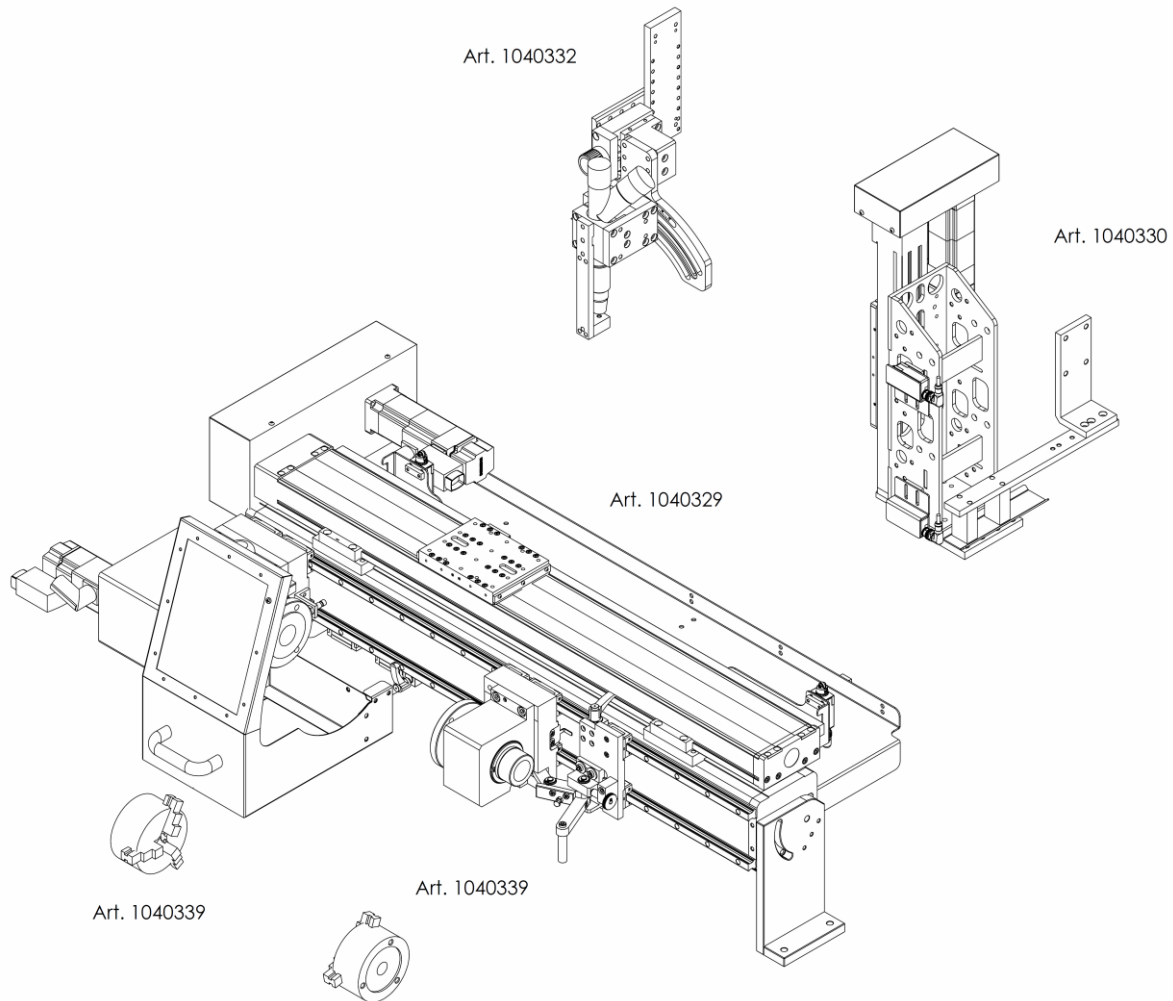


Figure 5: Servo control for lengthwise and vertical torch movement

WELDING AXIS SWIVEL UNIT FOR ROTAWELD D0200

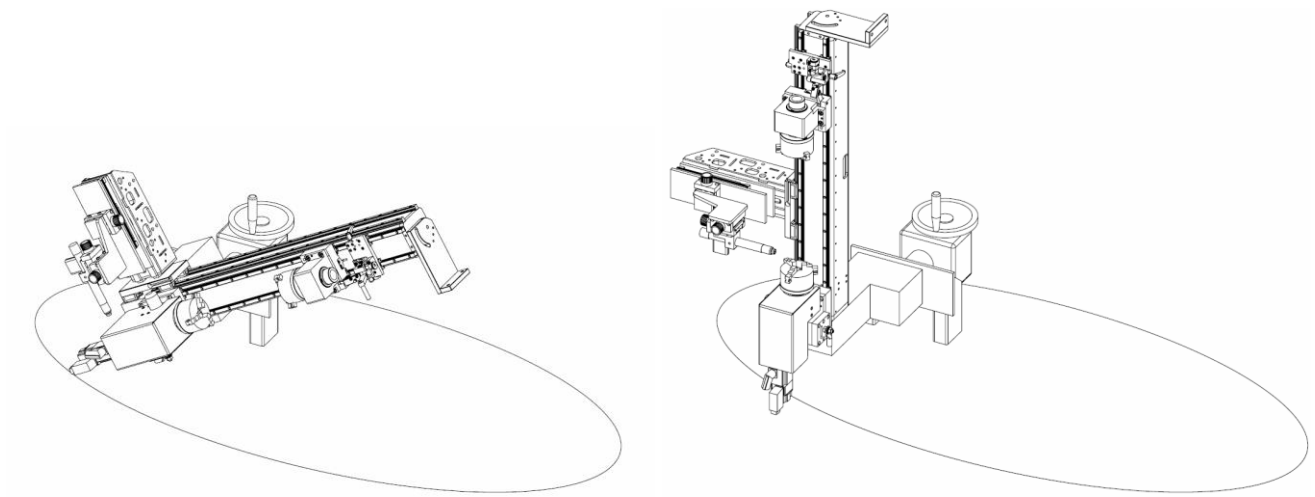


Figure 6: Manual swivel unit for welding axis for varying optimum welding position

WIRE FEEDING

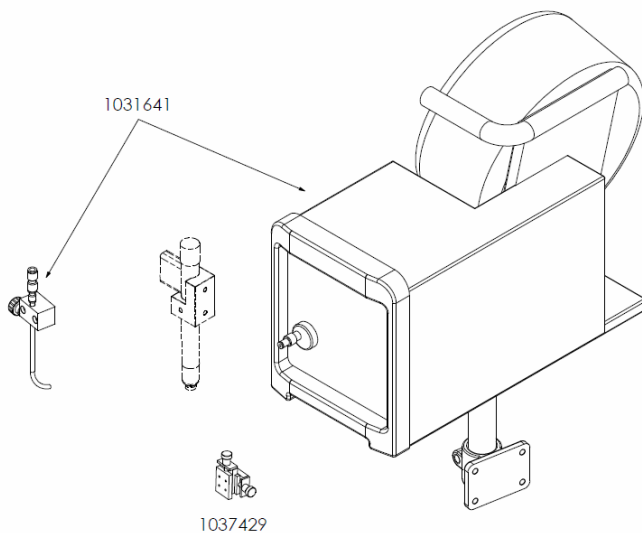


Figure 7: Wire feeding system with optional three axes wire guide adjustment.

ITEM LIST

Item	Basic Machine	
1035696	ROTAWELD D0200-L0500-HW032	Circumferential seam welder
1040325	ROTAWELD D0200-L1100-HW032	Circumferential seam welder
1017089	Welding program memory	

Item	Torch Servo Control	
1040329	Torch longitudinal positioning system, servo motor driven, 500 mm	for ROTAWELD
1040330	Torch height positioning system, servo motor driven, 130 mm, incl. torch lift function	for ROTAWELD

Item	Options	
1040341	Special trailing gas shield (customised)	
1040326	Stops for longitudinal torch positioning unit manually	for ROTAWELD D0200
1040328	Torch assembly swivel-mounted, to the side - 50°	for ROTAWELD D0200
1040331	Torch assembly 2, longitudinal positioning manually	for ROTAWELD D0200
1040327	Mechanical link between longitudinal torch positioning unit manually and Tailstock	for ROTAWELD D0200
1040334	Loading movement manually with spring for tailstock	for ROTAWELD D0200
1040335	Loading movement pneumatic, for tailstock	for ROTAWELD D0200
1040337	Welding filter auto-darkening	for ROTAWELD
1040338	Arc ray protection screen 2	for ROTAWELD D0200
1041905	Swivel Unit for Welding Axis from horizontal to vertical (90°), manually	for ROTAWELD D0200

Item	Part Holders	
1040339	Chuck size 100, 3 jaws, DIN 6350	for ROTAWELD D0200
1040340	Centre, dead	for ROTAWELD D0200
1040480	Part holder in special design, part specific	for ROTAWELD
1040336	Holder slide for tools (e.g. tube support, lunette)	for ROTAWELD D0200

Artikel	TIG Welding	
1033847	FRONIUS TT 2500 Job DC, TIG - Inverter welding power source	Communication by Profibus system
1040574	FRONIUS TT 2500 Job DC MV UL-Standard, TIG - Inverter welding power source	Communication by Profibus system
1017014	FRONIUS TT 3000 Job DC, TIG - Inverter welding power source	Communication by Profibus system
	FRONIUS MW 3000 Job AC / DC, TIG - Inverter welding power source	Communication by Profibus system
1031641	FRONIUS KD 4000 D-11 Drahtvorschubgerät	Communication by Profibus system
Artikel	Microplasma Welding	
1017140	MIG-O-MAT PlasmaJET 100 SPS TP, Microplasma-arc welding unit	Communication by Profibus system
1033997	MIG-O-MAT wire feed unit	Communication by 0-10 V and start/stop signal
Artikel	Wire Guide Adjustment	
1037429	Wire guide adjustment unit, three axes, manually	



Figure 8: Ergonomic operation through height adjustable laboratory table (optional)

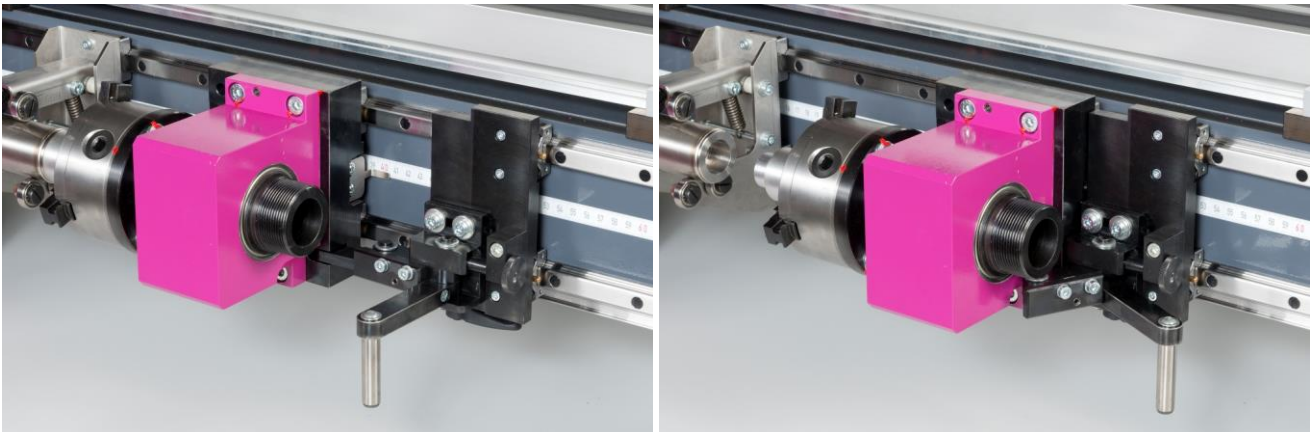


Figure 9: Manual loading movement for tailstock (chuck optional)

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NOTES



Figure 10: Precision welds on a bellow Ø 60 mm. Bellow to flange and elbow piece



Figure 11: Circumferential welding of bearing flanges into a tube Ø 38 mm



Figure 12: Welded part with 2 circumferential seams, as welded, \varnothing 40 mm, high alloyed steel